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Modularni sistemi alata

Praktični saveti

Formule

Indeks

	P	M	K	N	S	H
2						
6						
8						
12						
22						
58	24	32	40	–	50	56
70	70	76	82	88	90	94
96						
106						
106	108	108	–	108	108	–
	110	110	110	–	110	–
	112	112	112	112	112	–
	114	114	114	114	114	114
	116	116	116	118	116	116
120	120	120	120	120	120	–
122						
132						
	134	134	134	134	134	–
	136	136	136	136	136	–
138						
140	145	145	145	169	148	145
	151	151	151	156	156	151
	163	163	163	166	166	163
	171	171	171	171	171	171
178						
179	182	182	182	182	182	182
	194	194	194	194	194	194
202						
204						
210						
213						



OVO JE COROKEY

LAK IZBOR - LAKA PRIMENA

1. Materijal obradka

ISO P	ČELIK Referentni materijal: Niskolegirani čelik, CMC02.1/ HB 180
ISO M	NERĐAJUĆI ČELIK Referentni materijal: Austenitni nerđajući čelik, CMC 05.21/HB 180
ISO K	SIVI LIV Referentni materijal: Sivi liv, CMC 08.2/HB 220 Nodularni liv, CMC 09.2/HB 250

ISO N	Aluminijumske legure Referentni materijal: Liveni, nežaren, CMC 30.21/HB 75
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ISO S	Vatrootporne legure Referentni materijal: Ni bazirane, CMC 20.22/ HB 350
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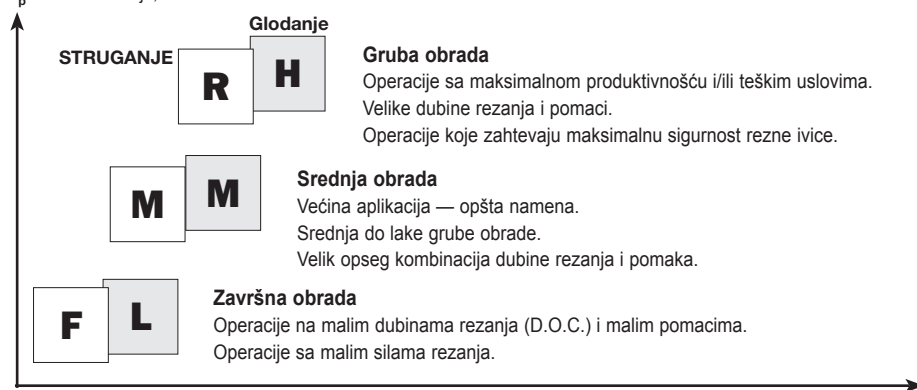
ISO H	KALJENI MATERIJALI Referentni materijal: Kaljeni čelik, CMC 04.1/ HRC 60
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Sandvik Coromant će postepeno uvoditi novu klasifikaciju materijala sa MC kodovima i zameniti postojeći CMC kodni sistem.

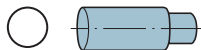
MC kodovi, sa daljim podgrupama će pružati određenije preporuke režima obrade u poređenju sa CMC klasifikacijama materijala.

2. VRSTA PRIMENE (STRUGANJE / GLODANJE)

a_p Dubina rezanja, mm

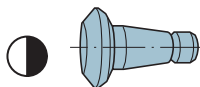


3. Uslovi obrade



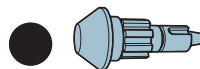
Dobri uslovi

Neprekidni rezovi. Velike brzine rezanja. Predobrađena površina. Odlično stezanje komponente. Mali prepusti.



Prosečni uslovi

Promenljiva dubina rezanja. Srednje brzine rezanja. Odlivak ili otkovak. Dobro stezanje komponente.



Teški uslovi

Prekinuti rezovi. Male brzine rezanja. Gruba kora na obradku. Slabo stezanje komponente.

OVO JE COROKEY

LAK IZBOR. LAKA PRIMENA.



4. REŽIMI OBRADJE

Preporučene startne vrednosti za brzinu rezanja i pomak, kao i opseg primene (max - min) su date na nalepnici svakog pakovanja pločice, što olakšava brz start obrade.



Materijal obradka
Vrsta obrade
Uslovi obrade

Pločice za struganje

Pločice za glodanje

a_p = Dubina rezanja (mm, inch)
f_n = Pomak (mm/r, inch/r)
v_c = Brzina rezanja (m/min feet/min)

f_z = Pomak/zubu (mm, inch)
v_c = Brzina rezanja (m/min stopa/min)





OVO JE COROKEY

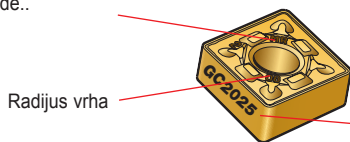
LAK IZBOR - LAKA PRIMENA

5. OZNAČAVANJE PLOČICA

Identitet pločice je trajno obeležen oznakom geometrije, kvaliteta, radijusa vrha i oznakom broja rezne ivice..

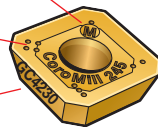
Označavanje geometrije: Materijal obradka i vrsta obrade..

Označavanje geometrije: vrsta obrade



Oznaka rezne ivice

Označavanje kvaliteta



6. NAMENSKI RAZVIJENI PROIZVODI

Namenski razvijene geometrije i kvaliteti tvrdog metala za određene materijale i uslove obrade.

Prvi izbor! →

ISO/ANSI P ČELIK		
Završna obrada	Srednja obrada	Gruba obrada
-WF / GC4215 -PF / GC4215	-WMX / GC4205 -PM / GC4215	WR / GC4205 -PR / GC4215
 -WF / GC4215 -PF / GC4215	 -WMX / GC4215 -PM / GC4225	 -WR / GC4215 -PR / GC4225 <small>Jednostrane pločice</small> <small>Dvostrane pločice</small> <small>Jednostrane pločice</small>
-WF / GC4225 -PF / GC4225	-WMX / GC4225 -PM / GC4235	-WR / GC4225 -PR / GC4235

USLOVI



Kako je popraviti?

Šta je produktivnost?

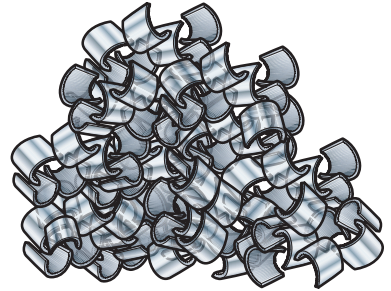
Produktivnost se može definisati na više načina, Sandvik Coromant je definiše kao odnos IZLAZA / ULAZ.

Uraditi više sa što manje ulaganja.

Na Izlaz utiče više faktora, kao što su:

- Izbor metode obrade i putanje alata
- Izbor alata, geometrije pločice i kvaliteta tvrdog metala
- Režim obrade (brzina, pomak i dubina rezanja)
- Manji broj škarta
- Manji broj zamena alata - manje zastoja
- Dostupnost proizvoda - manje zalihe alata u magacinu
- Tehnička obuka zaposlenih - bolje razumevanje procesa obrade

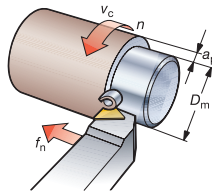
faktor je količina skinute strugotine „Q“, koja može biti merena kao količina skinutog materijala u datom vremenskom periodu (cm³/min).



Struganje:

Količina skinute strugotine
cm³/min

$$Q = v_c \times a_p \times f_n$$



a_e = širina glodanja (mm)

a_p = dubina rezanja (mm)

D_c = prečnik burgije (mm)

f_n = pomak (mm/obrtaju)

n = broj obrtaja vretena (obrtaja/min)

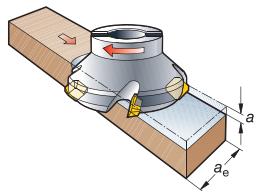
v_c = pomak stola (mm/obrtaju)

v_f = table feed (mm/obrtaju)

Glodanje:

Količina skinute strugotine
cm³/min

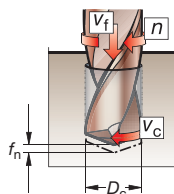
$$Q = \frac{a_p \times a_e \times v_f}{1000}$$

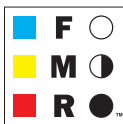


Bušenje:

