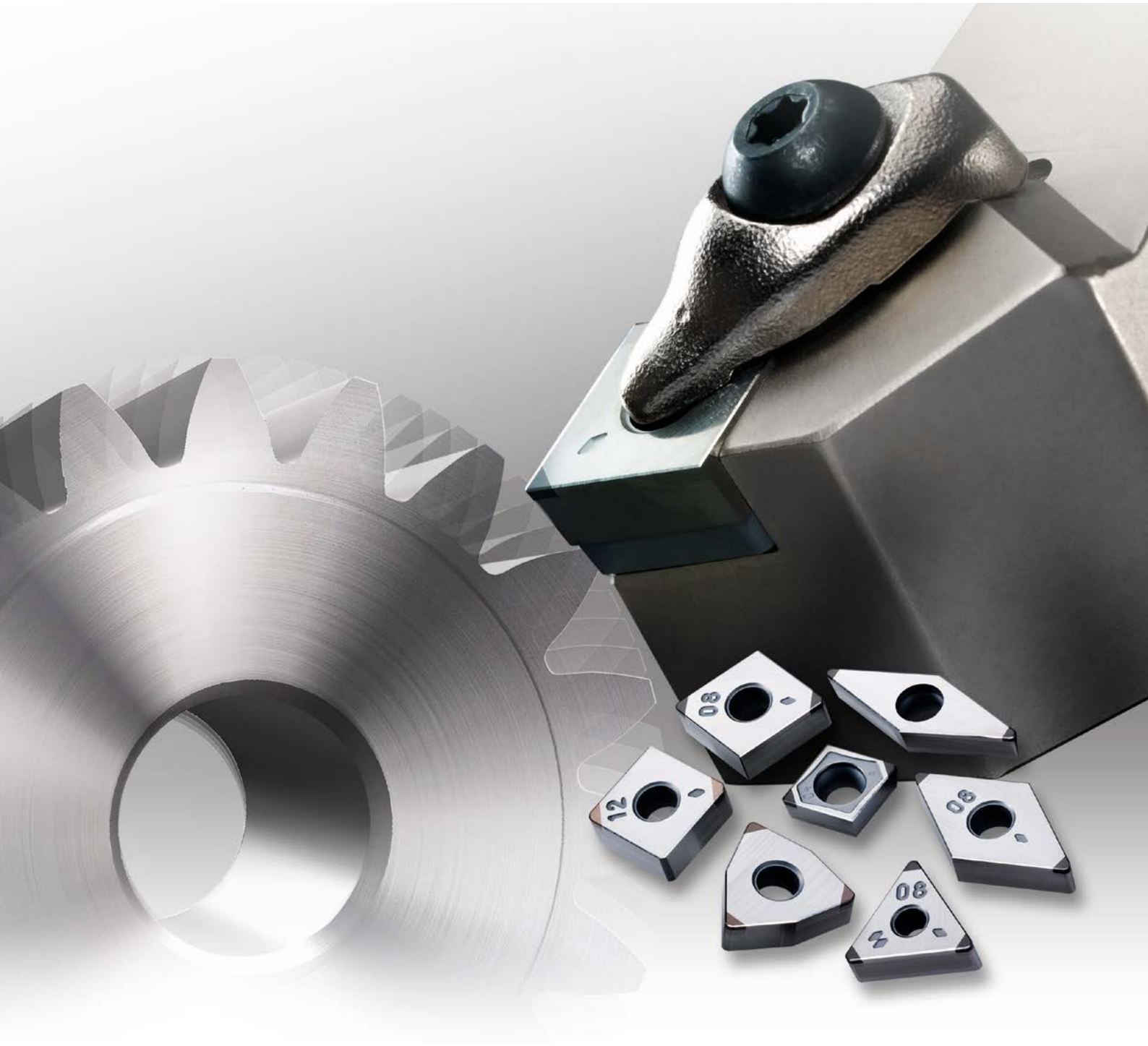
B246TR

MB4120

SİNTERLENMİŞ ALAŞIM VE DÖKME DEMİR İÇİN CNB KALİTESİ



MITSUBISHI MATERIALS

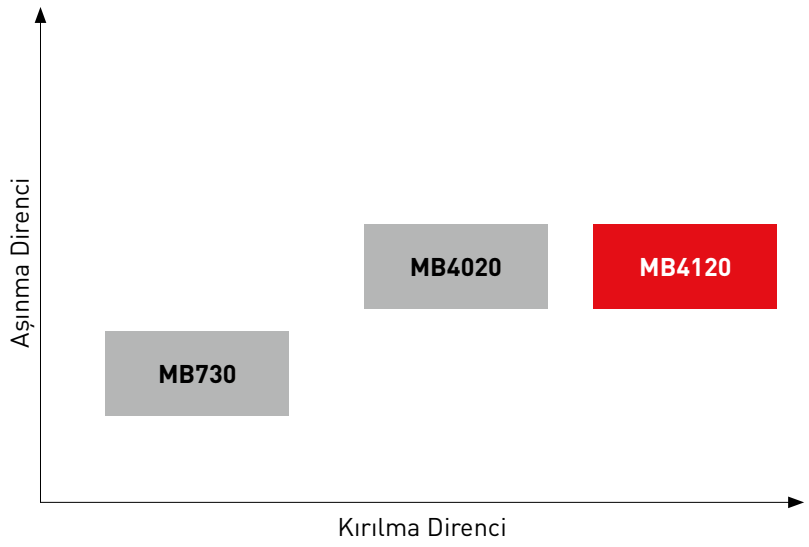
MB4120

DAHA YÜKSEK VERİMLİLİK İÇİN MÜKEMMEL KIRILMA DİRENCİ VE DAYANIKLILIK

