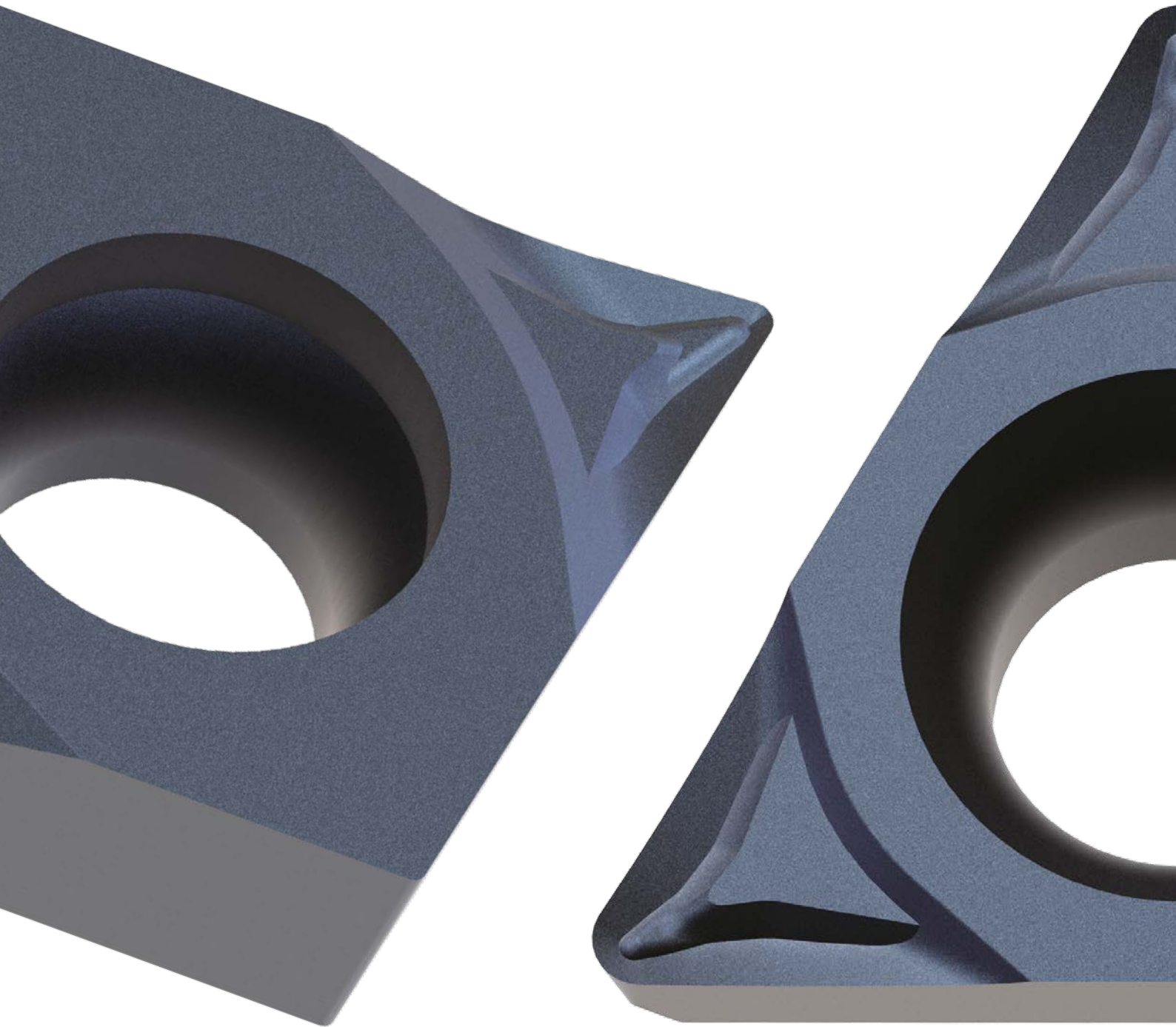


NEW

SPANBRECHER FSF/FSF-P

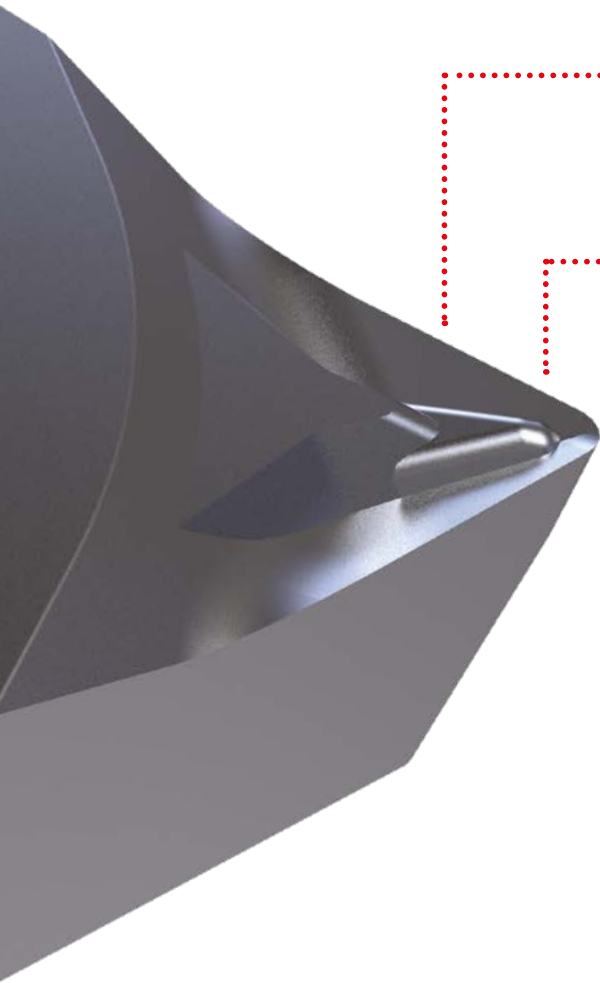
IDEALER SPANBRECHER FÜR GERINGE SCHNITTIEFEN
UND FERTIGBEARBEITUNG

B210D-I



SPANBRECHER FSF/FSP-P

SPANBRECHER FÜR KLEINE SCHNITTTIEFEN



SCHARFE SCHNEIDKANTE

