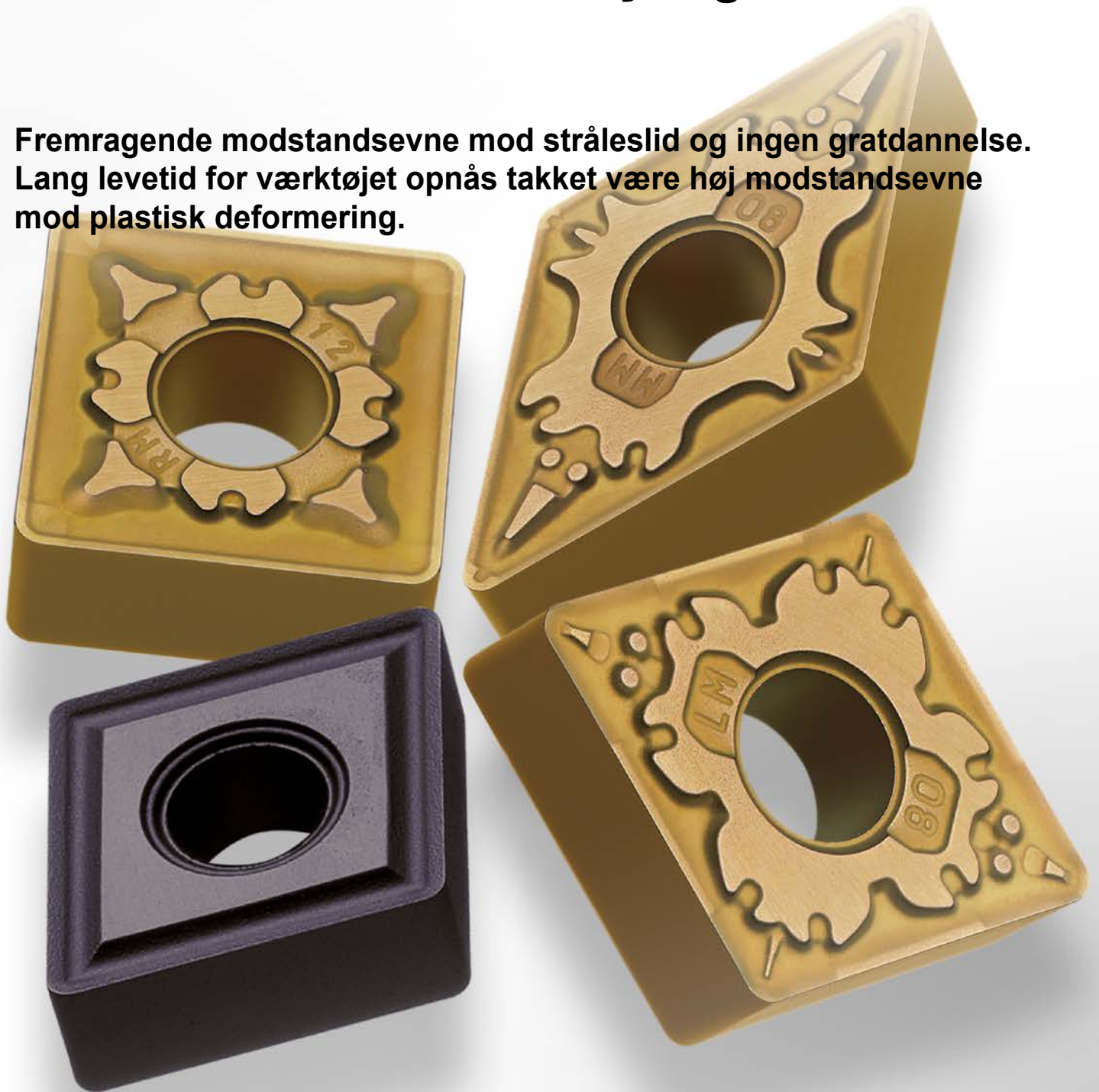


ISO platter til drejning af rustfrit stål

MIC7000

En revolution inden for drejning i rustfrit stål

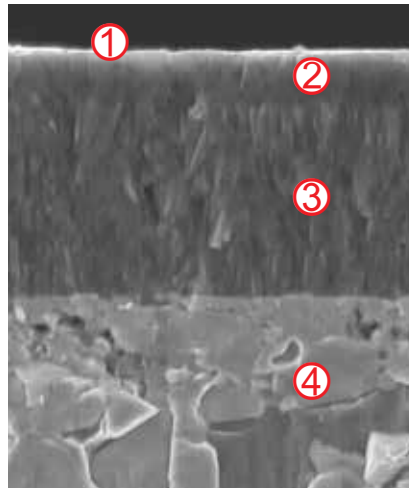
Fremragende modstandsevne mod stråleslid og ingen graddannelse. Lang levetid for værktøjet opnås takket være høj modstandsevne mod plastisk deformation.