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

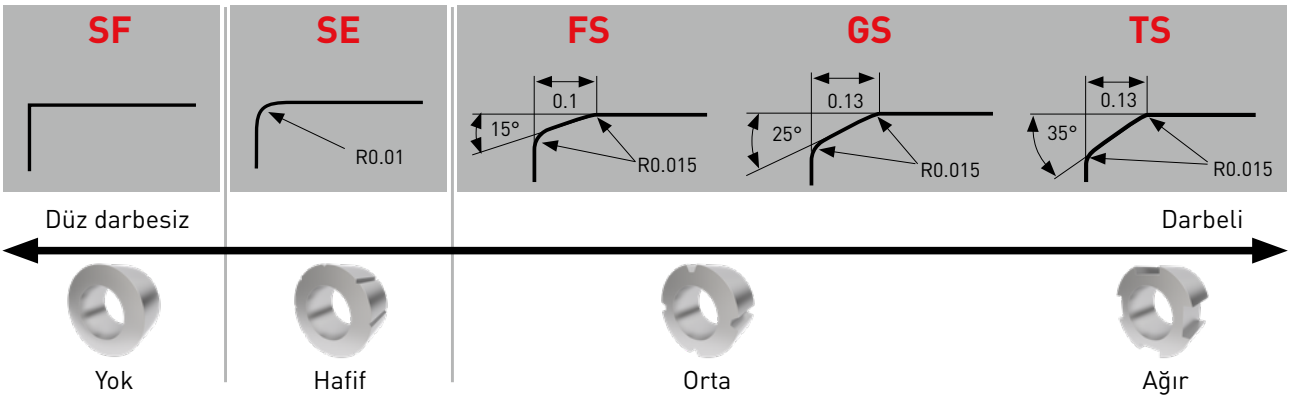
YÜKSEK KIRILMA DİRENCİ
İnce CBN partikülleri kesme kenarının tokluğunu arttırır. Yüksek kırılma direnci, darbeli işlemede bile dengeli performans sağlar.