Količina skinute strugotine
cm³/min

$$Q = \frac{v_c \times D_c \times f_n}{4}$$





Lista uporednih oznaka materijala

CMC ¹⁾	Velika Britanija		Švedska	SAD	Nemačka		Francuska	Italija	Španija	Japan
	Standard									
	BS	EN	SS	AISI/SAE	W.-nr.	DIN	AFNOR	UNI	UNE	JIS
ISO P 02.1	4360 43C		1412	A573-81	1.0144	S275J2G3	E 28-3	-	-	SM 400A;B;C
	4360 50B		2132	-	1.0570	S355J2G3+CP	E36-3	Fe52BFN/Fe52CFN	-	SM490A;B;C;YA;YB
	150 M 19		2172	5120	1.0841	S355J2G3	20 MC 5	Fe52	F-431	-
	250A53	45	2085	9255	1.5026	55Si7	55S7	55Si8	56Si7	-
	-	-	-	9262	1.0961	60SiCr7	60SC7	60SiCr8	60SiCr8	-
	534A99	31	2258	52100	1.3505	100Cr6	100C6	100Cr6	F.131	SUJ2
	1501-240	-	2912	ASTM A204Gr.A	1.5415	16Mo3	15D3	16Mo3KW	16Mo3	-
	1503-245-420	-	-	4520	1.5423	16Mo5	-	16Mo5	16Mo5	-
	-	-	-	ASTM A350LF5	1.5622	14Ni6	16N6	14Ni6	15N6	-
	805M20	362	2506	8620	1.6523	21NiCrMo2	20NCD2	20NiCrMo2	20NiCrMo2	SNMCM220(H)
	311-Type 7	-	-	8740	1.6546	40NiCrMo22	-	40NiCrMo2(KB)	40NiCrMo2	SNMCM240
	820A16	-	-	-	1.6587	17CrNiMo6	18NCD6	-	14NiCrMo13	-
	523M15	-	-	5015	1.7015	15Cr3	12C3	-	-	SCR415(H)
	-	-	2245	5140	1.7045	42Cr4	-	-	42Cr4	SCR440(H)
	527A60	48	-	5155	1.7176	55Cr3	55C3	-	-	SUP9(A)
	-	-	2216	-	1.7262	15CrMo5	12CD4	-	12CrMo4	SCM415(H)
	1501-620Gr27	-	-	ASTM A182 F11;F12	1.7335	13CrMo4-5	15CD3.5	14CrMo4 5	14CrMo45	-
	-	-	-	ASTM A182 F22	1.7380	10CrMo9 10	15CD4.5	-	-	-
	1501-622 Gr.31;45	-	2218	-	-	-	12CD9, 10	12CrMo9, 10	TU.H	-
	1503-660-440	-	-	-	1.7715	14MoV6 3	-	-	13MoCrV6	-
	722 M 24	-	2240	-	1.8515	31CrMo12	30 CD 12	30CrMo12	F-1712	-
	897M39	40C	-	-	1.8523	39CrMoV13 9	-	36CrMoV12	-	-
	524A14	-	2092	L1	1.7039	41CrS4	-	105WCR 5	-	-
	605A32	-	2108	8620	1.5419	22Mo4	-	-	F520.S	-
	-	-	-	-	1.7323	20MoCrMo16	-	-	-	-
	823M30	33	2512	-	1.7228	50CrMo4	-	653M31	-	-
	-	-	2127	-	1.2713	55NiCrMo16	-	-	-	-
	-	-	-	-	1.7139	16MnCrS5	-	-	-	-
	830 M 31	-	2534	-	1.5755	31NiCr14	-	-	-	-
	-	-	2550	L6	1.2721	50NiCr13	55NCV6	-	F-1270	-
	816M40	110	-	9840	1.6511	36CrNiMo4	40NCD3	38NiCrMo4(KB)	F-528	-
	817M40	24	2541	4340	1.6582	34CrNiMo6	35NCD6	35NiCrMo6(KB)	35NiCrMo4	-
	530A32	18B	-	5132	1.7033	34Cr4	32C4	34Cr4(KB)	35Cr4	SCR430(H)
	530A40	18	-	5140	1.7035	41Cr4	42C4	41Cr4	42Cr4	SCR440(H)
	(527M20)	-	2511	5115	1.7131	16MnCr5	16MC5	16MnCr5	16MnCr5	-
	1717CDS110	-	2225	4130	1.7218	25CrMo4	25CD4	25CrMo4(KB)	55Cr3	SCM420;SCM430
	708A37	19B	2234	4137;4135	1.7220	34CrMo4	35CD4	35CrMo4	34CrMo4	AM26CrMo4
	708M40	19A	2244	4140;4142	1.7223	41CrMo4	42CD4TS	41CrMo4	42CrMo4	SCM432;SCCRM3
	708M40	19A	2244	4140	1.7225	42CrMo4	42CD4	42CrMo4	42CrMo4	SCM 440
	722M24	40B	2240	-	1.7361	32CrMo12	30CD12	32CrMo12	42CrMo4	SCM440(H)
735A50	47	2230	6150	1.8159	51CrV4	50CV4	50CrV4	F.124.A	-	
905M39	41B	2940	-	1.8509	41CrAlMo7	40CAD6, 12	41CrAlMo7	41CrAlMo7	SUP10	
BL3	-	-	L3	1.2067	100Cr6	Y100C6	-	100Cr6	-	
-	-	2140	-	1.2419	105WCr6	105WC13	10WCr6	105WCr5	SKS31	
-	-	-	L6	1.2713	55NiCrMoV6	55NCDV7	107WCr5KU	-	SKS2, SKS3	
-	-	-	-	-	-	-	-	F.520.S	SKT4	

¹⁾ = Coromant-ova Klasifikacija Materijala (CMC)

Lista uporednih oznaka materijala



CMC ¹⁾	Velika Britanija		Švedska	SAD	Nemačka		Francuska	Italija	Španija	Japan
	Standard									
	BS	EN	SS	AISI/SAE	W.-nr.	DIN	AFNOR	UNI	UNE	JIS
ISO M 05.21	304S11	-	2352	304L	1.4306	X2CrNi 19-11	Z2CN18-10	X2CrNi18 11	-	-
	304S31	58E	2332/2333	304			Z6CN18.09	X5CrNi18 10	F.3551 F.3541 F.3504	SUS304
	303S21	58M	2346	303	1.4305	X8CrNiS 18-9	Z10CNF 18.09	X10CrNiS 18.09	F.3508	SUS303
	304S15	58E	2332	304	1.4301	X5CrNi 18-10	Z6CN18.09	X5CrNi18 10	F.3551	SUS304
	304C12	-	2333	-	-	-	Z3CN19.10	-	-	SUS304L
	304S12	-	2352	304L	1.4306	X2CrNi 18 9	Z2CrNi18 10	X2CrNi18 11	F.3503	SCS19
	-	-	2331	301	1.4310	X9CrNi 18-8	Z12CN17.07	X12CrNi17 07	F.3517	SUS301
	304S62	-	2371	304LN	1.4311	X2CrNiN 18 10	Z2CN18.10	-	-	SUS304LN
	316S16	58J	2347	316	1.4401	X5CrNiMo17-12-2	Z6CND17.11	X5CrNiMo17 12	F.3543	SUS316
	-	-	2375	316LN	1.4429	X2CrNiMoN 17-13-2	Z2CND17.13	-	-	SUS316LN
	316S13	-	2348	316L	1.4404	X2CrNiMo17-12-2	Z2CND17-12	X2CrNiMo1712	-	-
	316S13	-	2353	316L	1.4435	X2CrNiMo18-14-3	Z2CND17.12	X2CrNiMo17 12	-	SCS16
	316S33	-	2343 2347	316	1.4436	X4CrNiMo17-13-3	Z6CND18-12-03	X8CrNiMo1713	-	SUS316L
	321S12	58B	2337	V 0890A 321	1.4541	X6CrNiTi18-10	Z6CNT18.10	X6CrNiTi18 11	F.3553 F.3523	SUS321
	347S17	58F	2338	347	1.4550	X10CrNiNb 18 9	Z6CNNb18.10	X6CrNiNb18 11	F.3552 F.3524 F.3535	SUS347
	320S17	58J	2350	316Ti 318	1.4571 1.4583	X6CrNiMoTi 17-12-2 X10CrNiMoNb 18 12	Z6NDT17.12 Z6CNDNb17 13B	X6CrNiMoTi17 12 X6CrNiMoNb17 13	- -	- -
309S24	-	-	309	1.4828	X15CrNiSi 20 12	Z15CNS20.12	-	-	SUH309	
310S24	-	2361	310S	1.4845	X8CrNi 25-21	Z12CN25 20	X6CrNi25 20	F.331	SUH310	
301S21	58C	2370	308	1.4406	X2CrNiMoN 17-11-2	Z1NCDU25.20	-	F.8414	SCS17	
-	-	2387	-	1.4418	X4CrNiMo 16-5-1	Z6CND16-04-01	-	-	-	
K 08.2	Grade 300	-	0130	No 45 B	0.6030	EN-GJL-300	Ft 30 D	G 30	FG 30	FC300
	Grade 350	-	0135	No 50 B	0.6035	EN-GJL-350	Ft 35 D	G 35	FG 35	FC350
	Grade 400	-	0140	No 55 B	0.6040	EN-JL-Z	Ft 40 D	-	-	-
09.2	SNG 600/3	-	0732-03	-	0.7060	EN-GJS-600-3	FGS 600-3	-	-	FCD600
	SNG 700/2	-	0737-01	100-70-03	0.7070	EN-GJS-700-2	FGS 700-2	GS 700-2	FGS 70-2	FCD700
N 30.21	LM25	-	4244	356.1	-	-	-	-	-	A5052
	-	-	4247	A413.0	3.2582.05	GD-AISI12	-	-	-	A6061
	LM24	-	4250	A380.1	3.2162.05	GD-AISI8Cu3	-	-	-	A7075
	LM20	-	4260	A413.1	-	G-AISI12(Cu)	-	-	-	ADC12
	LM6	-	4261	A413.2	3.2982	AISI12Cu1	-	-	-	-
LM9	-	4253	A360.2	3-2382	AISI10MgFe	-	-	-	-	
S 20.22	-	-	-	5660	2.4662	Nimonic alloy 901	ZSNCDT42	-	-	-
	3146-3	-	-	5391	-	-	NC12AD	-	-	-
	HR8	-	-	5383	2.4668	Inconel 718	-	-	-	-
	3072-76	-	-	4676	2.4375	Monel alloy K-500	-	-	-	-
	Hr401,601	-	-	-	2.4631	Nimonic alloy 80A	NC20TA	-	-	-
	-	-	-	AMS 5399	2.4973	NiCr19Co11MoTi	NC19KDT	-	-	-
	-	-	-	AMS 5544	-	-	NC20K14	-	-	-
H 04.1	-	-	2258-08	440A	1.4108	X100CrMo13	-	-	-	C4BS
	-	-	2534-05	610	1.4111	X110CrMoV15	-	-	-	AC4A
	-	-	2541-06	0-2	-	X65CrMo14	-	-	-	AC4A
	-	-	-	-	1.1740	C60W	-	-	-	-
	-	-	-	-	1.2067	100Cr6	-	-	-	-
-	-	-	-	1.2419	10 5WCr6	-	-	-	-	