ISO dreje program til drejning i rustfrit stål

CVD belagt kvalitet

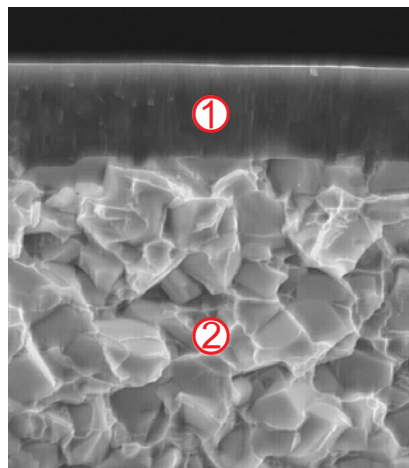
MC7015/MC7025



- ① Skarp skærekant
Forebygger løssægdannelse (på svejsning)
- ② Tyndt lag, Nano-tekstur Al₂O₃
Forhindrer unormal skade
- ③ Sej, nano-tekstur TiCN
Høj slidstyrke
- ④ Specielt karbidsubstrat
Modstandsevne mod plastisk deformation
Modstandsevne mod skærekant udflisning

Belægning med PVD klasse

MP7035

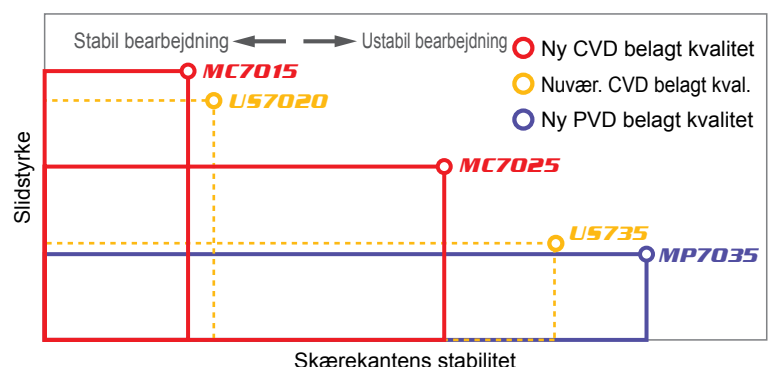


- ① (Al, Ti)N belægning
Forebygger løssægdannelse (på svejsning)
- ② Specielt karbidsubstrat
Forbedret brudstyrke, tåler termisk chok

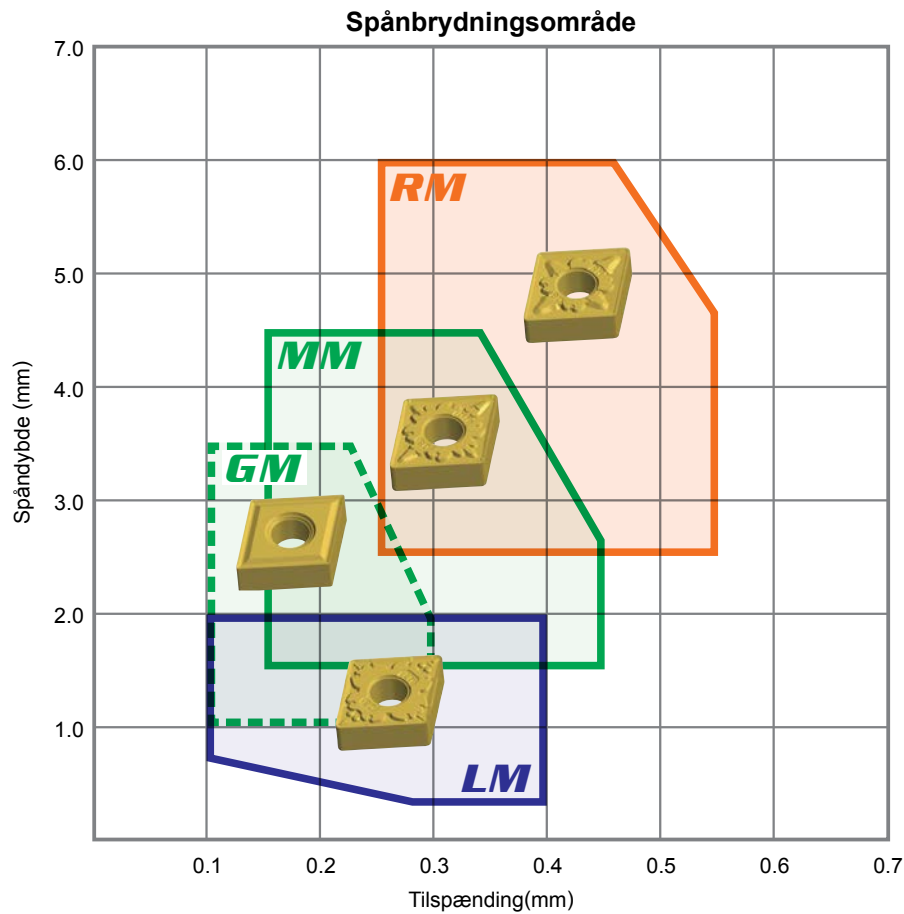
Anvendelsesområde

ISO	Rustfrit stål
M01	
M10	MC7015
M20	MC7015, MC7025
M30	MC7025, MP7035
M40	MP7035

Kvalitetskoncept



Spånbreakersystem til drejning i rustfrit stål

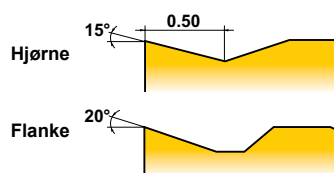


Hovedspånbreakere

LM for let skæring

Fremragende spånkontrol

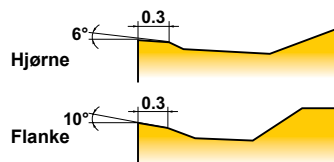
Nedbringer dramatisk grater på emnet, da egenskaberne for skarpheden og skærekantens styrke er optimale med forskellige hældningsvinkler.



MM til middel drejning

Fremragende modstandsevne mod plastisk deformation

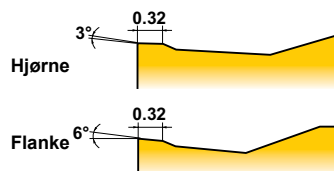
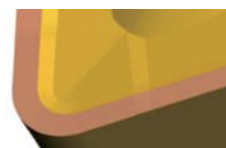
Resultatet af den optimale landgeometri ved brug af teknologi for simulationsanalyse, til kontrol af den plastiske deformation af plattens hjørne sikrer platten lang levetid.