İNCE CBN PARTİKÜLLERİNİN YÜKSEK BAĞLANMA KUVVETİ
Sinterleme koşullarının optimizasyonu, ince CBN partikülleri arasındaki bağlanmayı güçlendirir. Bu hem kırılma hemde aşınma direncini arttırır.



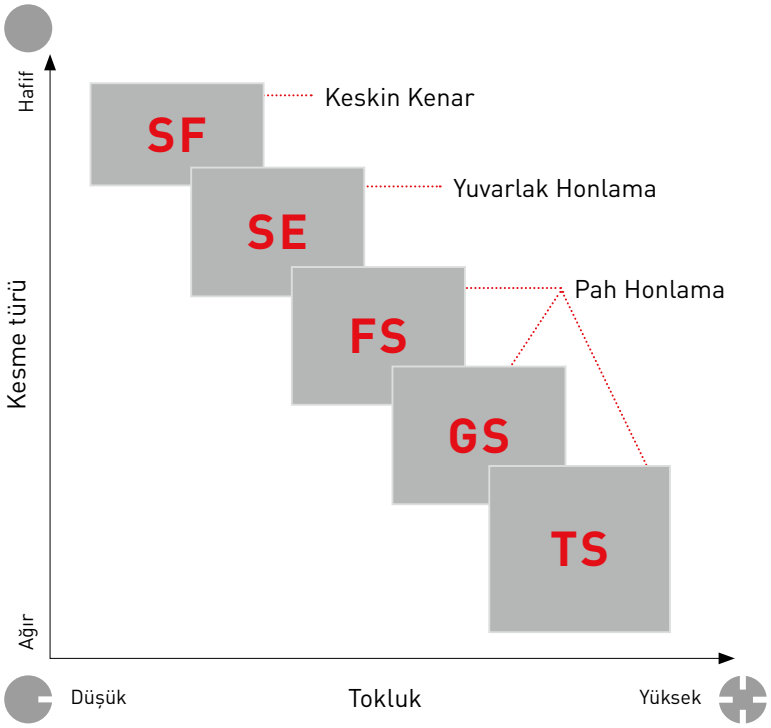
GEOMETRİ

KESME KENARI HAZIRLAMA



KAPSAMLI KENAR HAZIRLAMA (HONLAMA)

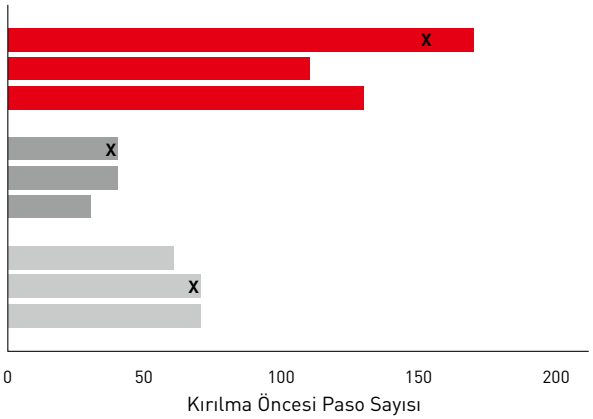
SF honlama tipi, kesme direncinde düşmeye yol açan daha keskin bir kesme kenarı sunar ve çapak oluşumu yanı sıra parça yüzey kalitesinde de iyileştirme sağlar. SF tipi ilk genel tavsiyedir ancak kesme kenarı sağlamlığı ve kenar dökülmesi direnci artışı için SE, FS, GS ve TS honlama türleri tavsiye edilir.



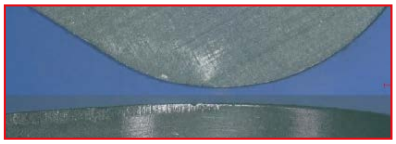
AĞIR DARBELİ İŞLEME SIRASINDA ARTTIRILMIŞ KIRILMA DİRENCİ

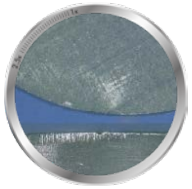
Yüksek mukavemetli sinterlenmiş alaşımın darbeli yüzeyinin kesilmesi sırasında kırılma direnci karşılaştırması.