Der 25°-Spanwinkel sorgt für eine scharfe Schneidkante und erreicht dadurch sehr gute Oberflächengüten.

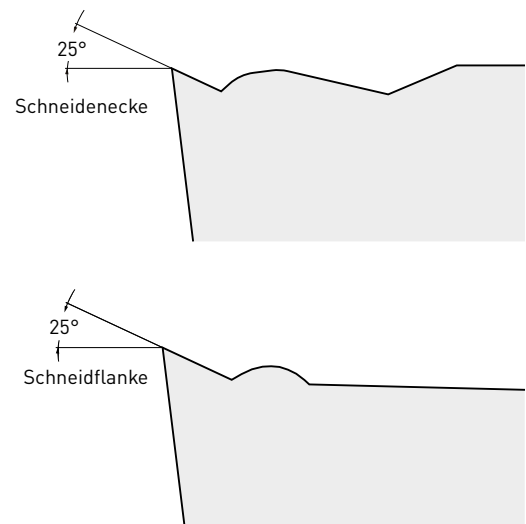
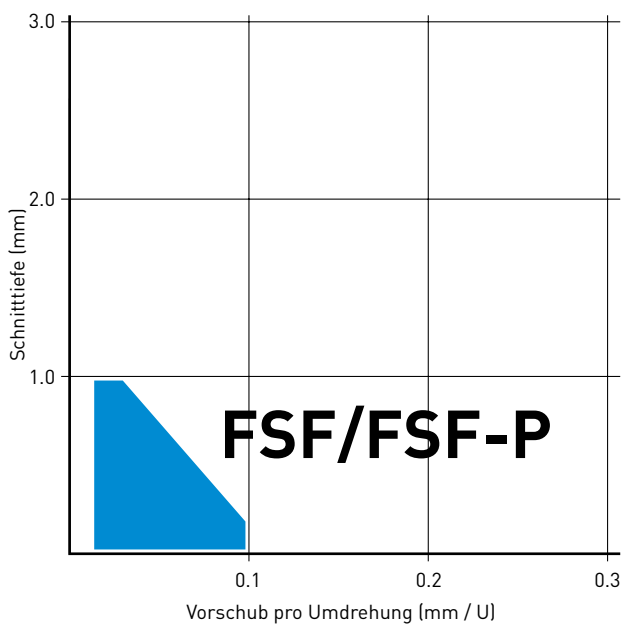
GERINGER SCHNITTDRUCK

Ausführung mit geringem Schnittwiderstand und weicher Spanbrecher-Auskrägung.