RM til kraftig drejning

Fremragende brudstyrke

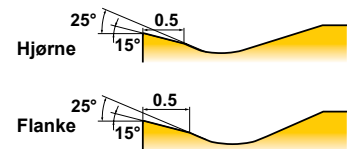
Via optimering af plattens landvinkel og honingsgeometrien, opnås høj stabilitet for skærekant under afbrudt spån.



Alternativ Spånbreaker

GM

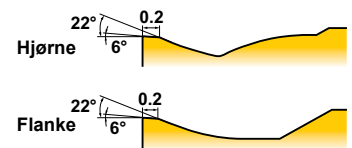
Alternativ spånbreaker til LM og MM. Fremragende styrke mod stråleslid for let til middel drejning.



Alternativ Spånbreaker


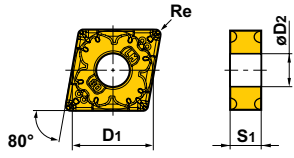

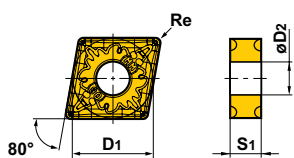

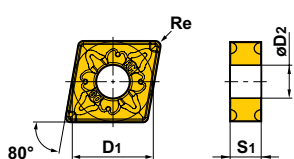

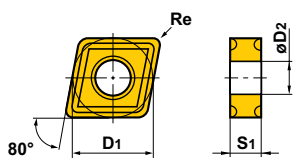

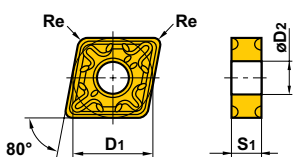

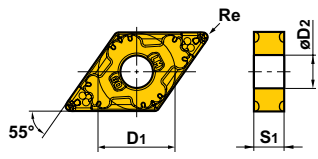

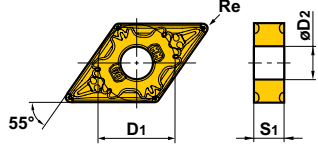
MA

Velegnet til middel drejning.


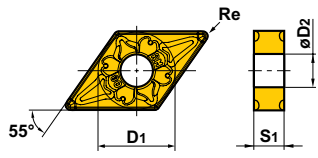
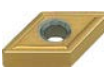
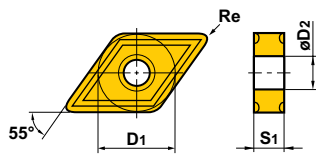

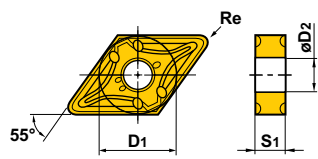

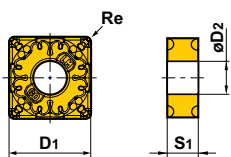

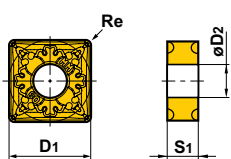

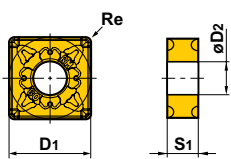

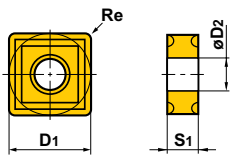


PLATTE

● Negative drejeflatter (med hul)


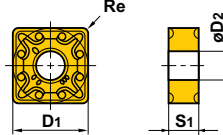

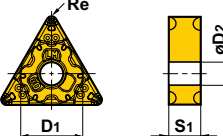

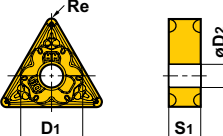

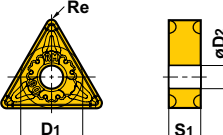

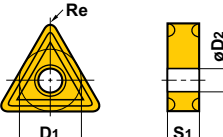

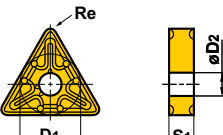

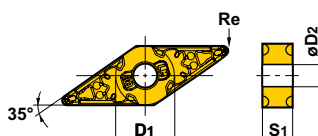

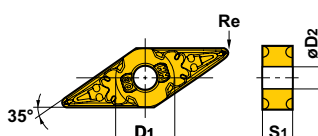
Form	Bestillingsnr.	Lager			Mål (mm)				Geometri
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
	CNMG120404-LM	●	●	●	12.7	4.76	0.4	5.16	
	120408-LM	●	●	●	12.7	4.76	0.8	5.16	
	120412-LM	●	●	●	12.7	4.76	1.2	5.16	
Let drejning									
	CNMG120408-MM	●	●	●	12.7	4.76	0.8	5.16	
	120412-MM	●	●	●	12.7	4.76	1.2	5.16	
	120416-MM	●	●	●	12.7	4.76	1.6	5.16	
	160608-MM	●	●	●	15.875	6.35	0.8	6.35	
	160612-MM	●	●	●	15.875	6.35	1.2	6.35	
	160616-MM	●	●	●	15.875	6.35	1.6	6.35	
	190608-MM	●	●	●	19.05	6.35	0.8	7.93	
	190612-MM	●	●	●	19.05	6.35	1.2	7.93	
190616-MM	●	●	●	19.05	6.35	1.6	7.93		
Middel drejning									
	CNMG120408-RM	●	●	●	12.7	4.76	0.8	5.16	
	120412-RM	●	●	●	12.7	4.76	1.2	5.16	
	120416-RM	●	●	●	12.7	4.76	1.6	5.16	
	160612-RM	●	●	●	15.875	6.35	1.2	6.35	
	160616-RM	●	●	●	15.875	6.35	1.6	6.35	
	190612-RM	●	●	●	19.05	6.35	1.2	7.93	
190616-RM	●	●	●	19.05	6.35	1.6	7.93		
Kraftig drejning									
	CNMG120404-GM	●	●	●	12.7	4.76	0.4	5.16	
	120408-GM	●	●	●	12.7	4.76	0.8	5.16	
	120412-GM	●	●	●	12.7	4.76	1.2	5.16	
Middel drejning									
	CNMG120404-MA		●	●	12.7	4.76	0.4	5.16	
	120408-MA		●	●	12.7	4.76	0.8	5.16	
	120412-MA		●	●	12.7	4.76	1.2	5.16	
Middel drejning									
	DNMG110404-LM	●	●	●	9.525	4.76	0.4	3.81	
	110408-LM	●	●	●	9.525	4.76	0.8	3.81	
	150404-LM	●	●	●	12.7	4.76	0.4	5.16	
	150408-LM	●	●	●	12.7	4.76	0.8	5.16	
	150412-LM	●	●	●	12.7	4.76	1.2	5.16	
	150604-LM	●	●	●	12.7	6.35	0.4	5.16	
	150608-LM	●	●	●	12.7	6.35	0.8	5.16	
150612-LM	●	●	●	12.7	6.35	1.2	5.16		
Let drejning									
	DNMG150408-MM	●	●	●	12.7	4.76	0.8	5.16	
	150412-MM	●	●	●	12.7	4.76	1.2	5.16	
	150608-MM	●	●	●	12.7	6.35	0.8	5.16	
	150612-MM	●	●	●	12.7	6.35	1.2	5.16	
Middel drejning									

