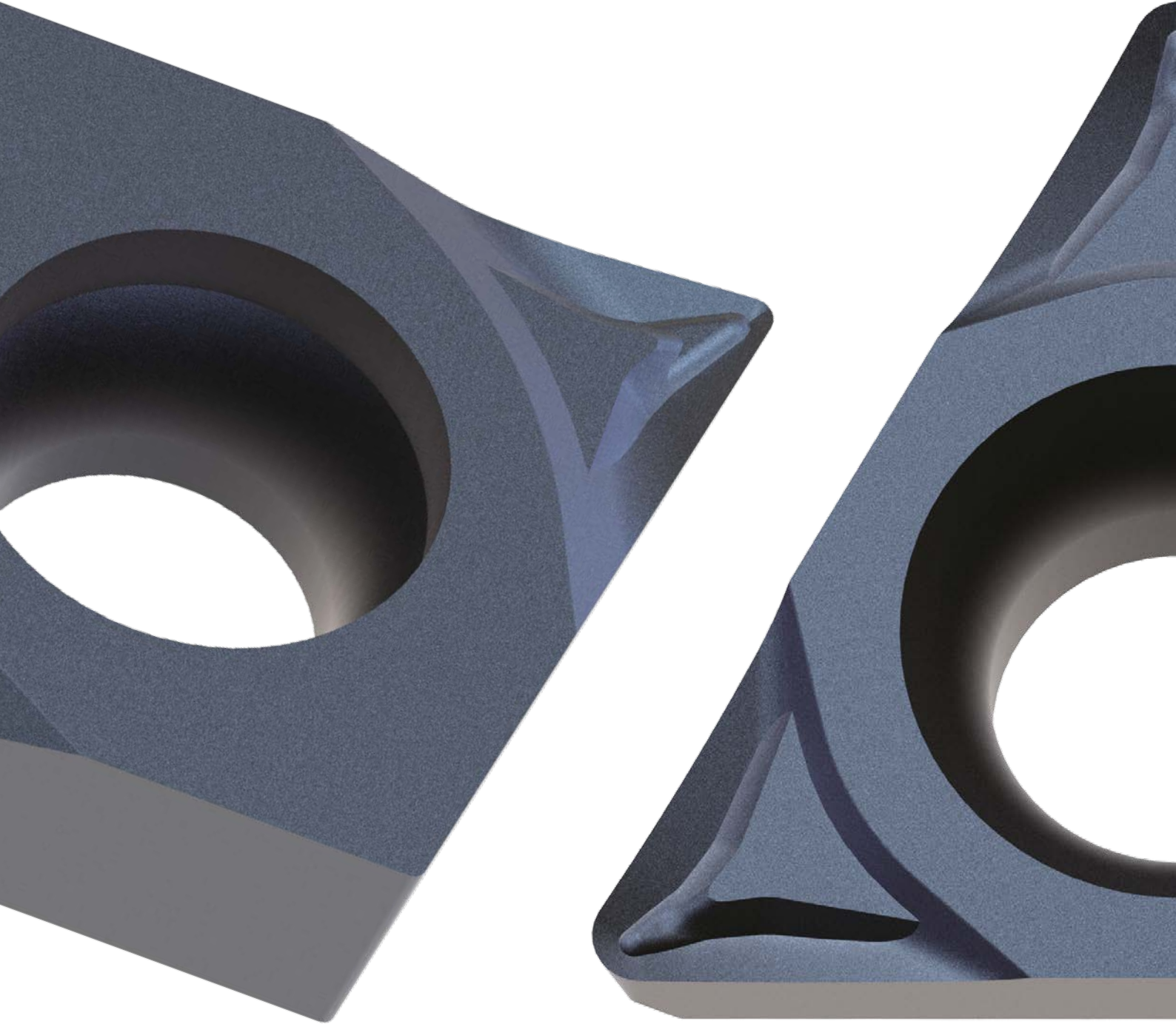


NEW

FSF/FSF-P TALAŞ KIRICI

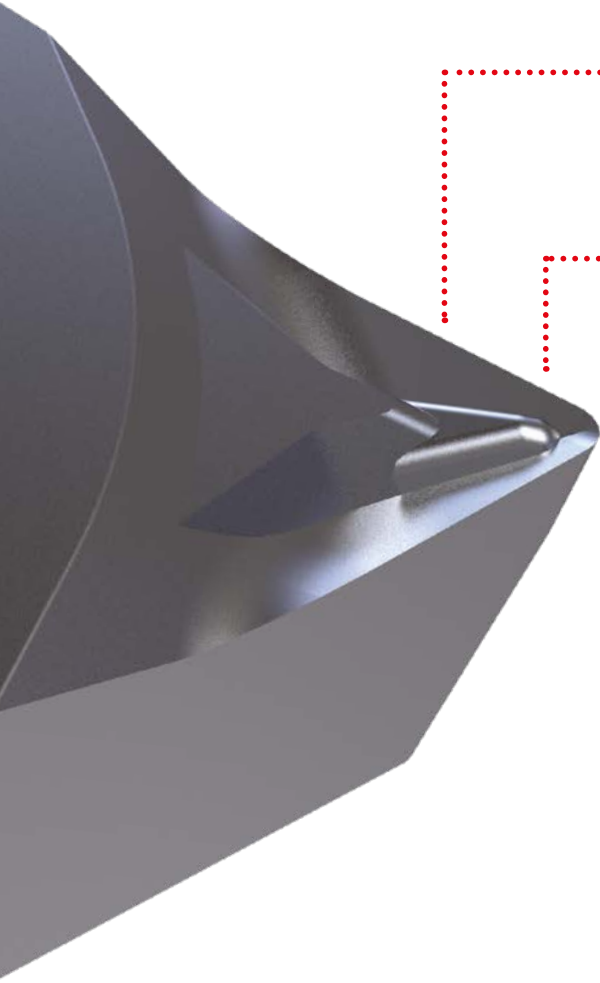
KÜÇÜK KESME DERİNLİKLERİNE VE FİNİŞ İŞLEMLERİNE
YÖNELİK İÇİN İDEAL TALAŞ KIRICI

B210TR-I



FSF/FSP-P TALAŞ KIRICI