Opšte informacije

Tabela za konverziju za različite tvrdoće

U industriji se koristi mnogo različitih sistema merenja tvrdoće materijala. U tabeli ispod dato je poređenje tri najčešće korišćena sistema

CoroKey preporuke režima rezanja su date za tvrdoću po Brinellu (HB).

- HB 180 za čelik (CMC oznaka 02.1)
- HB 180 za Nerđajući čelik (CMC oznaka 05.21)
- HB 220 za Sivi liv (CMC oznaka 08.2)
- HB 250 za Nodularni liv (CMC oznaka 09.2)
- HB 75 za Aluminijum i neferitne materijale (CMC oznaka 30.21)
- HB 350 za Vatrotporne legure (CMC oznaka 20.22)
- HRC 60 za Kaljene materijale (CMC oznaka 04.1)

CMC = Coromant-ova Klasifikacija Materijala (CMC). Molimo, pogledajte uporedne oznake materijala na strani 6.

Zatezna čvrstoća	Tvrdoća po Vickersu	Tvrdoća po Brinellu	Tvrdoća po Rockwellu	
			HRC	HRB
N/mm ²	HV	HB		
255	80	76.0	–	–
270	85	80.7	–	41.0
285	90	85.5	–	48.0
305	95	90.2	–	52.0
320	100	95.0	–	56.2
350	110	105	–	62.3
385	120	114	–	66.7
415	130	124	–	71.2
450	140	133	–	75.0
480	150	143	–	78.7
510	160	152	–	81.7
545	170	162	–	85.0
575	180	171	–	87.5
610	190	181	–	89.5
640	200	190	–	91.5
660	205	195	–	92.5
675	210	199	–	93.5
690	215	204	–	94.0
705	220	209	–	95.0
720	225	214	–	96.0
740	230	219	–	96.7
770	240	228	20.3	98.1
800	250	238	22.2	99.5
820	255	242	23.1	–
835	260	247	24.0	(101)
850	265	252	24.8	–
865	270	257	25.6	(102)
900	280	266	27.1	–
930	290	276	28.5	(105)
950	295	280	29.2	–
965	300	285	29.8	–
995	310	295	31.0	–

Zatezna čvrstoća	Tvrdoća po Vickersu	Tvrdoća po Brinellu	Tvrdoća po Rockwellu
N/mm ²	HV	HB	HRC
1030	320	304	32.2
1060	330	314	33.3
1095	340	323	34.4
1125	350	333	35.5
1155	360	342	36.6
1190	370	352	37.7
1220	380	361	38.8
1255	390	371	39.8
1290	400	380	40.8
1320	410	390	41.8
1350	420	399	42.7
1385	430	409	43.6
1420	440	418	44.5
1485	460	437	46.1
1555	480	–	47.7
1595	490	–	48.4
1630	500	–	49.1
1665	510	–	49.8
1700	520	–	50.5
1740	530	–	51.1
1775	540	–	51.7
1810	550	–	52.3
1845	560	–	53.0
1880	570	–	53.6
1920	580	–	54.1
1955	590	–	54.7
1995	600	–	55.2
2030	610	–	55.7
2070	620	–	56.3
2105	630	–	56.8
2145	640	–	57.3
2180	650	–	57.8

Opšte informacije



Kompenzacija brzine rezanja usled razlike u tvrdoći, HB

Brzina rezanja sa stranica za izbor je data za preporučeni prvi izbor kvaliteta u kombinaciji sa tvrdoćom obradka (HB) iz tabele.

Ukoliko se tvrdoća obradka razlikuje od ovih vrednosti, preporučena brzina rezanja se množi sa faktorom datim u tabeli datoj ispod.

ISO/ ANSI	CMC ¹⁾	HB ²⁾	Smanjena tvrdoća					Povećana tvrdoća				
			-60 ³⁾	-40	-20	0	+20	+40	+60	+80	+100	
P	02.1	HB ²⁾ 180	1,44	1,25	1,11	1,0	0,91	0,84	0,77	0,72	0,67	
M	05.21	HB ²⁾ 180	1,42	1,24	1,11	1,0	0,91	0,84	0,78	0,73	0,68	
K	08.2	HB ²⁾ 220	1,21	1,13	1,06	1,0	0,95	0,90	0,86	0,82	0,79	
	09.2	HB ²⁾ 250	1,33	1,21	1,09	1,0	0,91	0,84	0,75	0,70	0,65	
N	30.21	HB ²⁾ 75			1,05	1,0	0,95					
S	20.22	HB ²⁾ 350			1,12	1,0	0,89					
H	04.1	HRC ³⁾ 60			1,07	1,0	0,97					

¹⁾ = Coromant-ova Klasifikacija Materijala (CMC)

²⁾ = Tvrdoća po Brinelu

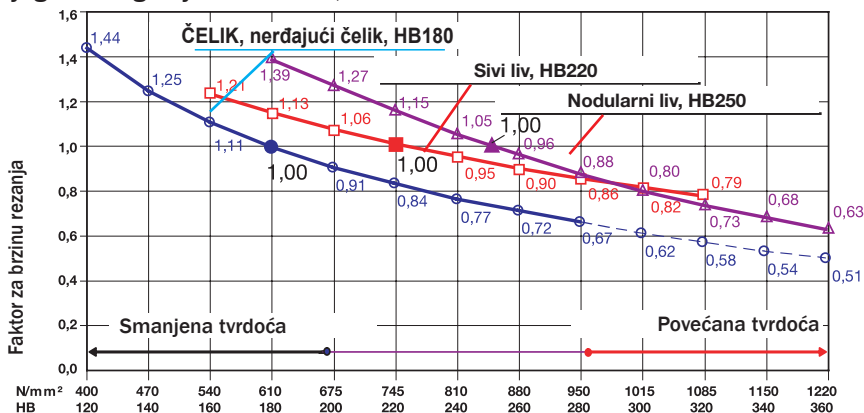
³⁾ = Tvrdoća po Rockvelu

Primer:

Ako izaberete pločicu CNMG 120416-PM za za vašu operaciju struganja, preporučeni režimi obrade po CoroKey priručniku za prvi izbor kvalitet GC4225 i obradu nisko legiranog čelika (CMC oznakom 02.1) sa tvrdoćom HB 180: Dubina rezanja (ap) = 3 mm
Pomak (fn) = 0,40 mm/rev
Brzina rezanja (vc) = 305 m/min.