Malzeme	Yüksek Mukavemetli Sinterlenmiş Alaşım
Kesici uç	NP-TNGA160408SE3
Vc (m/min)	150
f (mm/rev)	0.15
ap (mm)	0.1
Kesme Türü	Islak Kesme



MB4120



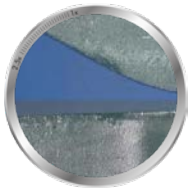


Dökülme 150 geçiş

Klasik A

Dökülme 40 geçiş

Klasik B

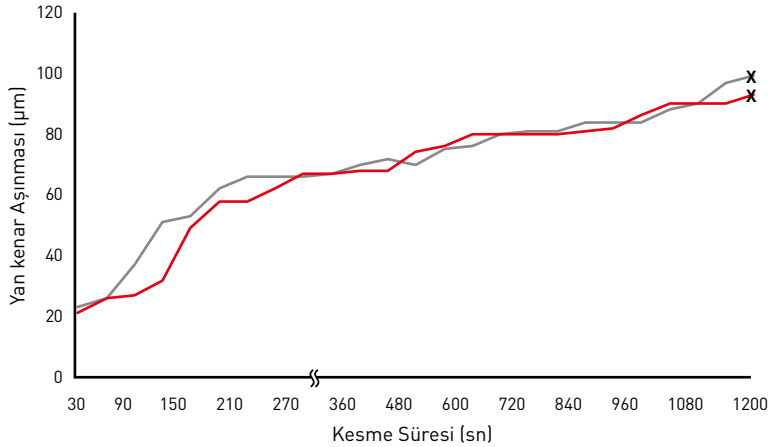


Dökülme 70 geçiş

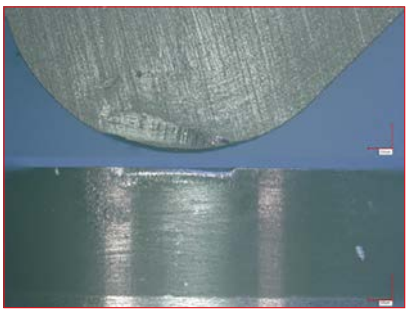
DIN GG25'İN DÜZ SÜREKLİ İŞLEME KARŞILAŞTIRMASI

Klasik ürünler ile karşılaştırıldığında mükemmel kırılma direnci.

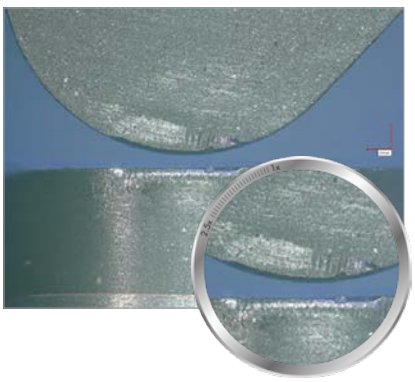
Malzeme	DIN GG25 (Perlite)
Kesici uç	NP-TNGA160408SF3
Vc (m/min)	800
f (mm/rev)	0.1
ap (mm)	0.2
Kesme Türü	Kuru Kesme



MB4120 1200 sn



Klasik 1200 sn



■ : Mitsubishi Materials Takım ■ : klasik Takım

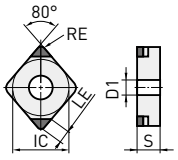
MB4120

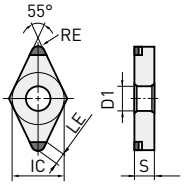
NEGATİF KESİCİ UÇLAR (DELİKLİ)

K H

G SINIFI

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





●: Avrupa standart stokta. ★: Japonya standart stokta. ▲: Yeni ürünlerle değişecek.