● : Lagerføres.


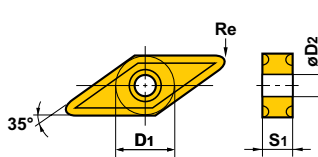

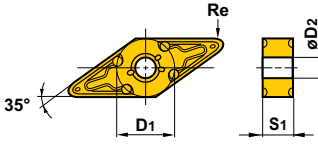

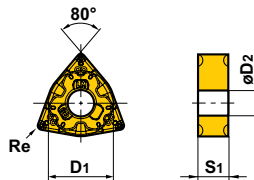

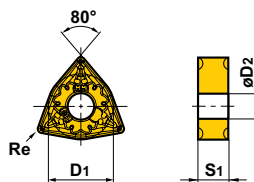

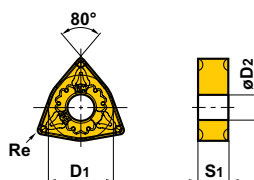

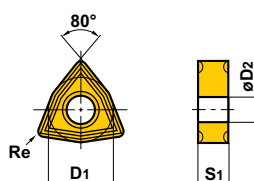

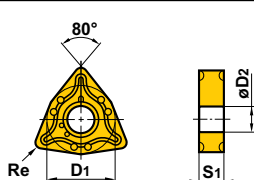
Form	Bestillingsnr.	Lager			Mål (mm)				Geometri
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
RM  Kraftig drejning	DNMG150408-RM	●	●	●	12.7	4.76	0.8	5.16	
	150412-RM	●	●	●	12.7	4.76	1.2	5.16	
	150416-RM	●	●	●	12.7	4.76	1.6	5.16	
	150608-RM	●	●	●	12.7	6.35	0.8	5.16	
	150612-RM	●	●	●	12.7	6.35	1.2	5.16	
	150616-RM	●	●	●	12.7	6.35	1.6	5.16	
GM  Middel drejning	DNMG150404-GM	●	●	●	12.7	4.76	0.4	5.16	
	150408-GM	●	●	●	12.7	4.76	0.8	5.16	
	150412-GM	●	●	●	12.7	4.76	1.2	5.16	
	150604-GM	●	●	●	12.7	6.35	0.4	5.16	
	150608-GM	●	●	●	12.7	6.35	0.8	5.16	
	150612-GM	●	●	●	12.7	6.35	1.2	5.16	
MA  Middel drejning	DNMG150404-MA		●	●	12.7	4.76	0.4	5.16	
	150408-MA		●	●	12.7	4.76	0.8	5.16	
	150412-MA		●	●	12.7	4.76	1.2	5.16	
	150604-MA		●	●	12.7	6.35	0.4	5.16	
	150608-MA		●	●	12.7	6.35	0.8	5.16	
	150612-MA		●	●	12.7	6.35	1.2	5.16	
LM  Let drejning	SNMG120404-LM	●	●	●	12.7	4.76	0.4	5.16	
	120408-LM	●	●	●	12.7	4.76	0.8	5.16	
MM  Middel Drejning	SNMG120408-MM	●	●	●	12.7	4.76	0.8	5.16	
	120412-MM	●	●	●	12.7	4.76	1.2	5.16	
	120416-MM	●	●	●	12.7	4.76	1.6	5.16	
	150608-MM	●	●	●	15.875	6.35	0.8	6.35	
	150612-MM	●	●	●	15.875	6.35	1.2	6.35	
	150616-MM	●	●	●	15.875	6.35	1.6	6.35	
	190612-MM	●	●	●	19.05	6.35	1.2	7.93	
	190616-MM	●	●	●	19.05	6.35	1.6	7.93	
RM  Kraftig drejning	SNMG120408-RM	●	●	●	12.7	4.76	0.8	5.16	
	120412-RM	●	●	●	12.7	4.76	1.2	5.16	
	120416-RM	●	●	●	12.7	4.76	1.6	5.16	
	150612-RM	●	●	●	15.875	6.35	1.2	6.35	
	150616-RM	●	●	●	15.875	6.35	1.6	6.35	
	190612-RM	●	●	●	19.05	6.35	1.2	7.93	
	190616-RM	●	●	●	19.05	6.35	1.6	7.93	
GM  Middel drejning	SNMG120404-GM	●	●	●	12.7	4.76	0.4	5.16	
	120408-GM	●	●	●	12.7	4.76	0.8	5.16	
	120412-GM	●	●	●	12.7	4.76	1.2	5.16	