Ukoliko vaš materijal obradka ima različitu tvrdoću, napr. HB 240, razlika između tvrdoće date u tabeli HB 180 i HB 240 je + 60. Faktor u tabeli je 0,77. Prilagođena brzina rezanja za HB 240 = 305 m/min x 0,77 = 234.85 m/min ≈ 235 m/min

Dijagram za gornje tabele za P, M i K



Zatezna čvrstoća/ tvrdoća



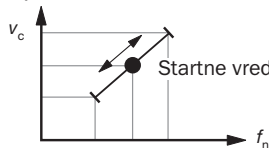
Opšte informacije

Tabela za pretvaranje Obimne Brzine (v_c) u Obrtaje u minuti (RPM)

Komponenti / glodalu \emptyset	Brzina rezanja (v_c), metara/min.										
	30	40	50	100	150	200	300	400	500	600	700
12	795	1060	1326	2652	3979	5305	7957	10610	13262		
16	597	795	995	1989	2984	3978	5968	7957	9947	11936	
20	477	637	796	1591	2387	3183	4774	6366	7957	9549	11140
25	382	509	637	1273	1910	2546	3819	5092	6366	7639	8912
32	298	398	497	994	1492	1989	2984	3978	4973	5968	6963
40	239	318	398	795	1194	1591	2387	3183	3978	4774	5570
50	191	255	318	636	955	1272	1909	2546	3183	3819	4456
63	151	202	253	505	758	1010	1515	2021	2526	3031	3536
80	119	159	199	397	597	795	1193	1591	1989	2387	2785
100	95	127	159	318	477	636	952	1273	1591	1909	2228
125	76	109	124	255	382	509	764	1018	1237	1527	1782
160	60	80	99	198	298	397	596	795	994	1193	1392
175	55	71	91	182	273	363	544	727	909	1091	1273
200	48	64	80	160	239	318	476	636	795	954	1114

Primer: Koristite glodalu prečnika 80 mm. Startna vrednost brzine rezanja (v_c) na kutiji je 200 m/min. Pronađite prečnik glodalca u levoj koloni, i brzinu rezanja u gornjem redu, a zatim očitajte vrednost za broj obrtaja vretena RPM u njihovom preseku: 795 obrtaja u minuti.

Opšte smernice:



Da bi zadržali lomljenje strugotine pri promeni režima rezanja, povećavajte/smanjujte v_c i f_n .

Formule

Brzina rezanja, m/min.

$$v_c = \frac{\pi \times D_c \times n}{1000}$$

v_c = brzina rezanja m/min
 n = broj obrtaja / min.
 D_c = prečnik mm

Broj obrtaja vretena, obrtaja u minuti

$$n = \frac{v_c \times 1000}{\pi \times D_c}$$

n = broj obrtaja vretena, broj obrtaja/min.
 v_c = brzina rezanja m/min
 D_c = prečnik mm

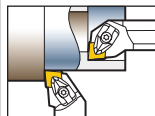
Pomak stola, mm/min.

$$v_f = n \times z \times f_z$$

v_f = pomak stola mm/min.
 n = broj obrtaja/min.
 z = broj zuba
 f_z = pomak mm/zubu



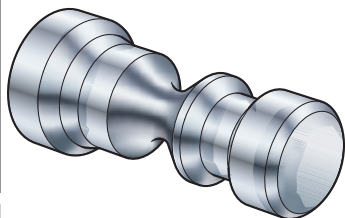
CoroTurn® RC



Alati za struganje

Kako izabrati alat za vašu operaciju

SPOLJAŠNJA OBRADA

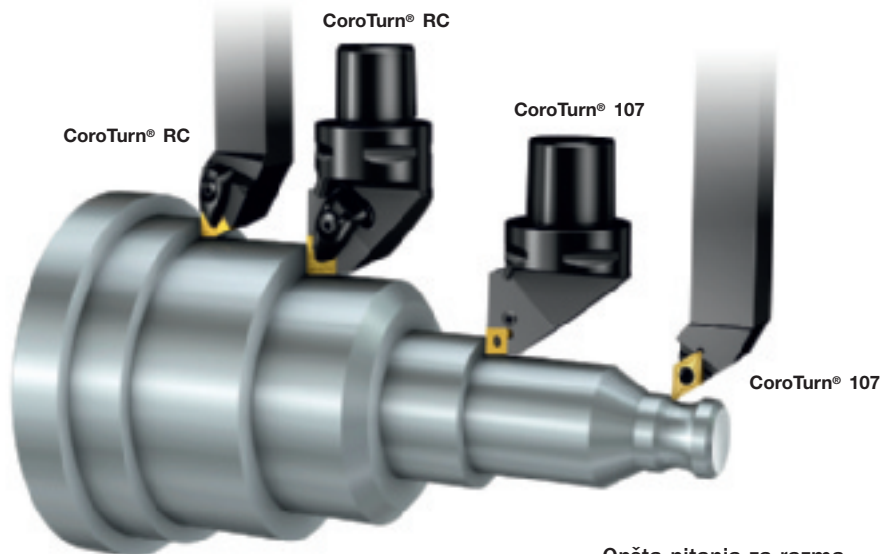


CoroTurn® RC

– Spoljašnja obrada, od grube do završne obrade

CoroTurn® 107

– Spoljašnja obrada malih, dugačkih i vitkih komponenti

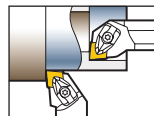


Opšta pitanja za razmatranje

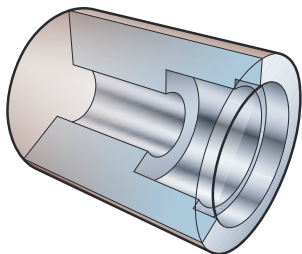
Koristiti napadni ugao manji od 90° ako je moguće da bi se smanjili udari i sile

Alati za struganje

Kako izabrati alat za vašu operaciju



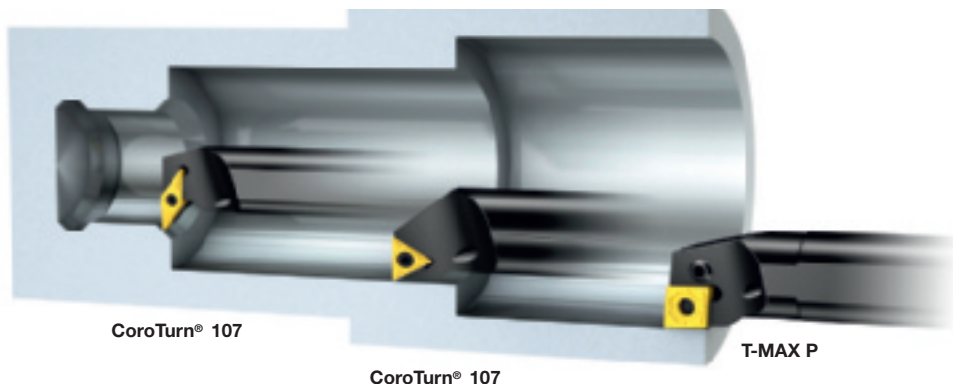
UNUTRAŠNJA OBRADA

**CoroTurn® 107**

- Prvi izbor za unutrašnju obradu malih i srednjih otvora i u slučajevima dugačkih prepusta

T-MAX P

- Unutrašnja obrada velikih otvora sa kratkim prepustima alata u stabilnim uslovima.



CoroTurn® 107

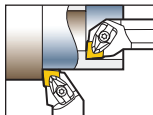
CoroTurn® 107

T-MAX P

Opšta pitanja za razmatranje

Koristiti napadni ugao manji od 90° ako je moguće da bi se smanjili udari i sile.

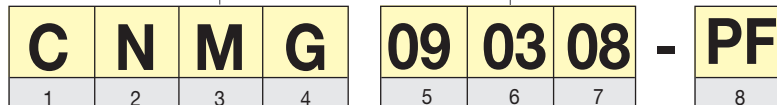
Korišćenje najvećih nosača i najmanjeg mogućeg prepusta za maksimalnu stabilnost.



Alati za struganje

Sistem označavanja za pločice i nosače alata
Izvod od ISO 1832—1991

PLOČICA



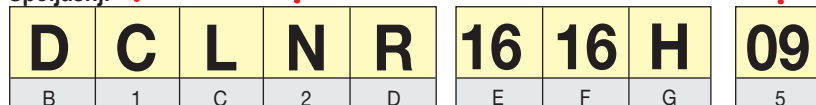
1. Oblik pločice

5. Veličina pločice = Dužina rezne ivice

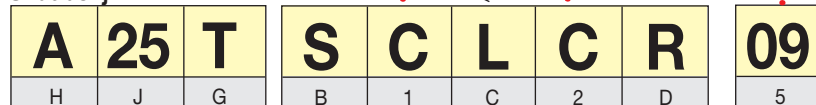
2. Leđni ugao pločice

NOSAČI ALATA

Spoljašnji


C3-
A

Unutrašnji



Prečnik nosača

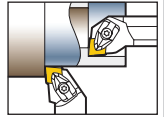
S = Nosač od punog čelika
A = Nosač sa otvorima za hlađenje

Tip nosača

Coromant Capto®
Veličina prihвата

Alati za struganje

Sistem označavanja za pločice i nosače alata
Izvod od ISO 1832—1991



1. OBLIK PLOČICE



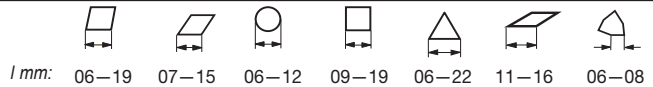
2. LEDNI UGAO PLOČICE



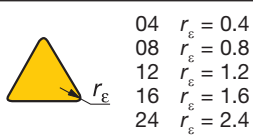
4. TIP PLOČICE



5. VELIČINA PLOČICE = DUŽINA REZNE IVICE



7. RADIJUS VRHA PLOČICE



Prvi izbor radijusa vrha pločice:

	T-MAX P	CoroTurn 107
ZAVRŠNA	08	04
SREDNJA	08	08
GRUBA OBRADA	12	08

8. OZNAKA GEOMETRIJE - OPCIJA PROIZVOĐAČA

Proizvođač može dodati dva simbola u kod opisujući geometriju pločice i sl.