KÜÇÜK KESME DERİNLİKLERİ İÇİN TALAŞ KIRICI



KESKİN KESME KENARI

Keskin 25° eğim açısı, keskin kesme kenarı ve güzel işlenmiş bir yüzeyi garanti eder.

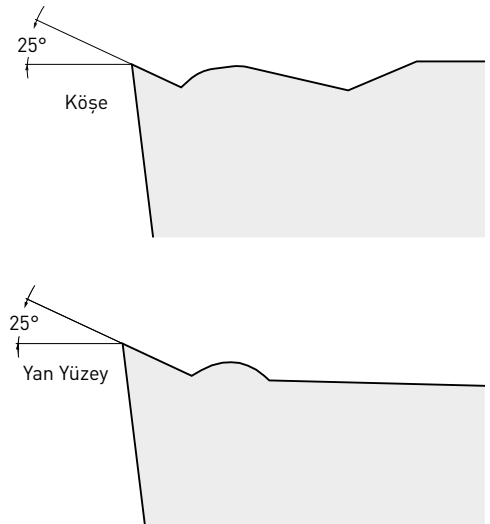
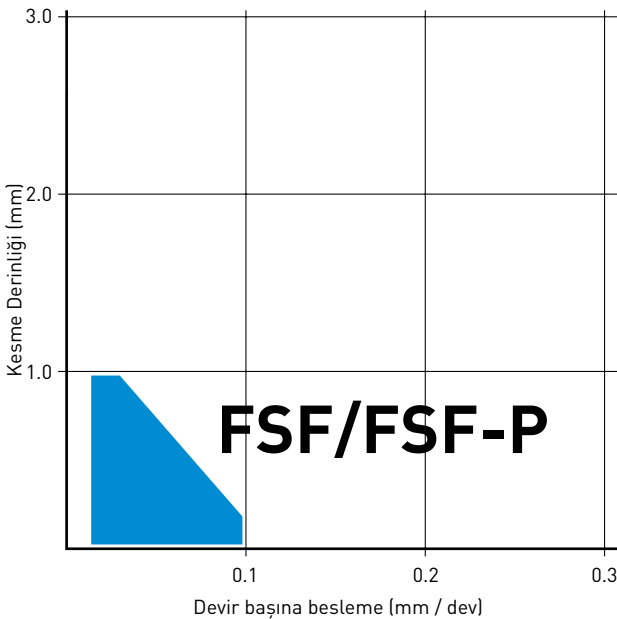
DÜŞÜK KESME DİRENCİ

