

B17 Fräswendeplatten und Schnittdaten

Milling inserts and parameters, Plaquettes de fraisage et paramètres, Inserti e parametri di taglio

			HC45 (code 41)	HT45 (code 31)	HT50 (code 22)	HT32 (code 33)	HT30 (code 29)	HC30 (code 52)	XC35 (code 46)
	JMB17-75R04- 12,0x7,0x4,0 R0,4	Order- No.		B17A-XM31	B17A-YK22	B17A-WL33	B17A-UH29		
	HM	f_z [mm]		0,10 (0,05-0,30)	0,10 (0,05-0,30)	0,10 (0,05-0,30)	0,10 (0,05-0,30)		
	JMB17-275R04- 12,0x7,0x4,0 R0,4	Order- No.		B17A-DT31		B17A-CX33			
	HM	f_z [mm]		0,10 (0,05-0,30)		0,10 (0,05-0,30)			
	JMB17-275R08- 12,0x7,0x4,0 R0,8	Order- No.		B17A-RA31		B17A-KJ33			
	HM	f_z [mm]		0,10 (0,05-0,30)		0,10 (0,05-0,30)			
	JMB17-75MR10- 12,0x7,0x4,0 R1,0	Order- No.	B17A-TK41					B17A-SH52	
	U	f_z [mm]	0,15 (0,05-0,30)					0,15 (0,05-0,30)	
	JMB17-75R10- 12,0x7,0x4,0 R1,0	Order- No.		B17A-KU31	B17A-LK22	B17A-JP33	B17A-HT29		
	HM	f_z [mm]		0,10 (0,05-0,30)	0,10 (0,05-0,30)	0,10 (0,05-0,30)	0,10 (0,05-0,30)		
	JMB17-76R04- 12,0x7,0x4,0 R0,4	Order- No.			B17B-NK22		B17B-GP29		
	S	f_z [mm]			0,15 (0,10-0,30)		0,10 (0,05-0,30)		
	JMB17-76R06- 12,0x7,0x4,0 R0,6	Order- No.			B17B-SX22		B17B-RK29		
	S	f_z [mm]			0,10 (0,05-0,30)		0,10 (0,05-0,30)		
	JMB17-76MR08- 12,0x7,0x4,0 R0,8	Order- No.							B17B-AO46
	U	f_z [mm]							0,10 (0,09-0,25)
	JMB17-76R08- 12,0x7,0x4,0 R0,8	Order- No.			B17B-WR22		B17B-UW29		B17B-ZS46
	S	f_z [mm]			0,10 (0,05-0,30)		0,10 (0,05-0,30)		0,10 (0,04-0,20)
	JMB17-76R02- 12,0x7,0x4,0 R0,2	Order- No.							
	S	f_z [mm]							
	JMB17-76R04- 12,0x7,0x4,0 R0,4	Order- No.							
	S	f_z [mm]							
	JMB17-76R06- 12,0x7,0x4,0 R0,6	Order- No.							
	S	f_z [mm]							
			20	20	20	20	20	20	20

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			HT20 (code 32)	KT28 (code 23)	K15M (code 8)				
									
	JMB17-75R04- 12,0x7,0x4,0 R0,4	Order- No.		B17A-ZE23					
	H M 	f_z [mm]		0,15 (0,10-0,30)					
	JMB17-275R04- 12,0x7,0x4,0 R0,4	Order- No.	B17A-BR32						
	H M 	f_z [mm]	0,15 (0,10-0,30)						
	JMB17-275R08- 12,0x7,0x4,0 R0,8	Order- No.	B17A-FY32						
	H M 	f_z [mm]	0,10 (0,05-0,30)						
	JMB17-75MR10- 12,0x7,0x4,0 R1,0	Order- No.							
	U 	f_z [mm]							
	JMB17-75R10- 12,0x7,0x4,0 R1,0	Order- No.		B17A-MU23					
	H M 	f_z [mm]		0,10 (0,05-0,30)					
	JMB17-76R04- 12,0x7,0x4,0 R0,4	Order- No.		B17B-JT23					
	S 	f_z [mm]		0,10 (0,05-0,30)					
	JMB17-76R06- 12,0x7,0x4,0 R0,6	Order- No.		B17B-TY23					
	S 	f_z [mm]		0,10 (0,05-0,30)					
	JMB17-76MR08- 12,0x7,0x4,0 R0,8	Order- No.							
	U 	f_z [mm]							
	JMB17-76R08- 12,0x7,0x4,0 R0,8	Order- No.		B17B-YT23					
	S 	f_z [mm]		0,10 (0,05-0,30)					
	JMB17-76R02- 12,0x7,0x4,0 R0,2	Order- No.			B17D-NU08				
	S 	f_z [mm]			0,10 (0,05-0,30)				
	JMB17-76R04- 12,0x7,0x4,0 R0,4	Order- No.			B17D-MX08				
	S 	f_z [mm]			0,10 (0,05-0,30)				
	JMB17-76R06- 12,0x7,0x4,0 R0,6	Order- No.			B17D-NT08				
	S 	f_z [mm]			0,10 (0,05-0,30)				
			20	20	20				

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v_c [m/min]	Stahl Steel Acier Acciaio	Rostfrei Stainless Acier inoxydable Inossidabile	Guss Cast iron Fonte Ghisa	NE-Metalle Non-ferrous metals Non ferreux Metalli non ferrosi	Hochwarmfest Highly heat-resistant Superalliages Resistente al calore	Gehärtet Tempered Aciers traités Temprato
HC45	250 (200 - 350)	240 (140 - 300)	240 (130 - 280)			
HT45	250 (200 - 350)	240 (140 - 300)	240 (130 - 280)			
HT50	220 (160 - 300)	200 (100 - 300)	240 (200 - 300)			
HT32	250 (200 - 350)	240 (140 - 300)			60 (40 - 200)	
HT30		240 (140 - 300)			60 (40 - 200)	
HC30	160 (120-220)	200 (100 - 300)			60 (40 - 200)	
XC35	120 (60 - 160)	100 (60 - 180)			80 (40 - 200)	
HT20			260 (180 - 350)			80 (40 - 120)
KT28			260 (180 - 350)			80 (40 - 120)
K15M				400 (300 - 600)		

Ersatzteile Spare parts, Pièces de rechange, Parti di ricambio

	SS 2,5-7 (M = 1,2-1,3 Nm)		T 08+		Fett Grease, Graisse, Grasso
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B17 Rampingwinkel

Ramping angle type, Angle de ramping, Angolo rampa inserti

D	Ramping- winkel <i>Ramping angle type Angle de ramping Angolo rampa inserti</i> max. α (°)	Bearbeitungs- weg <i>Processing path Distance parcourue lunghezza di lavorazione</i> min. L (mm)	a_p max. $\phi/2$	ϕ WP <i>Insert Plaqueette Inserti</i>	WP <i>Insert Plaqueette Inserti</i>
20	7,9	13	3,00	7,00	JMB17 (FP 75, 75 R.., 75M, 275, 275 R.., 76, 76 R..)
22	6,8	15	3,00	7,00	
25	5,7	18	3,00	7,00	
28	4,9	21	3,00	7,00	
30	4,5	23	3,00	7,00	
32	4,1	25	3,00	7,00	
35	3,7	28	3,00	7,00	
36	3,6	29	3,00	7,00	
40	3,1	33	3,00	7,00	
50	2,4	43	3,00	7,00	
63	1,8	56	3,00	7,00	
80	1,4	73	3,00	7,00	
100	1,1	93	3,00	7,00	
125	0,9	118	3,00	7,00	