-PF = ISO P Završna obrada

-MR = ISO M Gruba obrada

B. SISTEM STEZANJA



Rigid clamping (RC)



Stežanje odozgo i preko
otvora

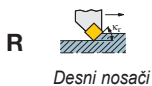


Stežanje preko otvora

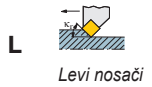


Stežanje vijkom

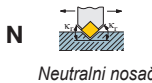
D. ORJENTACIJA ALATA



Desni nosači

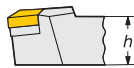


Levi nosači

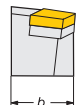


Neutralni nosači

E. VISINA NOSAČA

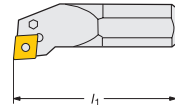


F. ŠIRINA ALATA

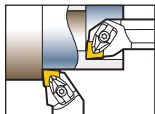


G. DUŽINA ALATA

Dužina alata =
l₁ in mm



H = 100	S = 250
K = 125	T = 300
M = 150	U = 350
P = 170	V = 400
Q = 180	W = 450
R = 200	Y = 500



Alati za struganje

T-MAX P negativni koncept za struganje

Čelik, Nerđajući čelik i Sivi liv — ISO P, M i K

Kako napraviti najbolji izbor za vašu operaciju struganjem

Sledeći dijagrami ilustruju preporučene kombinacije geometrija i kvaliteta

DOBRI USLOVI

Kontinualan rez. Velike brzine rezanja. Predobrađeni i materijali sa malom korom. Sigurno stezanje pripremk.

PROSEČNI USLOVI

Prvi izbor za operacije opšte namene
 Profilisanje ili lak prekidan rez. Umerene brzine rezanja. Kovani i liveni materijali. Dobro stezanje pripremk.

TEŠKI USLOVI

Prekidan rez ili veoma gruba obrada. Male brzine rezanja. Odlivci i otkivci sa korom. Slabo stezanje pripremk.

Prvi izbor!

Prvi izbor!

Prvi izbor!

ISO/ANSI P ČELIK		
Završna obrada	Srednja obrada	Gruba obrada
-WF / GC4215 -PF / GC4215	-WMX / GC4205 -PM / GC4015	-WR / GC4205 -PR / GC4215
-WF / GC4215	-WMX / GC4215	-WR / GC4215 <i>Jednostrane pločice</i>
-PF / GC4215	-PM / GC4225	-PR / GC4225 <i>Dvostrane pločice</i> <i>Jednostrane pločice</i>
-WF / GC4225 -PF / GC4225	-WMX / GC4225 -PM / GC4235	-WR / GC4225 -PR / GC4235



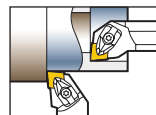
ISO/ANSI M NERĐAJUĆI ČELIK		
Završna obrada	Srednja obrada	Gruba obrada
-WF / GC2015 -MF / GC2015	-WMX / GC2015 -MM / GC2015	-MR / GC2025
-WF / GC2015	-WMX / GC2015	-MR / GC2025 <i>Dvostrane pločice</i> <i>Jednostrane pločice</i>
-MF / GC2015	-MM / GC2025	
-WF / GC2015 -MF / GC2025	-WMX / GC2015 -MM / GC2035	-MR / GC2025 -MR / GC2035



ISO/ANSI K SIVI LIV		
Završna obrada	Srednja obrada	Gruba obrada
-WF / GC3215 NGA / CC650	-WMX / GC3215 -NGA / CC6190	-KR / GC3205
-WF / GC3215	-WMX / GC3215	-KR / GC3205
-KF / GC3215	-KM / GC3205	
-WF / GC3215 -KF / GC3215	-WMX / GC3215 -KM / GC3215	-KR / GC3215



Wiper za visoku produktivnost i kvalitet obrađenje površine -WF i -WMX.



Alati za struganje

CoroTurn® 107 pozitivan koncept za struganje

Čelik, nerđajuči čelik i sivi liv — ISO P, M and K







Kako napraviti najbolji izbor za vašu operaciju struganjem

Sledeći dijagrami ilustruju preporučene kombinacije geometrija i kvaliteta

DOBRI USLOVI

Kontinualan rez. Velike brzine rezanja. Predobrađeni i materijali sa malom korom. Sigurno stezanje priprema.

Prvi izbor!







ISO/ANSI P ČELIK		
Završna obrada	Srednja obrada	Gruba obrada
-WF / GC4215 -PF / GC4215	-WM / GC4215 -PM / GC4215	-PR / GC4215
 -WF / GC4215	 -WM / GC4215	
 -PF / GC4215	 -PM / GC4225	 -PR / GC4225
-WF / GC4215 -PF / GC4225	-WM / GC4225 -PM / GC4235	-PR / GC4235



PROSEČNI USLOVI

Prvi izbor za operacije opšte namene
Profilisanje ili lak prekidan rez.
Umerene brzine rezanja. Kovani i liveni materijali. Dobro stezanje priprema.

Prvi izbor!







ISO/ANSI M NERĐAJUĆI ČELIK		
Završna obrada	Srednja obrada	Gruba obrada
-WF / GC2015 -MF / GC2015	-WM / GC2015 -MM / GC2015	-MR / GC2015
 -WF / GC2015	 -WM / GC2015	
 -MF / GC2015	 -MM / GC2025	 -MR / GC2025
-MF / GC2025	-MM / GC2035	-MR / GC2035



TEŠKI USLOVI

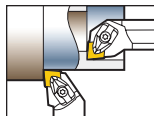
Prekidan rez ili veoma Gruba obrada. Male brzine rezanja. Odlivci i otkvici sa korom. Slabo stezanje priprema.

Prvi izbor!

ISO/ANSI K SIVI LIV		
Završna obrada	Srednja obrada	Gruba obrada
-WF / GC3215 -KF / GC3005	-WM / GC3215 -KM / GC3005	-KR / GC3210
 -WF / GC3215	 -WM / GC3215	
 -KF / GC3205	 -KM / GC3215	 -KR / GC3210
-WF / GC3215	-WM / GC3215 -KM / GC3215	-KR / GC3215



Wiper za visoku produktivnost i kvalitet obrađenje površine; geometrije -WF i -WM.



Alati za struganje

Kako je moguće unaprediti produktivnost?

Ako želite da promenite brzinu rezanja da bi ste postigli veću produktivnost, nove vrednosti brzine mogu se izračunati pomoću sledeće tabele

Postojanost alata (Mins.)	10	15	20	25	30	45	60
Korekzioni faktor	1,11	1,0	0,93	0,88	0,84	0,75	0,70

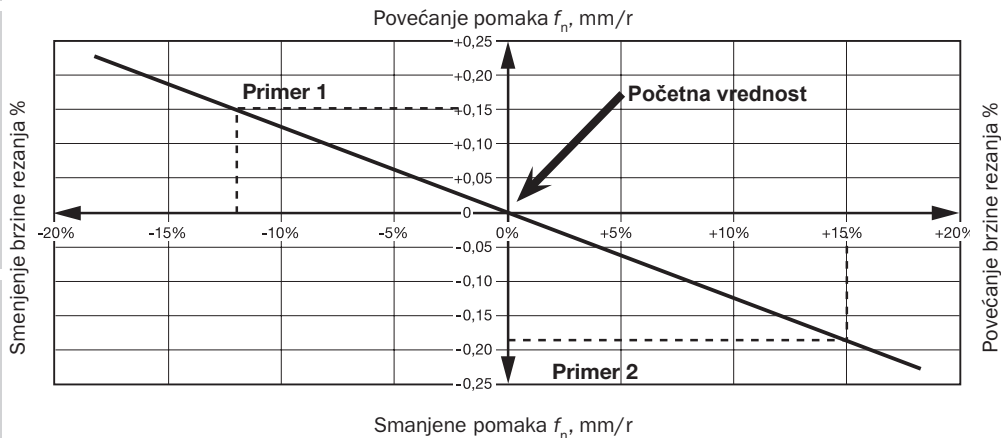
Primer: Ako je preporučena brzina rezanja (v_c) = 225 m/min. Postojanost alata od 10 minuta daje vam: $225 \times 1,11 \approx 250$ m/min

Napomena! Prilikom povećanja pomaka (f_n mm/r) brzina rezanja (v_c m/min) bi trebalo da se smanjuje i obrnuto, kao što je navedeno u preporukama.