Yumuşak talaş kırıcı çıkıntısı ile düşük kesme direnci tasarımı.

ÇOK AŞAMALI TALAŞ KIRICI

Kesim derinliğindeki dalgalanmaları karşılar.

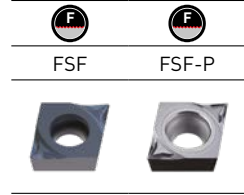
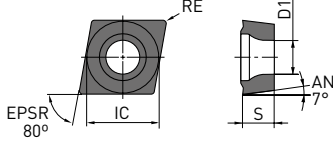
UYGULAMA ARALIĞI





CCGT

7° POZİTİF KESİCİ UÇLAR (DELİKLİ)

G Sınıf



Sipariş No.	 	MP9025	MS7025	MS9025	VP30RT	HT110	IC	S	RE	D1
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

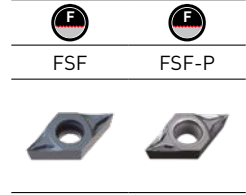
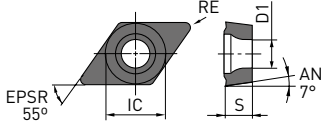
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DCGT

7° POZİTİF KESİCİ UÇLAR (DELİKLİ)

G Sınıf



Sipariş No.	 	MP9025	MS7025	MS9025	VP30RT	HT110	IC	S	RE	D1
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

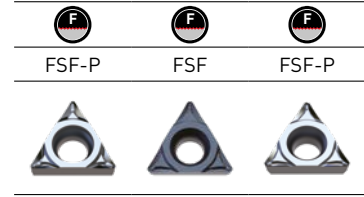
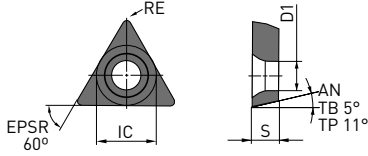
1/1





TBGT, TPGH

5°, 11° POZİTİF KESİCİ UÇLAR (DELİKLİ)

G Sınıf



Sipariş No.	 	MP9025	MS7025	MS9025	VP30RT	HT110	IC	S	RE	D1
TBGT060101M-FSF-P	F		●	●	●		3.97	1.59	0.1	2.3
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

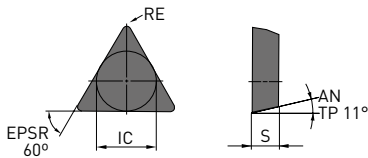
1/1



TPGB



11° POZİTİF KESİCİ UÇLAR (DELİKSİZ)

G Sınıf



Güçl Kesme
Kenarı
Düz Üst



Sipariş No.	 	MP9025	MS7025	MS9025	VP30RT	HT110	IC	S	RE	D1
TPGB110201	M					●	6.35	2.38	0.1	—
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	—

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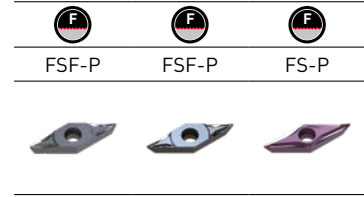
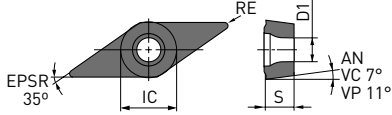
● : Avrupa da standart stok. ★ : Japonya da standart stok.