PLATTER

● Negative platter (med hul)

Form	Bestillingsnr.	Lager			Mål (mm)				Geometri
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
	SNMG120404-MA		●	●	12.7	4.76	0.4	5.16	
	120408-MA		●	●	12.7	4.76	0.8	5.16	
	120412-MA		●	●	12.7	4.76	1.2	5.16	
Middel drejning									
	TNMG160404-LM	●	●	●	9.525	4.76	0.4	3.81	
	160408-LM	●	●	●	9.525	4.76	0.8	3.81	
	160412-LM	●	●	●	9.525	4.76	1.2	3.81	
Let drejning									
	TNMG160408-MM	●	●	●	9.525	4.76	0.8	3.81	
	160412-MM	●	●	●	9.525	4.76	1.2	3.81	
	220408-MM	●	●	●	12.7	4.76	0.8	5.16	
	220412-MM	●	●	●	12.7	4.76	1.2	5.16	
	220416-MM	●	●	●	12.7	4.76	1.6	5.16	
Middel drejning									
	TNMG160408-RM	●	●	●	9.525	4.76	0.8	3.81	
	160412-RM	●	●	●	9.525	4.76	1.2	3.81	
	220408-RM	●	●	●	12.7	4.76	0.8	5.16	
	220412-RM	●	●	●	12.7	4.76	1.2	5.16	
	220416-RM	●	●	●	12.7	4.76	1.6	5.16	
Kraftig drejning									
	TNMG160404-GM	●	●	●	9.525	4.76	0.4	3.81	
	160408-GM	●	●	●	9.525	4.76	0.8	3.81	
	160412-GM	●	●	●	9.525	4.76	1.2	3.81	
	220408-GM	●	●	●	12.7	4.76	0.8	5.16	
	220412-GM	●	●	●	12.7	4.76	1.2	5.16	
Middel drejning									
	TNMG160404-MA		●	●	9.525	4.76	0.4	3.81	
	160408-MA		●	●	9.525	4.76	0.8	3.81	
	160412-MA		●	●	9.525	4.76	1.2	3.81	
	220408-MA		●	●	12.7	4.76	0.8	5.16	
	220412-MA		●	●	12.7	4.76	1.2	5.16	
Middel drejning									
	VNMG160404-LM	●	●	●	9.525	4.76	0.4	3.81	
	160408-LM	●	●	●	9.525	4.76	0.8	3.81	
Let drejning									
	VNMG160408-MM	●	●	●	9.525	4.76	0.8	3.81	
Middel drejning									


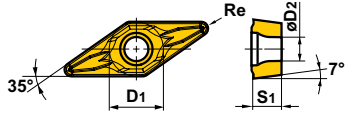

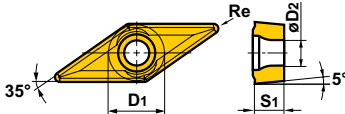
● : Lagerføres.

Form	Bestillingsnr.	Lager			Mål (mm)				Geometri
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
GM 	VNMG160404-GM	●	●	●	9.525	4.76	0.4	3.81	
	160408-GM	●	●	●	9.525	4.76	0.8	3.81	
Middel drejning									
MA 	VNMG160404-MA		●	●	9.525	4.76	0.4	3.81	
	160408-MA		●	●	9.525	4.76	0.8	3.81	
Middel drejning									
LM 	WNMG060404-LM	●	●	●	9.525	4.76	0.4	3.81	
	060408-LM	●	●	●	9.525	4.76	0.8	3.81	
	080404-LM	●	●	●	12.7	4.76	0.4	5.16	
	080408-LM	●	●	●	12.7	4.76	0.8	5.16	
Let drejning									
MM 	WNMG060408-MM	●	●	●	9.525	4.76	0.8	3.81	
	060412-MM	●	●	●	9.525	4.76	1.2	3.81	
	080408-MM	●	●	●	12.7	4.76	0.8	5.16	
	080412-MM	●	●	●	12.7	4.76	1.2	5.16	
Middel drejning									
RM 	WNMG060408-RM	●	●	●	9.525	4.76	0.8	3.81	
	060412-RM	●	●	●	9.525	4.76	1.2	3.81	
	080408-RM	●	●	●	12.7	4.76	0.8	5.16	
	080412-RM	●	●	●	12.7	4.76	1.2	5.16	
Kraftig drejning									
GM 	WNMG060404-GM	●	●	●	9.525	4.76	0.4	3.81	
	060408-GM	●	●	●	9.525	4.76	0.8	3.81	
	080404-GM	●	●	●	12.7	4.76	0.4	5.16	
	080408-GM	●	●	●	12.7	4.76	0.8	5.16	
	080412-GM	●	●	●	12.7	4.76	1.2	5.16	
Middel drejning									
MA 	WNMG060408-MA		●	●	9.525	4.76	0.8	3.81	
	060412-MA		●	●	9.525	4.76	1.2	3.81	
	080404-MA		●	●	12.7	4.76	0.4	5.16	
	080408-MA		●	●	12.7	4.76	0.8	5.16	
	080412-MA		●	●	12.7	4.76	1.2	5.16	
Middel drejning									