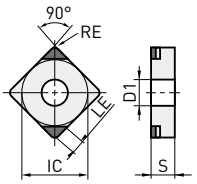
MB4120

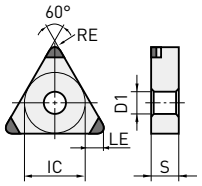
NEGATİF KESİCİ UÇLAR (DELİKLİ)

K H

G SINIFI

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





●: Avrupa standart stokta. ★: Japonya standart stokta. ▲: Yeni ürünlerle değişecek.

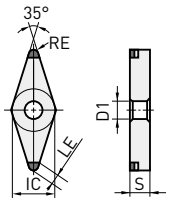
MB4120

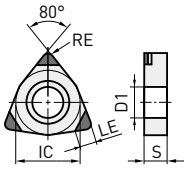
NEGATİF KESİCİ UÇLAR (DELİKLİ)

K H

G SINIFI

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





●: Avrupa standart stokta. ★: Japonya standart stokta. ▲: Yeni ürünlerle değişecek.

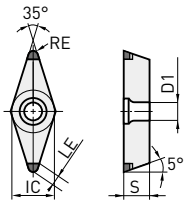
MB4120

POZİTİF KESİCİ UÇLAR (DELİKLİ)

K H

G SINIFI

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



●: Avrupa standart stokta. ★: Japonya standart stokta. ▲: Yeni ürünlerle değişecek.

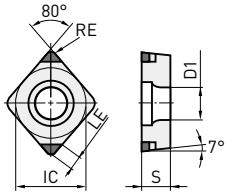
MB4120

POZİTİF KESİCİ UÇLAR (DELİKLİ)

K H

G SINIFI

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



●: Avrupa standart stokta. ★: Japonya standart stokta. ▲: Yeni ürünlerle değişecek.

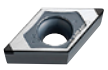
MB4120

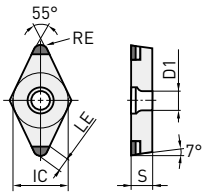
POZİTİF KESİCİ UÇLAR (DELİKLİ)

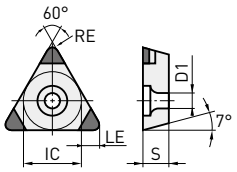
K H

G SINIFI

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







●: Avrupa standart stokta. ★: Japonya standart stokta. ▲: Yeni ürünlerle değişecek.

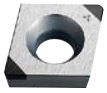
MB4120

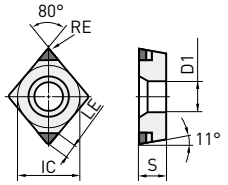
POZİTİF KESİCİ UÇLAR (DELİKLİ)

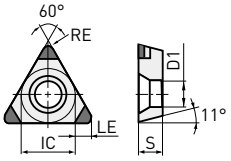
K H

G SINIFI

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







●: Avrupa standart stokta. ★: Japonya standart stokta. ▲: Yeni ürünlerle değişecek.