MEHRSTUFIGER SPANBRECHER

Für schwankende Schnitttiefen.

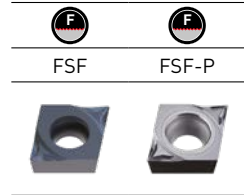
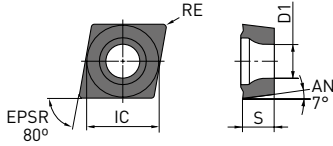
ANWENDUNGSBEREICH



CCGT

7° POSITIVE WSP (MIT LOCH)

G-Klasse



Bestellnummer	F M		MP9025	MS7025	MS9025	VP30RT	HT110	IC	S	RE	D1
	F	M									
CCGT03S101M-FSF	F		●					3.97	1.39	0.1	2.0
CCGT03S102M-FSF	F		●					3.97	1.39	0.2	2.0
CCGT04T001M-FSF	F		●					4.76	1.79	0.1	2.4
CCGT04T002M-FSF	F		●					4.76	1.79	0.2	2.4
CCGT060201M-FSF	F		●					6.35	2.38	0.1	2.8
CCGT060202M-FSF	F		●					6.35	2.38	0.2	2.8
CCGT060204M-FSF	F		●					6.35	2.38	0.4	2.8
CCGT03S101M-FSF-P	F			●	●			3.97	1.39	0.1	2.0
CCGT03S102M-FSF-P	F			●	●			3.97	1.39	0.2	2.0
CCGT04T001M-FSF-P	F			●	●			4.76	1.79	0.1	2.4
CCGT04T002M-FSF-P	F			●	●			4.76	1.79	0.2	2.4
CCGT0602V5M-FSF-P	F			●		●		6.35	2.38	0.05	2.8
CCGT060201M-FSF-P	F			●	●	●		6.35	2.38	0.1	2.8
CCGT060202M-FSF-P	F			●	●	●		6.35	2.38	0.2	2.8
CCGT060204M-FSF-P	F			●	●	●		6.35	2.38	0.4	2.8
CCGT09T3V5M-FSF-P	F			●		●		9.525	3.97	0.05	4.4
CCGT09T301M-FSF-P	F			●	●	●		9.525	3.97	0.1	4.4
CCGT09T302M-FSF-P	F			●		●		9.525	3.97	0.2	4.4
CCGT09T304M-FSF-P	F			●		●		9.525	3.97	0.4	4.4

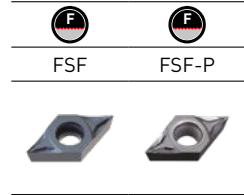
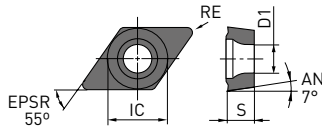
1/1



DCGT

7° POSITIVE WSP (MIT LOCH)

G-Klasse



Bestellnummer	F M		MP9025	MS7025	MS9025	VP30RT	HT110	IC	S	RE	D1
	F	M									
DCGT070201M-FSF	F		●					6.35	2.38	0.1	2.8
DCGT070202M-FSF	F		●					6.35	2.38	0.2	2.8
DCGT11T301M-FSF	F		●					9.525	3.97	0.1	4.4
DCGT11T302M-FSF	F		●					9.525	3.97	0.2	4.4
DCGT0702V5M-FSF-P	F			●		●		6.35	2.38	0.05	2.8
DCGT070201M-FSF-P	F			●	●	●		6.35	2.38	0.1	2.8
DCGT070202M-FSF-P	F			●	●	●		6.35	2.38	0.2	2.8
DCGT11T3V5M-FSF-P	F			●		●		9.525	3.97	0.05	4.4
DCGT11T301M-FSF-P	F			●	●	●		9.525	3.97	0.1	4.4
DCGT11T302M-FSF-P	F			●	●	●		9.525	3.97	0.2	4.4
DCGT11T304M-FSF-P	F			●		●		9.525	3.97	0.4	4.4