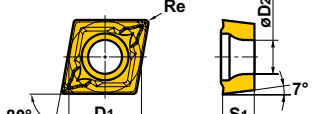

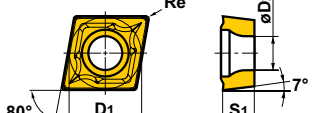

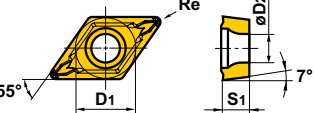

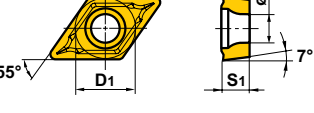

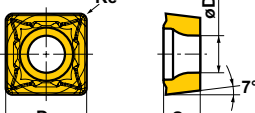
ISO platter til drejning af rustfrit stål

INSERTS


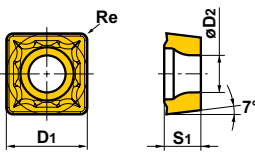

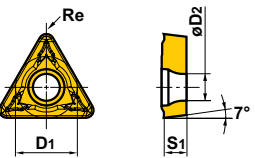

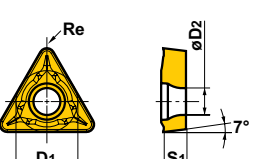

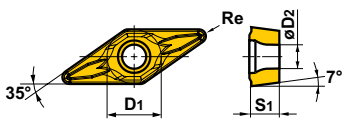

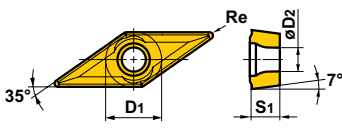
● Positive platter 5° (med hul)

Form	Bestillingsnr.	Lager			Mål (mm)				Geometri
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
 Let drejning	VBMT110304-LM		●	●	6.35	3.18	0.4	2.9	
	110308-LM		●	●	6.35	3.18	0.8	2.9	
	160404-LM		●	●	9.525	4.76	0.4	4.4	
	160408-LM		●	●	9.525	4.76	0.8	4.4	
 Middel drejning	VBMT160404-MM		●	●	9.525	4.76	0.4	4.4	
	160408-MM		●	●	9.525	4.76	0.8	4.4	

● Positive platter 7° (med hul)

Form	Bestillingsnr.	Lager			Mål (mm)				Geometri
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
 Let drejning	CCMT060204-LM		●	●	6.35	2.38	0.4	2.8	
	060208-LM		●	●	6.35	2.38	0.8	2.8	
	09T304-LM		●	●	9.525	3.97	0.4	4.4	
	09T308-LM		●	●	9.525	3.97	0.8	4.4	
 Middel drejning	CCMT060204-MM		●	●	6.35	2.38	0.4	2.8	
	060208-MM		●	●	6.35	2.38	0.8	2.8	
	09T304-MM		●	●	9.525	3.97	0.4	4.4	
	09T308-MM		●	●	9.525	3.97	0.8	4.4	
	120404-MM		●	●	12.7	4.76	0.4	5.5	
	120408-MM		●	●	12.7	4.76	0.8	5.5	
 Let drejning	DCMT070204-LM		●	●	6.35	2.38	0.4	2.8	
	070208-LM		●	●	6.35	2.38	0.8	2.8	
	11T304-LM		●	●	9.525	3.97	0.4	4.4	
	11T308-LM		●	●	9.525	3.97	0.8	4.4	
 Middel drejning	DCMT070204-MM		●	●	6.35	2.38	0.4	2.8	
	070208-MM		●	●	6.35	2.38	0.8	2.8	
	11T304-MM		●	●	9.525	3.97	0.4	4.4	
	11T308-MM		●	●	9.525	3.97	0.8	4.4	
	150404-MM		●	●	12.7	4.76	0.4	5.5	
	150408-MM		●	●	12.7	4.76	0.8	5.5	
 Let drejning	SCMT09T304-LM		●	●	9.525	3.97	0.4	4.4	
	09T308-LM		●	●	9.525	3.97	0.8	4.4	

● : Lagerføres.

Form	Bestillingsnr.	Lager			Mål (mm)				Geometri
		MC7015	MC7025	MP7035	D1	S1	Re	D2	
 Middel drejning	NEW MM								
	SCMT09T304-MM		●	●	9.525	3.97	0.4	4.4	
	09T308-MM		●	●	9.525	3.97	0.8	4.4	
	120404-MM		●	●	12.7	4.76	0.4	5.5	
120408-MM		●	●	12.7	4.76	0.8	5.5		
 Let drejning	NEW LM								
	TCMT090204-LM		●	●	5.56	2.38	0.4	2.5	
	090208-LM		●	●	5.56	2.38	0.8	2.5	
	110204-LM		●	●	6.35	2.38	0.4	2.8	
	110208-LM		●	●	6.35	2.38	0.8	2.8	
	16T304-LM		●	●	9.525	3.97	0.4	4.4	
16T308-LM		●	●	9.525	3.97	0.8	4.4		
 Middel drejning	NEW MM								
	TCMT090204-MM		●	●	5.56	2.38	0.4	2.5	
	090208-MM		●	●	5.56	2.38	0.8	2.5	
	110204-MM		●	●	6.35	2.38	0.4	2.8	
	110208-MM		●	●	6.35	2.38	0.8	2.8	
	130304-MM		●	●	7.94	3.18	0.4	3.4	
	16T304-MM		●	●	9.525	3.97	0.4	4.4	
	16T308-MM		●	●	9.525	3.97	0.8	4.4	
16T312-MM		●	●	9.525	3.97	1.2	4.4		
 Let drejning	NEW LM								
	VCMT110304-LM		●	●	6.35	3.18	0.4	2.8	
	110308-LM		●	●	6.35	3.18	0.8	2.8	
	160404-LM		●	●	9.525	4.76	0.4	4.4	
160408-LM		●	●	9.525	4.76	0.8	4.4		
 Middel drejning	NEW MM								
	VCMT160404-MM		●	●	9.525	4.76	0.4	4.4	
	160408-MM		●	●	9.525	4.76	0.8	4.4	
160412-MM		●	●	9.525	4.76	1.2	4.4		