MB4120

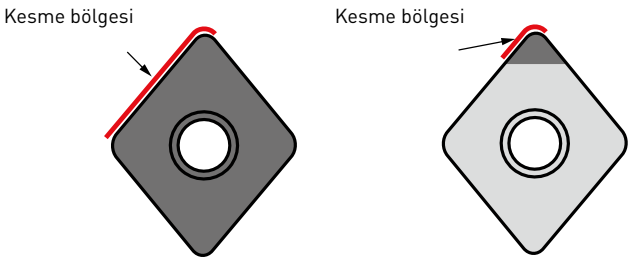
ÖNERİLEN KESME KOŞULLARI

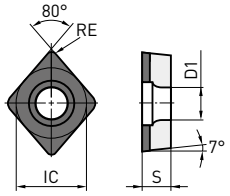
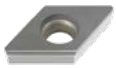
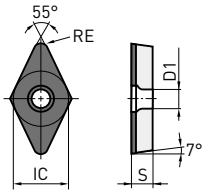
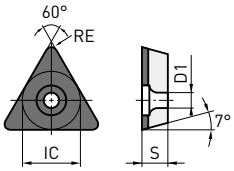
	Malzeme	Kesme Türü	Kalite	f	ap	Vc
H	Genel Sinterlenmiş Alaşımlar	Kuru, Islak	MB4120	≤0.2	≤0.3	80—320
H	Yüksek Dayanıklı Sinterlenmiş Alaşımlar	Kuru, Islak	MB4120	≤0.2	≤0.3	80—230
H	Sertleştirilmiş Sinterlenmiş Alaşımlar	Kuru, Islak	MB4120	≤0.2	≤0.3	80—180
K	Gri Dökme Demir	Kuru, Islak	MB4120	≤0.2	≤0.3	210—320

MB4020

TAM YÜZ CBN

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



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

ÖNERİLEN KESME KOŞULLARI

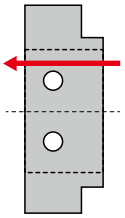
TAM YÜZ İÇİN KESME KOŞULLARI

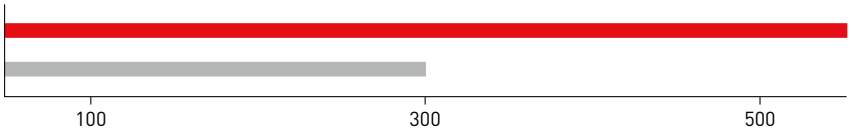
	Malzeme	Kesme Türü	Kalite	f	ap	Vc
H	Genel Sinterlenmiş Alaşımlar	Kuru, Islak	MB4020	-0.2	-0.3 (-2.0)	80—250
H	Yüksek Dayanıklı Sinterlenmiş Alaşımlar	Kuru, Islak		-0.2	-0.3 (-2.0)	80—200
H	Sertleştirilmiş Sinterlenmiş Alaşımlar	Kuru, Islak		-0.2	-0.3 (-2.0)	80—150
K	Gri Dökme Demir	Kuru, Islak	MB4020	-0.4	-0.5 (-2.0)	230—760
K		Kuru		-0.15	-0.5 (-2.0)	510—1000

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

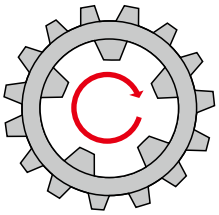
UYGULAMA ÖRNEKLERİ

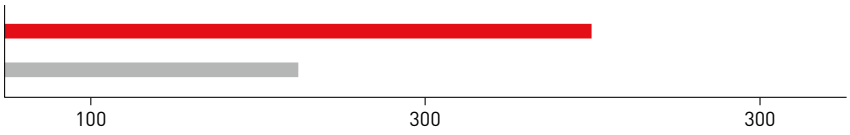
Kesici uç	NP-DCGW11T308SF2
İş Parçası Malzemesi	Genel Sinterlenmiş Alaşım
Parça	Gövde (Darbeli delik işleme)
Vc (m/dk)	200
f (mm/dev)	0.07
ap (mm)	0.2
Kesme türü	Islak Kesme
Sonuçlar	Klasik ürüne göre iki kat takım ömrü.



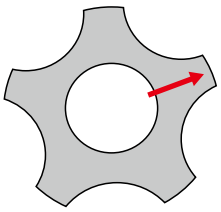


Kesici uç	NP-DCGW11T308SF2
İş Parçası Malzemesi	Genel Sinterlenmiş Alaşım
Parça	Muhafaza (Darbeli Delik İşleme)
Vc (m/dk)	180
f (mm/dev)	0.25
ap (mm)	0.2 – 0.3
Kesme türü	Islak Kesme
Sonuçlar	Klasik ürüne göre iki kat takım ömrü.