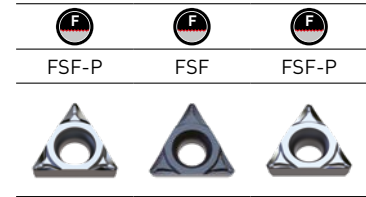
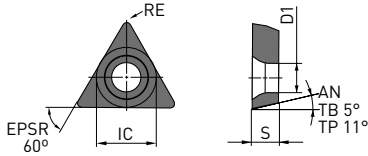
1/1





TBGT, TPGH

5°, 11° POSITIVE WSP (MIT LOCH)

G-Klasse



Bestellnummer	 	MP9025	MS7025	MS9025	VP30RT	HT110	IC	S	RE	D1
TBGT060102M-FSF-P	F		●		●		3.97	1.59	0.2	2.3
TPGH090201M-FSF	F	●					5.56	2.38	0.1	2.9
TPGH090202M-FSF	F	●					5.56	2.38	0.2	2.9
TPGH090204M-FSF	F	●					5.56	2.38	0.4	2.9
TPGH080201M-FSF-P	F		●	●	●		4.76	2.38	0.1	2.4
TPGH080202M-FSF-P	F		●		●		4.76	2.38	0.2	2.4
TPGH090201M-FSF-P	F		●	●	●		5.56	2.38	0.1	2.9
TPGH090202M-FSF-P	F		●	●	●		5.56	2.38	0.2	2.9
TPGH090204M-FSF-P	F		●	●	●		5.56	2.38	0.4	2.9

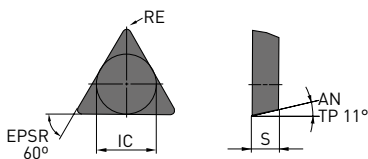
1/1



TPGB



11° POSITIVE WSP (OHNE LOCH)

G-Klasse



Stabile
Schneidkante
Glatt



Bestellnummer	 	MP9025	MS7025	MS9025	VP30RT	HT110	IC	S	RE	D1
TPGB110202	M					●	6.35	2.38	0.2	—
TPGB110204	M					●	6.35	2.38	0.4	—
TPGB160304	M					●	9.525	3.18	0.4	—
TPGB160308	M					●	9.525	3.18	0.8	—
TPGB080202	M					●	4.76	2.38	0.2	—
TPGB080204	M					●	4.76	2.38	0.4	—
TPGB080208	M					●	4.76	2.38	0.8	—
TPGB090202	M					●	5.56	2.38	0.2	—
TPGB090204	M					●	5.56	2.38	0.4	—
TPGB1102V5	M					●	6.35	2.38	0.05	—
TPGN090202	—					●	5.56	2.38	0.2	—
TPGN090204	—					●	5.56	2.38	0.4	—
TPGN090208	—					●	5.56	2.38	0.8	—

1/1

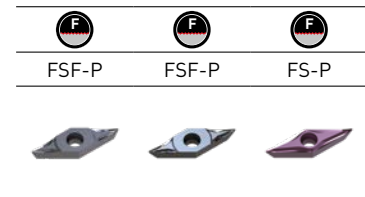
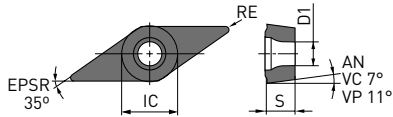
● : Lagerstandard. ★ : Lagerstandard in Japan.



VCGT, VPGT

7°, 11° POSITIVE WSP (MIT LOCH)

G-Klasse



Bestellnummer	F M	MP9025	MS7025	MS9025	VP30RT	HT110	IC	S	RE	D1
VCGT110301M-FSF-P	F		●	●	●		6.35	3.18	0.1	2.8
VCGT110302M-FSF-P	F		●		●		6.35	3.18	0.2	2.8
VCGT110304M-FSF-P	F		●		●		6.35	3.18	0.4	2.8
VPGT110301M-FSF-P	F		●	●	●		6.35	3.18	0.1	2.9
VPGT110302M-FSF-P	F		●		●		6.35	3.18	0.2	2.9
VPGT110304M-FSF-P	F		●		●		6.35	3.18	0.4	2.9
VPGT110301M-FS-P	F		●		●		6.35	3.18	0.1	2.9
VPGT110302M-FS-P	F		●		●		6.35	3.18	0.2	2.9