	Pomak \rightarrow		
f_n	0,25	0,4	0,7
v_c	310	265	210

\leftarrow Brzina rezanja

Kompensacija brzine rezanja i pomaka kod struganja



Kako koristiti dijagram

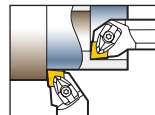
Ovaj dijagram pokazuje jednostavan metod za podešavanje brzine rezanja i preporuke za pomake. Režimi obrade preporučeni na kutiji su bazirani na postojanosti alata od 15 min. I ostaće isti sa vrednostima iz ovog dijagrama.

Primer 1: Povećanje pomaka za 0.15 mm/r (+0,15).
Rezultat: Smanjenje brzine rezanja za 12%.

Primer 2: Povećanje brzine rezanja za 15%.
Rezultat: Smanjenje pomaka za 0.18 mm/r.

Alati za struganje

Proračun potrebne snage



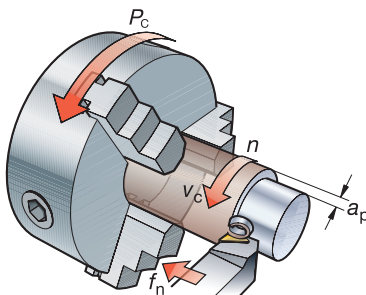
Približna snaga (kW) zahtevana M/C za 80% efikasnost

Srednja i gruba obrada				
		$a_p \times f_n$ (dubina rezanja x pomak)		
v_c		2 x 0.2	4 x 0.3	6 x 0.5
P	150	3.4	9.2	20.3
	200	4.5	12.3	27.1
	250	5.7	15.4	33.8
	300	6.8	18.5	40.6
	400	9.1	24.6	54.1
M	150	3.8	10.3	23.2
	200	5.0	13.8	31.0
	250	6.3	17.2	38.7
K	150	2.3/2.8	6.2/7.6	13.4/16.5
	200	3.1/3.8	8.3/10.15	17.9/21.9
	250	3.9/4.7	10.3/12.7	22.4/27.4
	300	4.6/5.7	12.4/15.2	26.8/32.9
N	500	4.0	10.9	23.9
	1000	8.0	21.7	47.8
	1500	12.0	32.6	71.6
	2000	16.0	43.4	95.5
S	20	0.8	2.1	
	45	1.7	4.7	
	90	3.5	9.4	
H	60	3.4	9.1	
	120	6.7	18.2	
	180	10.1	27.4	

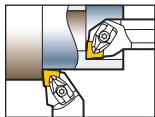
2.3 = sa lomačem strugotine

2.8 = bez lomača strugotine

Neto snaga (P_C) u KW potrebna za rezanje je predmet interesovanja pri gruboj obradi, kada je ključno zadovoljiti uslov da mašina poseduje dovoljno snage za zahtevanu operaciju. Pored toga, veoma je važan i stepen efikasnosti mašine.

 a_p = dubina rezanja (mm) v_c = brzina rezanja (m/min) f_n = pomak (mm/obrtaju) k_C = specifična sila rezanja (N/mm²) n = broj obrtaja vretena (ob/min) P_C = Neto snaga (KW)

$$P_C = \frac{v_c \times a_p \times f_n \times k_C}{60 \times 10^3} \text{ kW}$$



Alati za struganje

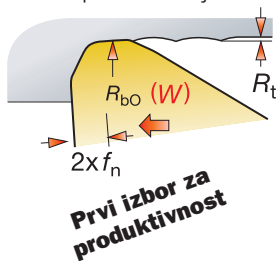
Uputstva za korišćenje Wiper pločica

Povećanje produktivnosti sa Wiper pločicama

Wiper pločice nove visoko produktivne pločice za srednje i fino struganje. Zahvaljujući maloj izmeni radijusa vrha pomak se može udvostručiti bez promene kvaliteta površine.

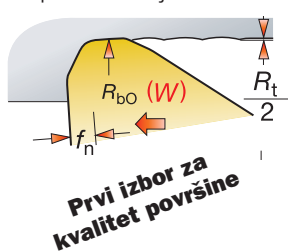
Wiper radijus

Dvostuki pomak rezanja

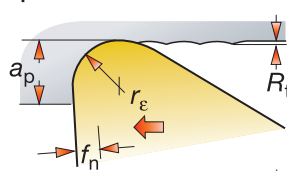


Wiper radijus

Isti pomak rezanja



Standardni radijus vrha pločice

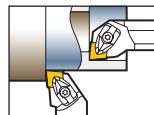


Poredjenje standardnih pločica sa wiper pločicama

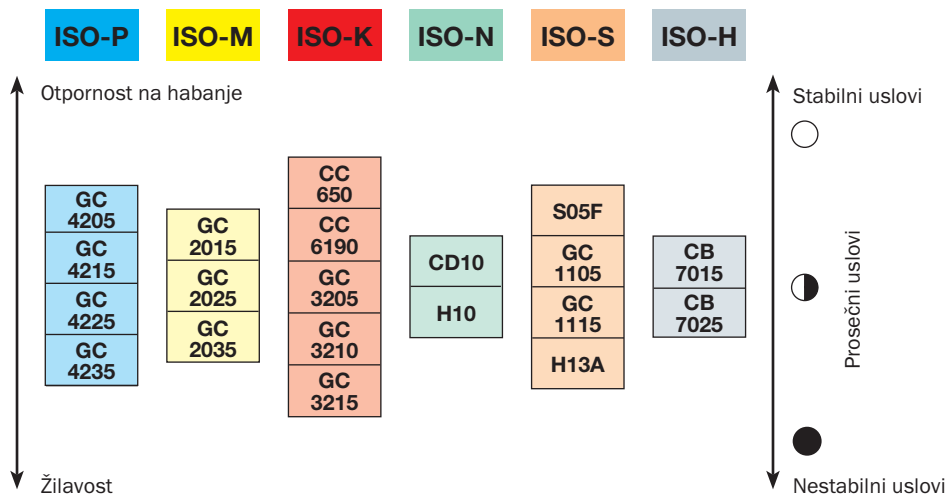
Pomak, f_n	Standardan radijus	Wiper (WF/WM)	Standardan radijus	Wiper (WMX)	Standardan radijus	Wiper (WMX)
mm/ob	r_ϵ 0.4 R_a μm	r_ϵ 0.4 R_a μm	r_ϵ 0.8 R_a μm	r_ϵ 0.8 R_a μm	r_ϵ 1.2 R_a μm	r_ϵ 1.2 R_a μm
0.07	0.31	0.30	–	–	–	–
0.10	0.63	0.32	0.31	–	–	–
0.12	0.90	0.45	0.45	–	–	–
0.15	1.41	0.70	0.70	0.25	0.47	–
0.18	2.03	1.00	1.01	0.30	0.68	–
0.20	2.50	1.25	1.25	0.35	0.83	0.30
0.22	3.48	1.74	1.74	0.40	1.16	0.30
0.25	–	–	2.25	0.45	1.50	0.40
0.28	–	–	2.82	0.50	1.88	0.40
0.30	–	–	3.23	0.55	2.16	0.40
0.35	–	–	4.40	0.60	2.93	0.50
0.40	–	–	5.75	0.70	3.83	0.65
0.45	–	–	8.54	1.10	5.70	0.85
0.50	–	–	10.55	1.30	7.03	1.15
0.55	–	–	–	–	8.51	1.20
0.60	–	–	–	–	10.13	1.30