Kesici uç	NP-DCGW11T308SF2
İş Parçası Malzemesi	Demir Esaslı Sinterlenmiş Alaşım (60 HRB) Ra<1,0 µm
Parça	Pinyon (Darbeli alın İşleme)
Vc (m/dk)	200
f (mm/dev)	0.04 – 0.05
ap (mm)	0.4
Kesme türü	Islak Kesme
Sonuçlar	Klasik bir ürüne göre iyi yüzey kalitesi sağlanmış ve 2,5 kat daha uzun takım ömrü elde edilmiştir.

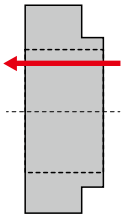


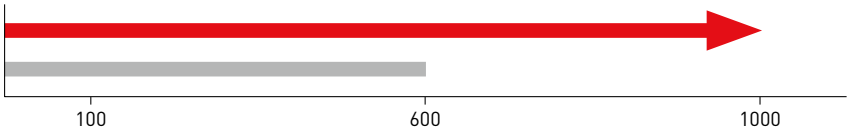
Yukarıdaki uygulama örnekleri müşteri uygulamalarıdır, bu nedenle önerilen koşullardan farklılık gösterebilir.

■ : Mitsubishi Materials Takım ■ : klasik Takım

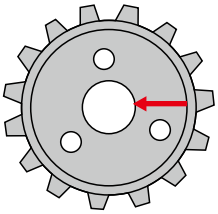
UYGULAMA ÖRNEKLERİ

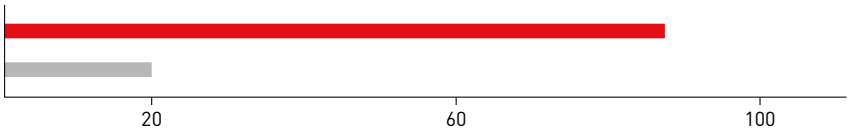
Kesici uç	NP-TNGA160408SF3
İş Parçası Malzemesi	Yüksek Dirençli Sinterlenmiş Alaşım
Parça	Dişli (Düz Sürekli Delik İşleme)
Vc (m/dk)	250
f (mm/dev)	0.1
ap (mm)	0.1
Kesme türü	Islak Kesme
Sonuçlar	Klasik bir ürünle karşılaştırıldığında yan kenar aşınması daha azdır ve kesici uç kullanılmaya devam edilebilmiştir.



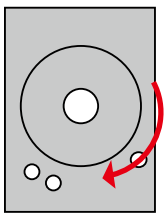


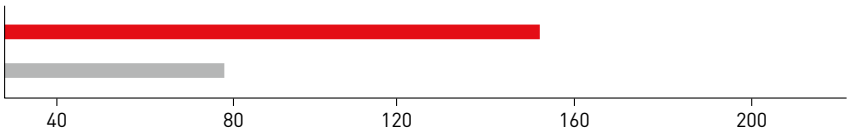
Kesici uç	NP-TNGA160408SE3
İş Parçası Malzemesi	Genel Sinterlenmiş Alaşım
Parça	Dişli (Darbeli alın işleme)
Vc (m/dk)	240
f (mm/dev)	0.12
ap (mm)	0.05
Kesme türü	Islak Kesme
Sonuçlar	Klasik bir sermet ürüne göre daha yüksek yüzey kalitesi ve en az 4 kat daha uzun takım ömrü elde edilmiştir.





Kesici uç	NP-CNGA120408SF2
İş Parçası Malzemesi	Dökme Demir
Parça	Mekanik Parçalar (Darbeli alın İşleme)
Vc (m/dk)	600
f (mm/dev)	0.175 – 0.25
ap (mm)	0.15 – 0.2
Kesme türü	Kuru Kesme
Sonuçlar	Anormal hasar yoktur ve en az 1,5 kat daha uzun takım ömrü elde edilmiştir.





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

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Tarafından yayınlanmıştır: MITSUBISHI MATERIALS TOOLS EUROPE | 2018.10