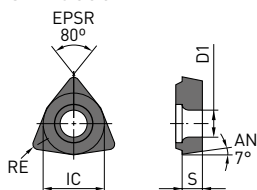
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WCGT

7° POSITIVE WSP (MIT LOCH)

G-Klasse



Bestellnummer	F M	MP9025	MS7025	MS9025	VP30RT	HT110	IC	S	RE	D1
WCGT020101M-FSF-P	F		●	●	●		3.97	1.59	0.1	2.3
WCGT020102M-FSF-P	F		●	●	●		3.97	1.59	0.2	2.3
WCGTL30201M-FSF-P	F		●	●	●		4.76	2.38	0.1	2.3
WCGTL30202M-FSF-P	F		●	●	●		4.76	2.38	0.2	2.3
WCGT040201M-FSF-P	F		●	●	●		6.35	2.38	0.1	2.8
WCGT040202M-FSF-P	F		●	●	●		6.35	2.38	0.2	2.8
WCGT06T301M-FSF-P	F			●			9.525	3.97	0.1	4.4
WCGT06T302M-FSF-P	F		●	●	●		9.525	3.97	0.2	4.4
WCGT06T304M-FSF-P	F		●		●		9.525	3.97	0.4	4.4

1/1



SPANBRECHER FSF/FSF-P

SCHNITTDATENEMPFEHLUNGEN

SCHNITTGESCHWINDIGKEIT

Material	Eigenschaften	Schnittmodus	MP9025 Vc	MS7025 Vc	MS9025 Vc	VP30RT Vc	HT110 Vc	
P Weichmagnetischer Stahl, Allgemeiner Baustahl	≤180 HB	F	●	—	100 – 300	—	—	
			✱	—	—	155 – 190	—	
			●	—	40 – 130	—	—	
C-Stahl, legierter Stahl	180–280 HB	F	●	—	—	—	—	
			✱	—	—	115 – 140	—	
			✱	—	—	80 – 100	—	
M Austenitischer rostfreier Stahl	≤200 HB	F	●	—	40 – 100	60 – 150	—	
			✱	—	—	50 – 90	—	
			●	—	40 – 100	—	—	
			✱	—	—	50 – 90	—	
			●	—	—	—	40 – 75	—
			✱	—	—	—	—	—
			✱	—	—	—	—	—
K Grauguss	≤350 MPa	M	●✱	—	—	—	90 – 125	
			●●✱	—	—	—	70 – 100	
			●●✱	—	—	—	60 – 90	
N Aluminiumlegierungen	—	M	●●✱	—	—	—	300 – 700	
			●	—	—	—	—	
S Hitzebeständige Legierungen	—	F	●	—	40 – 140	—	—	
			✱	25 – 40	—	—	—	

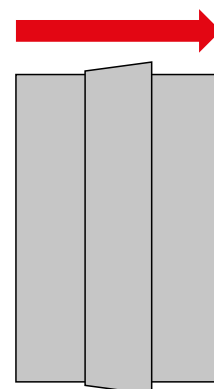
1/1

Spanbrecher	f (mm/U)	ap (mm)
FSF, FSF-P	0.02 – 0.1	0.02 – 1.0
FS-P	0.04 – 0.2	0.2 – 0.9
Standard	0.08 – 0.3	0.3 – 2.0
Glatt	0.08 – 0.3	0.3 – 2.0

ANWENDUNGSBEISPIELE

AUSSENDREHEN

Werkstückmaterial	DIN 1.4301 (X5CrNi18-10)
Scheidplatte	DCGT11T301M-FSF-P
Sorte	MS9025
Vc (m/min)	120
f (mm/U)	0.02
ap (mm)	0.1
Schnittmodus	Nassbearbeitung (Öl)
Ergebnis	Das Absplittern an der Schneidkante wurde unterdrückt, und der Spanabtrag war gut. Mit der neuen Werkzeugstandzeit können nun 750 Teile bearbeitet werden, anstatt der bisherigen 150.



Schnittmodus: ● : Stabile Bearbeitung ● : Allgemeine Bearbeitung ✱ : Instabile Bearbeitung

Anwendungsbereich: F: Schlichtbearbeitung M: Mittlere Bearbeitung

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