

LSE445

GÜVENİLİR VE VERİMLİ İŞLEME İÇİN 20° POZİTİF KESİCİ
UÇLU GENEL YÜZEY FREZELEME SERİSİ



*M*plus...

LSE445

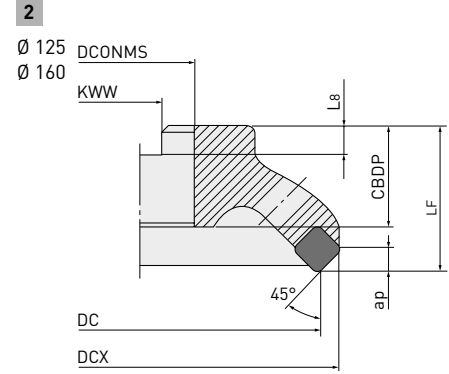
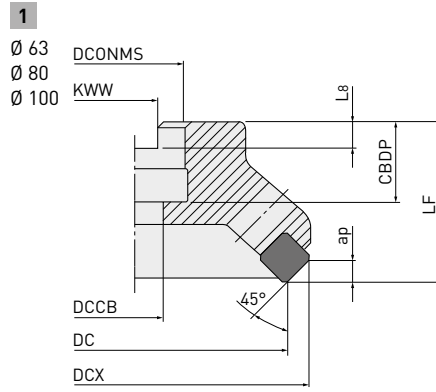


45° YÜZEY FREZELEME - GENEL KESME

P M K N



C H: 45°
A.R: +19° T: +13°
RR: -2° I: +15°



MALAFİ TİPİ

Sipariş No.	Stok		ZEFP	DC	DCX	LF	DCONMS	CBDP	DCCB	KWW	L8	WT	APMX	Tip	
	R	L													
LSE445-063A05R/L-E	●	□	5	63	76.5	40	22	20	11	10.4	6.4	0.8	5.5	—	1
LSE445-080A06R/L-E	●	□	6	80	93.5	50	27	22	13.5	12.4	7.0	1.0	5.5	—	1
LSE445-100A07R/L-E	●	□	7	100	113.5	50	32	25	17.5	14.4	8.0	1.4	5.5	—	1
LSE445-125B09R/L-E	□	□	9	125	138.5	50	40	—	—	16.4	9.0	2.0	5.5	—	2
LSE445-160B11R/L-E	□	□	11	160	173.5	50	40	—	—	16.4	9.0	3.0	5.5	—	2

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YEDEK PARÇALAR

Takım Tutucu Numarası	*1					
	Altık	Altık Vidası	Kama	Sıkma Vidası	Anahtar	Anahtar
LSE445 -063A05R/L-E				LS10T		
LSE445 -080A04R/L-E						
LSE445-100A07R/L-E	STBE445NF	CS300890T	CWSE445TR	LS15T	TKY25T	TKY08F
LSE445-125B09R/L-E						
LSE445 -160B11R/L-E						

*1 Sıkma Torku (N • m): LS10T= 8.5. LS15T= 8.5. CS300890T= 1.0

LSE445 – KESİCİ UÇLAR

P	Çelik	●	●		●	●	●											Kesme Koşulları:
M	Paslanmaz Çelik	●	●		●	●	●											●: Düz stabil Kesme ●: Genel Kesme ❖: Darbeli Kesme
K	Dökme Demir				●	❖	●											Honlama:
N	Demir İçermeyen Metal																	E: Yuvarlak F: Keskin S: Pah + Hon T: Şamfer Z: Güçlü

Sipariş No.	Sınıf	Honlama	F7010	F7030	MC5020	VP15TF	NX2525	NX4545	UT120T	HT10	IC	S	BS	RE	Şekil
SEEN1203AFFN1	E	F	●							●	12.7	3.18	1.4	1.0	
SEEN1203AFEN1	E	E				●					12.7	3.18	1.4	1.0	
SEEN1203AFTN1	E	T	●				●		●		12.7	3.18	1.4	1.0	
SEEN1203AFTN3	E	T	●					●	★		12.7	3.18	1.4	—	
SEEN1203AFSN1	E	S		●	●						12.7	3.18	1.4	1.0	
SEEN1203AFSN3	E	S		●							12.7	3.18	1.4	—	
SEEN1203AFZN1	E	Z					●				12.7	3.18	1.4	1.0	

Kırılcılı kesici uçlar

SEER1203AFEN-JS	E	E	●	●	●	●					12.7	3.18	1.4	1.0	
SEER1204AFEN-JS	E	E	●								12.7	3.18	1.4	1.0	

Silicili kesici uçlar

WEC42AFTR5C	C	T					●				—	3.18	5	1.0	

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ÖNERİLEN KESME KOŞULLARI

Malzeme	Sertlik	Kalite	Vc	fz
P Yumuşak Çelik	<180HB	F7030	300 (200 – 360)	0.2 (0.1 – 0.3)
		NX4545		
		UTi20T	240 (170 – 300)	
		UP20M		
Karbon Çeliği Alaşımlı Çelik	180 – 280HB	F7030	250 (170 – 300)	0.2 (0.1 – 0.3)
		NX4545		
	UTi20T	200 (140 – 240)		
	UP20M			
280 – 350HB	UTi20T	140 (100 – 170)	0.15 (0.1 – 0.2)	
	M Paslanmaz Çelik	<200HB	UP20M	200 (140 – 240)
UTi20T				
K Dökme Demir	Kopma Mukavemeti <450MPa	MC5020	200 (130 – 240)	0.2 (0.1 – 0.3)
		F5010		
		F5020		
		HTi10	160 (110 – 190)	
UTi20T				
N Alüminyum Alaşımı	—	MD220	1000 (200 – 1500)	0.15 (0.05 – 0.25)
		HTi10	1000 (700 – 1200)	0.12 (0.05 – 0.2)

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1. Devir [dk⁻¹] = (1000 x Kesme Hızı) ÷ (3.14 x veD1).

2. Tabla İlerlemesi (mm / dk) = Diş Başına İlerleme x Diş Sayısı x Kesici Devri.





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