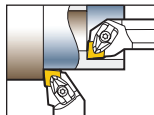
Alati za struganje

Kvaliteti za struganje



Pregled kvaliteta



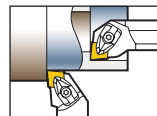


Alati za struganje

Kako izabrati pločicu i držač

Definisanje materijala	Negativne T-MAX P pločice Idi na stranu za pločice i izaberi geometriju, kvalitet i režime obrade.	Pozitivne pločice CoroTurn 107 pločice Idi na stranu za pločice i izaberi geometriju, kvalitet i režime obrade.	Nosaci alata Idi na stranu za nosače. Izaberi tip i veličinu nosača																		
P	<table border="1"> <tr> <td>Završna obrada</td> <td>Srednja obrada</td> <td>Gruba obrada</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> <tr> <td>Strana 24</td> <td>Strana 26</td> <td>Strana 28 30</td> </tr> </table>	Završna obrada	Srednja obrada	Gruba obrada				Strana 24	Strana 26	Strana 28 30	<table border="1"> <tr> <td>Završna obrada</td> <td>Srednja obrada</td> <td>Gruba obrada</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> <tr> <td>Strana 70</td> <td>Strana 72</td> <td>Strana 74</td> </tr> </table>	Završna obrada	Srednja obrada	Gruba obrada				Strana 70	Strana 72	Strana 74	<p>Spoljašnja obrada</p> <p>Nosači za negativne pločice</p> <p> Držači sa prizmatičnom drškom Strana 58–62</p> <p> Coromant Capto Strana 59–63</p>
Završna obrada	Srednja obrada	Gruba obrada																			
Strana 24	Strana 26	Strana 28 30																			
Završna obrada	Srednja obrada	Gruba obrada																			
Strana 70	Strana 72	Strana 74																			
M	<table border="1"> <tr> <td>Završna obrada</td> <td>Srednja obrada</td> <td>Gruba obrada</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> <tr> <td>Strana 32</td> <td>Strana 34</td> <td>Strana 36 38</td> </tr> </table>	Završna obrada	Srednja obrada	Gruba obrada				Strana 32	Strana 34	Strana 36 38	<table border="1"> <tr> <td>Završna obrada</td> <td>Srednja obrada</td> <td>Gruba obrada</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> <tr> <td>Strana 76</td> <td>Strana 78</td> <td>Strana 80</td> </tr> </table>	Završna obrada	Srednja obrada	Gruba obrada				Strana 76	Strana 78	Strana 80	<p>Nosači za pozitivne pločice</p> <p> Držači sa prizmatičnom drškom Strana 96–100</p> <p> Coromant Capto Strana 97–101</p>
Završna obrada	Srednja obrada	Gruba obrada																			
Strana 32	Strana 34	Strana 36 38																			
Završna obrada	Srednja obrada	Gruba obrada																			
Strana 76	Strana 78	Strana 80																			
K	<table border="1"> <tr> <td>Završna obrada</td> <td>Srednja obrada</td> <td>Gruba obrada</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> <tr> <td>Strana 40</td> <td>Strana 42 44</td> <td>Strana 46 48</td> </tr> </table>	Završna obrada	Srednja obrada	Gruba obrada				Strana 40	Strana 42 44	Strana 46 48	<table border="1"> <tr> <td>Završna obrada</td> <td>Srednja obrada</td> <td>Gruba obrada</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> <tr> <td>Strana 82</td> <td>Strana 84</td> <td>Strana 86</td> </tr> </table>	Završna obrada	Srednja obrada	Gruba obrada				Strana 82	Strana 84	Strana 86	<p>Unutrašnja obrada</p> <p>Nosači za pozitivne pločice</p> <p> Držači sa prizmatičnom drškom Strana 102–104</p> <p> Coromant Capto Strane 103–105</p>
Završna obrada	Srednja obrada	Gruba obrada																			
Strana 40	Strana 42 44	Strana 46 48																			
Završna obrada	Srednja obrada	Gruba obrada																			
Strana 82	Strana 84	Strana 86																			
N		<table border="1"> <tr> <td>Srednja obrada</td> </tr> <tr> <td></td> </tr> <tr> <td>Strana 88</td> </tr> </table>	Srednja obrada		Strana 88	<p>Nosači za negativne pločice</p> <p> Držači sa prizmatičnom drškom Strane 65–68</p> <p> Coromant Capto Strane 64–66</p>															
Srednja obrada																					
Strana 88																					
S	<table border="1"> <tr> <td>Završna obrada</td> <td>Srednja obrada</td> <td>Gruba obrada</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> <tr> <td>Strana 50</td> <td>Strana 52</td> <td>Strana 54</td> </tr> </table>	Završna obrada	Srednja obrada	Gruba obrada				Strana 50	Strana 52	Strana 54	<table border="1"> <tr> <td>Završna obrada</td> <td>Srednja obrada</td> </tr> <tr> <td></td> <td></td> </tr> <tr> <td>Strana 90</td> <td>Strana 92</td> </tr> </table>	Završna obrada	Srednja obrada			Strana 90	Strana 92	<p>Nosači za negativne pločice</p> <p> Držači sa prizmatičnom drškom Strane 65–68</p> <p> Coromant Capto Strane 64–66</p>			
Završna obrada	Srednja obrada	Gruba obrada																			
Strana 50	Strana 52	Strana 54																			
Završna obrada	Srednja obrada																				
Strana 90	Strana 92																				
H	<table border="1"> <tr> <td>Završna obrada</td> </tr> <tr> <td></td> </tr> <tr> <td>Strana 56</td> </tr> </table>	Završna obrada		Strana 56	<table border="1"> <tr> <td>Završna obrada</td> </tr> <tr> <td></td> </tr> <tr> <td>Strana 94</td> </tr> </table>	Završna obrada		Strana 94	<p>Nosači za negativne pločice</p> <p> Držači sa prizmatičnom drškom Strane 65–68</p> <p> Coromant Capto Strane 64–66</p>												
Završna obrada																					
Strana 56																					
Završna obrada																					
Strana 94																					


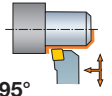

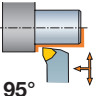

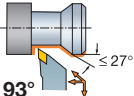

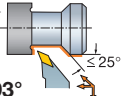

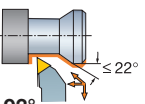

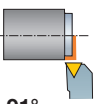

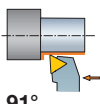

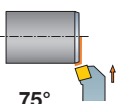

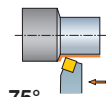

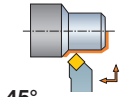
Alati za struganje




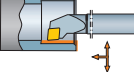

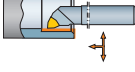

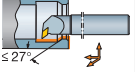

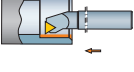

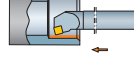
Struganje sa T-Max P i CoroTurn® 107 pločicama

SPOLJAŠNJA OBRADA (Strane 58 - 63)

CoroTurn® RC




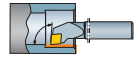

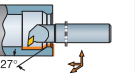

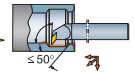

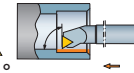

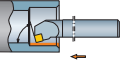
C   95°	W   95°	D   93° $\leq 27^\circ$	V   93° $\leq 25^\circ$
T   93° $\leq 22^\circ$	T   91°	T   91°	S   75°
S   75°	S   45°		

UNUTRAŠNJA OBRADA (Strane 64 - 69)


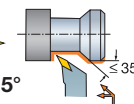

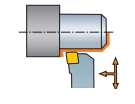

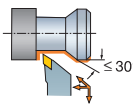

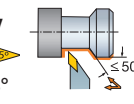

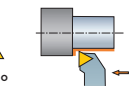

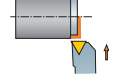

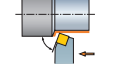

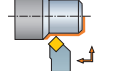

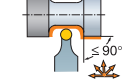


C   95°	W   95°	D   93° $\leq 27^\circ$	T   91°	S   75°
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UNUTRAŠNJA OBRADA (Strane 102 - 105)

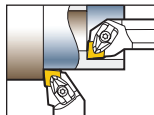
CoroTurn 107
Stezanje vijkom

V   107,5° $\leq 35^\circ$	C   95°	D   93° $\leq 27^\circ$	V   93° $\leq 50^\circ$	T   91°
S   75°				

SPOLJAŠNJA OBRADA (Strane 96 - 101)

V   107,5° $\leq 35^\circ$	C   95°	D   93° $\leq 30^\circ$	V   93° $\leq 50^\circ$	T   91°
T   91°	S   75°	S   45°	R   $\leq 90^\circ$	R   $\leq 27^\circ$

Oblik pločice: C = 80° romboidna, D = 55° romboidna, R = Okrugla, S = kvadratna,
T = trouglasta, V = 35° romboidna, W = trigon



ZAVRŠNA OBRADA ČELIKA

Nisko legirani čelik, HB 180

ISO/
ANSI

P

F

T-MAX P

Dvostrane
pločice

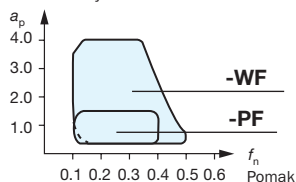
CNMG 12 04 08-WF

 $a_p = 0.25 - 4.0$ mm $f_n = 0.1 - 0.5$ mm/obr

CNMG 12 04 08-PF

 $a_p = 0.3 - 1.5$ mm $f_n = 0.1 - 0.4$ mm/obr

Dubina rezanja



WF – za produktivno završno struganje

Operacije: Uzdužno i čeono struganje

Komponente: stabilna vratila, osovine, zupčanci i sl.

Prednosti: Dvostruki pomak sa istim kvalitetom površine ili duplo bolja površina sa istim pomakom.

-PF

Operacije: uzdužno struganje, čeono, struganje unazad i profilisanje

Komponente: vratila, zupčanci gde je dobar kvalitet površine prioritet

Prednosti: pozitivna rezna geometrija, male sile rezanja pogodno za vitka vratila, tankozidne i slabo stegnute pripreme

DOBRI USLOVI OBRADJE



- Kontinualan rez.
- Predobrađeni ili sa malom korom.

VELIKI POMAK



-WF / GC4215

NORMALAN POMAK



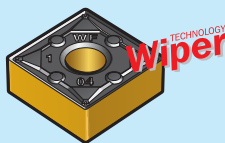
-PF / GC4215

Prvi izbor

PROSEČNI USLOVI OBRADJE

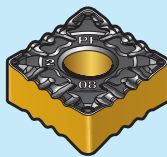
Operacije opšte
namene.