SKÆREHASTIGHEDER

Negative platter (udvendige drejeværktøjer)

Bearbejdningsmateriale	Hårdhed	Skærehastigheder	Bearbejdnings- område	Spånbryder	Kvalitet	Skærehastighed (m/min.)	Tilspænding (mm/omdr.)	Spåndybde (mm)
M Austenitisk rustfrit stål (X5CrNi189, X5CrNiMo17122)	≤200HB	Stabil bearbejdning	Let drejning	LM	MC7015	180–285	0.10–0.30	0.30–2.00
			Middel drejning	MM	MC7015	160–255	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MC7015	155–245	0.25–0.55	1.50–6.00
		Generel drejning	Let drejning	LM	MC7025	160–215	0.10–0.30	0.30–2.00
			Middel drejning	MM	MC7025	145–195	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MC7025	140–185	0.25–0.55	1.50–6.00
		Ustabil bearbejdning	Let drejning	LM	MP7035	95–155	0.10–0.30	0.30–2.00
			Middel drejning	MM	MP7035	85–140	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MP7035	85–135	0.25–0.55	1.50–6.00
Duplex rustfrit stål (X3CrNiCu1894)	≤280HB	Stabil bearbejdning	Let drejning	LM	MC7015	120–195	0.10–0.30	0.30–2.00
			Middel drejning	MM	MC7015	110–175	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MC7015	105–165	0.25–0.55	1.50–6.00
		Generel drejning	Let drejning	LM	MC7025	110–150	0.10–0.30	0.30–2.00
			Middel drejning	MM	MC7025	100–135	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MC7025	95–125	0.25–0.55	1.50–6.00
		Ustabil bearbejdning	Let drejning	LM	MP7035	65–105	0.10–0.30	0.30–2.00
			Middel drejning	MM	MP7035	60–95	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MP7035	55–90	0.25–0.55	1.50–6.00
Ferritisk og martensitisk rustfrit stål (X12Cr13, X17CrNi162)	≤200HB	Stabil bearbejdning	Let drejning	LM	MC7015	180–285	0.10–0.30	0.30–2.00
			Middel drejning	MM	MC7015	160–255	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MC7015	155–245	0.25–0.55	1.50–6.00
		Generel drejning	Let drejning	LM	MC7025	160–215	0.10–0.30	0.30–2.00
			Middel drejning	MM	MC7025	145–195	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MC7025	140–185	0.25–0.55	1.50–6.00
		Ustabil bearbejdning	Let drejning	LM	MP7035	95–155	0.10–0.30	0.30–2.00
			Middel drejning	MM	MP7035	85–140	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MP7035	85–135	0.25–0.55	1.50–6.00
Hærdet rustfrit stål (17-4PH, 1.4548 17-7PH, 1.4568)	<450HB	Stabil bearbejdning	Let drejning	LM	MC7015	100–160	0.10–0.30	0.30–2.00
			Middel drejning	MM	MC7015	90–145	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MC7015	85–135	0.25–0.55	1.50–6.00
		Generel drejning	Let drejning	LM	MC7025	90–120	0.10–0.30	0.30–2.00
			Middel drejning	MM	MC7025	80–110	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MC7025	80–105	0.25–0.55	1.50–6.00
		Ustabil bearbejdning	Let drejning	LM	MP7035	55–85	0.10–0.30	0.30–2.00
			Middel drejning	MM	MP7035	50–80	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MP7035	45–75	0.25–0.55	1.50–6.00

LEVETID

Skærehastigheds effekt på levetid

Mitsubishi's **TOOL NAVI** anbefalede skæredata er angivet ud fra en værktøjslevetid på 15-60 min. Baseret på Taylor's formel (Sammenhæng mellem Plattekvalitet, skæredata og levetid). Såfremt en anden plattekvalitet benyttes, så benyt da kalkulationsfaktoren i nedenstående skema og udregn en ny skærehastighed.

SKÆREHASTIGHEDER

Negative platter (udvendige drejeværktøjer)

Bearbejdningsmateriale	Hårdhed	Skærehastigheder	Bearbejdningsområde	Spånbrøder	Kvalitet	Skærehastighed (m/min.)	Tilspænding (mm/omdr.)	Spåndybde (mm)
Austenitisk rustfrit stål (X5CrNi189, X5CrNiMo17122)	≤200HB	Stabil bearbejdning	Let drejning	LM	MC7015	180–285	0.10–0.30	0.30–2.00
			Middel drejning	MM	MC7015	160–255	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MC7015	155–245	0.25–0.55	1.50–6.00
		Generel drejning	Let drejning	LM	MC7025	160–215	0.10–0.30	0.30–2.00
			Middel drejning	MM	MC7025	145–195	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MC7025	140–185	0.25–0.55	1.50–6.00
		Ustabil bearbejdning	Let drejning	LM	MP7035	95–155	0.10–0.30	0.30–2.00
			Middel drejning	MM	MP7035	85–140	0.15–0.45	0.70–5.00
			Kraftig drejning	RM	MP7035	85–135	0.25–0.55	1.50–6.00

M Kvalitet (Rustfri stål) skære data kalkulationsfaktorer

Kvalitet	Levetid				
	15min	30min	45min	60min	90min
MC7015	1.00	0.83	0.75	0.70	0.63
MC7025	1.00	0.90	0.84	0.80	0.75
MP7035	1.00	0.84	0.76	0.71	0.62