VCGT, VPGT

7°, 11° POZİTİF KESİCİ UÇLAR (DELİKLİ)

G Sınıf



Sipariş No.	 	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

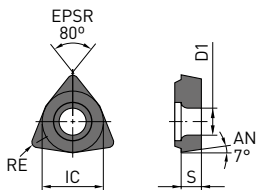
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WCGT

7° POZİTİF KESİCİ UÇLAR (DELİKLİ)

G Sınıf



Sipariş No.	 	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


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FSF/FSF-P TALAŞ KIRICI

TAVSİYE EDİLEN KESME KOŞULLARI

KESME HIZI

Malzeme	Sertlik		Kesme Koşulu	MP9025 Vc	MS7025 Vc	MS9025 Vc	VP30RT Vc	HT110 Vc
P	Yumuşak Manyetik Demir, Hafif Çelik	≤180 HB	F	●	100 – 300	—	—	—
	Karbon Çeliği, Alaşımli Çelik	180–280 HB	F	●	—	—	155 – 190	—
	Karbon Çeliği, Alaşımli Çelik	280–350 HB	F	●	—	—	80 – 100	—
M	Ostenitik Paslanmaz Çelik	≤200 HB	F	●	—	40 – 100	60 – 150	—
	Ferritik ve Martensitli Paslanmaz Çelik	≤200 HB	F	●	—	40 – 100	—	—
	Ostenitik, Ferritik ve Martensitik Paslanmaz Çelik	>200 HB	F	●	—	—	50 – 90	—
	Elektromanyetik Paslanmaz Çelik	230 HB	F	●	—	40 – 160	50 – 180	—
	Dubleks Paslanmaz Çelik	≤280 HB	F	●	—	—	—	35 – 60
	Çökeltmeyle Sertleştirilmiş Paslanmaz Çelik	<450 HB	F	●	70 – 85	40 – 80	50 – 100	—
	Gri Dökme Demir	≤350 MPa	M	●	—	—	—	90 – 125
K	Duktil Dökme Demir	≤450 MPa	M	●	—	—	—	70 – 100
	Duktil Dökme Demir	≤800 MPa	M	●	—	—	—	60 – 90
N	Alüminyum Alaşımlar	—	M	●	—	—	—	300 – 700
S	Isıya Dirençli Alaşımlar	—	F	●	—	40 – 140	—	—
				●	25 – 40	—	—	—

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Talaş kırıcı

f (mm/dev)

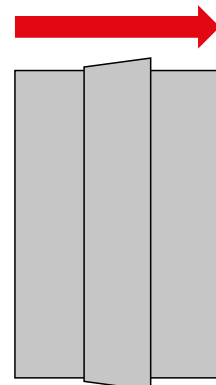
ap (mm)

FSF, FSF-P	0.02 – 0.1	0.02 – 1.0
FS-P	0.04 – 0.2	0.2 – 0.9
Standart	0.08 – 0.3	0.3 – 2.0
Düz Üst	0.08 – 0.3	0.3 – 2.0

UYGULAMA ÖRNEKLERİ

DIŞ ÇAP TORNALAMA

İş parçası malzemesi	DIN 1.4301 (X5CrNi18-10)
Kesici uç	DCGT11T301M-FSF-P
Kalite	MS9025
Vc (m/dak)	120
f (mm/dev)	0.02
ap (mm)	0.1
Kesme modu	Islak kesme (Yağ)
Sonuç	Kesme kenarındaki talaş uzaklaştırıldı ve talaş kaldırma işlemi başarılıydı. Geleneksel 150 parçalık takım ömrüne kıyasla artık 750 parça işlenebiliyor.



Kesme Koşulları: ● : Dengeli Kesme ● : Genel Kesme ✖ : Stabil Olmayan Kesme
Kesme Bölgesi : F : Finiş Kesme M : Orta Kesme

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