(ex.) Generel drejning, Austenitisk rustfrit stål (200HB)
 Det anbefalede førstevalg af plattetype: MC7025
 Platter : CNMG120408-MM
 Skærehastighed : Vc=195m/min (Levetid = 15min)
 (Levetid : Vc145m/min = 90min)

Nødvendig levetid : 30min

$$Vc195 \times 0.90 = Vc175m/min$$

Hårdhed på materialet der bearbejdes

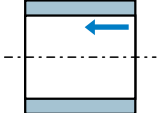
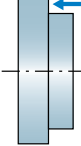
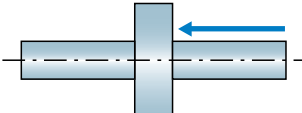






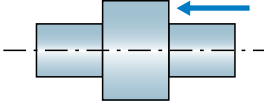

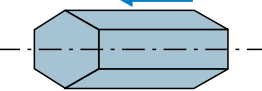






Materialets hårdhed har også effekt på plattens levetid. Mitsubishi's **TOOL NAVI** anbefalede skærehastigheder varierer når materialets hårdhed ændres. Find den rigtige koefficient værdi i skemaet herunder. Multipliser så koefficient værdien med den anbefalede skærehastighed for at opnå en ny skærehastighed.

Bearbejdningsmateriale	Hårdhed	Bearbejdningsmateriale HB									
		Blød	-60	-40	-20	0	+20	+40	+60	+80	+100
Austenitisk rustfrit stål	180HB	1.41	1.23	1.10	1.0	0.91	0.85	0.72	0.68	0.64	0.61
Duplex rustfrit stål	280HB	1.25	1.15	1.06	1.0	0.94	0.90	0.85	-	-	-
Ferritisk og martensitisk rustfrit stål	180HB	1.41	1.23	1.10	1.0	0.91	0.85	0.78	0.72	0.68	0.64
Hærdet rustfrit stål	350HB	1.18	1.13	1.07	1.0	0.95	-	-	-	-	-

(ex.) Austenitisk rustfrit stål (200HB)

$$Vc=175m/min \times 0.91 = Vc159m/min$$

EKSEMPLER PÅ ANVENDELSE

Platte	WNMG080408-MM	CNMG160612-RM	CNMG120408-MM
Arbejdsemne	1.4308 (G-X6CrNi189) 	Dupleks 1.4460 (X3CrNiMo27-5-2) 	1.4541 (X10CrNiTi189) 
Skærelængsler	Skærehastighed (m/min.)	145	100
	Tilspænding (mm/omdr.)	0.13	0.45
	Spåndybde (mm)	2.0	4.0
	Kølemiddel	Ja	Ja
Resultater	Konkurrentens MC7025  5 bearbejdede dele	Konkurrentens MC7025  10 bearbejdede dele	Konkurrentens MC7015  8 bearbejdede dele
	Konkurrentens MC7015  8 bearbejdede dele	Konkurrentens MC7015  4 bearbejdede dele	Konkurrentens MC7015  8 bearbejdede dele
Platte	CNMG120408-LM	WNMG080408-MM	CNMG120408-LM
Arbejdsemne	1.4529 (X1NiCrMoCuN25-20-6) 	1.4401 (X5CrNiMo1810) 	1.4350 (X5CrNi189) 
Skærelængsler	Skærehastighed (m/min.)	140	122
	Tilspænding (mm/omdr.)	0.2	0.3
	Spåndybde (mm)	1.1	2.2
	Kølemiddel	Ja	Ja
Resultater	Konkurrentens MC7025  12 bearbejdede dele	Konkurrentens MC7015  15 bearbejdede dele	Konkurrentens MP7035  60 bearbejdede dele
	Konkurrentens MP7035  60 bearbejdede dele	Konkurrentens MP7035  5 bearbejdede dele	Konkurrentens MP7035  5 bearbejdede dele



www.mitsubishicarbide.com

MMC HARTMETALL GmbH

Comeniusstr. 2, 40670 Meerbusch, Germany
Tel. +49-2159-9189-0 Fax +49-2159-918966
e-mail admin@mmchg.de

MMC HARDMETAL U.K. LTD.

Mitsubishi House, Galena Close, Tamworth, Staffs. B77 4AS, U.K.
Tel. +44-1827-312312 Fax +44-1827-312314
e-mail sales@mitsubishicarbide.co.uk

MMC METAL FRANCE s.a.r.l.

6, Rue Jacques Monod, 91400 Orsay, France
Tel. +33-1-69 35 53 53 Fax +33-1-69 35 53 50
e-mail mmfsales@mmc-metal-france.fr

MITSUBISHI MATERIALS ESPAÑA, S.A.

Calle Emperador 2, 46136 Museros/Valencia, Spain
Tel. +34-96-144-1711 Fax +34-96-144-3786
e-mail mme@mmevalencia.com

MMC ITALIA S.r.l.

V.le Delle Industrie 2, 20020 Milano, Italy
Tel. +39-02 93 77 03 1 Fax +39-02 93 58 90 93
e-mail info@mmc-italia.it

MMC HARDMETAL POLAND SP. z o.o.

Al. Armii Krajowej 61, 50-541 Wrocław, Poland
Tel. +48-71335-16-20 Fax +48-71335-16-21
e-mail sales@mitsubishicarbide.com.pl

MMC HARDMETAL RUSSIA OOO LTD.

UL. Bolschaja Semenovskaya, 11, bld 5, 107023 Moscow, Russia
Tel. +7-495-72558-85 Fax +7-495-98139-73
e-mail info@mmc-carbide.ru



HASSING GRUPPEN

Carl Hassing A/S
Hvidkærvej 43 • 5250 Odense SV
E-mail: tools@hassing.dk
Tlf.: 44 99 61 11 • Fax: 44 99 74 40