VELIKI POMAK



-WF / GC4215

NORMALAN POMAK



-PF / GC4215

TEŠKI USLOVI OBRADJE



- Prekidan rez.
- Pripremak sa teškom korom.

VELIKI POMAK



-WF / GC4225

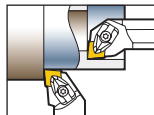
NORMALAN POMAK



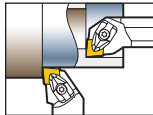
-PF / GC4225

ISO/
ANSI**P F****ZAVRŠNA OBRADA ČELIKA**

Negativne pločice



KATALOŠKA OZNAKA						REŽIMI OBRADJE, CMC 02.1 / HB 180		Brzina rezanja v_c (m/min)	
Dvostrane pločice r_c			GC4215	GC4215	GC4225	Dubina rezanja a_p mm	Pomak f_n mm/obr	GC4215	GC4225
	CNMG	09 03 04-WF	☆	★		0.5 (0.3-1.5)	0.15 (0.05-0.25)	515	
		09 03 08-WF	☆	★	☆	1 (0.3-2)	0.3 (0.1-0.5)	415	345
		12 04 04-WF	☆	★	☆	0.4 (0.25-3)	0.15 (0.05-0.25)	515	425
		12 04 08-WF	☆	★	☆	1 (0.25-4)	0.3 (0.1-0.5)	415	345
		12 04 12-WF	☆	★	☆	1.5 (0.4-4)	0.5 (0.2-0.6)	335	275
	DNMX	11 04 04-WF	☆	★	☆	1 (0.2-1.5)	0.2 (0.08-0.3)	475	395
		11 04 08-WF	☆	★	☆	1 (0.2-3)	0.3 (0.1-0.4)	415	345
		15 06 04-WF	☆	★		0.8 (0.2-3)	0.2 (0.08-0.3)	475	
		15 06 08-WF	☆	★	☆	1.5 (0.2-3)	0.3 (0.1-0.4)	415	345
		15 06 12-WF	☆	★	☆	1.5 (0.4-3.5)	0.4 (0.15-0.55)	370	305
	TNMX	16 04 04-WF	☆	★	☆	1 (0.2-3)	0.2 (0.08-0.3)	475	395
		16 04 08-WF	☆	★	☆	1.5 (0.2-3)	0.3 (0.1-0.4)	415	345
	WNMG	06 04 04-WF	☆	★	☆	0.4 (0.25-2)	0.15 (0.05-0.25)	515	425
		06 04 08-WF	☆	★	☆	1 (0.25-3)	0.3 (0.1-0.5)	415	345
		08 04 04-WF	☆	★	☆	0.4 (0.25-3)	0.15 (0.05-0.25)	515	425
		08 04 08-WF	☆	★	☆	1 (0.25-4)	0.3 (0.1-0.5)	415	345
		08 04 12-WF	☆	★	☆	1.5 (0.4-4)	0.5 (0.2-0.6)	335	275
	CNMG	09 03 04-PF	☆	★	☆	0.4 (0.25-1.5)	0.15 (0.07-0.3)	515	425
		09 03 08-PF	☆	★	☆	0.4 (0.3-1.5)	0.15 (0.1-0.3)	515	425
		12 04 04-PF	☆	★	☆	0.4 (0.25-1.5)	0.15 (0.07-0.3)	515	425
		12 04 08-PF	☆	★	☆	0.4 (0.3-1.5)	0.2 (0.1-0.4)	475	395
		12 04 12-PF	☆	★	☆	0.8 (0.35-1.5)	0.25 (0.15-0.5)	445	365
	DNMG	11 04 04-PF	☆	★	☆	0.4 (0.25-1.5)	0.15 (0.07-0.3)	515	425
		11 04 08-PF	☆	★	☆	0.4 (0.3-1.5)	0.2 (0.1-0.4)	475	395
		11 04 12-PF	☆	★	☆	0.8 (0.35-1.5)	0.25 (0.15-0.5)	445	365
		15 04 04-PF	☆	★	☆	0.4 (0.25-1.5)	0.15 (0.07-0.3)	515	425
		15 04 08-PF	☆	★	☆	0.4 (0.3-1.5)	0.2 (0.1-0.4)	475	395
		15 04 12-PF	☆	★	☆	0.8 (0.35-1.5)	0.25 (0.15-0.5)	445	365
		15 06 04-PF	☆	★	☆	0.4 (0.25-1.5)	0.15 (0.07-0.3)	515	425
15 06 08-PF	☆	★	☆	0.4 (0.3-1.5)	0.2 (0.1-0.4)	475	395		
15 06 12-PF	☆	★	☆	0.8 (0.35-1.5)	0.25 (0.15-0.5)	445	365		
	SNMG	12 04 08-PF	☆	★	☆	0.4 (0.3-1.5)	0.2 (0.1-0.4)	475	395
		12 04 12-PF	☆	★	☆	0.8 (0.35-1.5)	0.25 (0.15-0.5)	445	365
	TNMG	16 04 04-PF	☆	★	☆	0.4 (0.35-1.5)	0.15 (0.07-0.3)	515	425
		16 04 08-PF	☆	★	☆	0.4 (0.3-1.5)	0.2 (0.1-0.4)	475	395
		16 04 12-PF	☆	★	☆	0.8 (0.35-1.5)	0.25 (0.15-0.5)	445	365
		22 04 08-PF	☆	★	☆	0.4 (0.3-1.5)	0.2 (0.1-0.4)	475	395
22 04 12-PF	☆	★	☆	0.8 (0.35-1.5)	0.25 (0.15-0.5)	445	365		
	VNMG	16 04 04-PF	☆	★	☆	0.4 (0.25-1.5)	0.15 (0.07-0.3)	515	425
		16 04 08-PF	☆	★	☆	0.4 (0.3-1.5)	0.2 (0.1-0.4)	475	395
	WNMG	06 04 04-PF	☆	★	☆	0.4 (0.25-1.5)	0.15 (0.07-0.3)	515	425
		06 04 08-PF	☆	★	☆	0.4 (0.3-1.5)	0.2 (0.1-0.4)	475	395
		06 04 12-PF	☆	★	☆	0.8 (0.4-1.5)	0.25 (0.15-0.5)	445	
		08 04 04-PF	☆	★	☆	0.4 (0.25-1.5)	0.15 (0.07-0.3)	515	425
		08 04 08-PF	☆	★	☆	0.4 (0.3-1.5)	0.2 (0.1-0.4)	475	395
08 04 12-PF	☆	★	☆	0.8 (0.4-1.5)	0.25 (0.15-0.5)	445	365		



SREDNJA OBRADA ČELIKA

Nisko legirani čelik, HB 180

ISO/
ANSI

P M

T-MAX P

Dvostrane pločice

CNMG 12 04 08-WMX

$a_p = 0.5 - 5.0$ mm

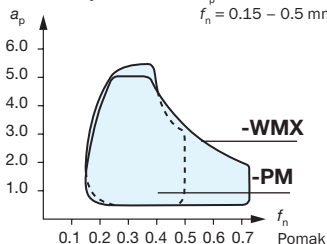
$f_n = 0.15 - 0.6$ mm/obr

CNMG 12 04 08-PM

$a_p = 0.5 - 5.5$ mm

$f_n = 0.15 - 0.5$ mm/obr

Dubina rezanja



WMX – za produktivnu srednju obradu struganjem

Operacije: Uzdužno i čeoно struganje

Komponente: krute osovine, vratila, spojnice, zupčаниci i sl.

Prednosti: Utrostručite konvencionalne pomake sa poboljšanim kvalitetom završne obrade. Idealan kada je kvalitet obradjene površine prioritet. Može da zameni i operaciju brušenja. Poboljšano je i lomljenje strugotine usled većih pomaka.

Poboljšан vek alata (komponenti/ivici) usled kraćeg vremena provedenog u zahvatu

-PM

Operacije: uzdužno i čeoно struganje, profilisanje

Komponente: osovine, zupčаниci i sl. od čelika

Prednosti: univerzalna, pouzdana obrada bez problema

DOBRI USLOVI OBRADJE



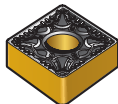
- Kontinualan rez.
- Predobrađeni ili sa malom korom.

VELIKI POMAK



-WMX / GC4205

NORMALAN POMAK



-PM / GC4215

Prvi izbor

PROSEČNI USLOVI OBRADJE



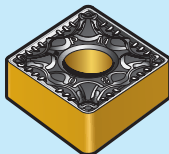
Operacije opšte namene.

VELIKI POMAK



-WMX / GC4215

NORMALAN POMAK



-PM / GC4225

TEŠKI USLOVI OBRADJE



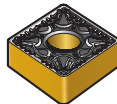
- Prekidan rez.
- Pripremak sa teškom korom.

VELIKI POMAK



-WMX / GC4225

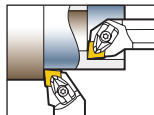
NORMALAN POMAK














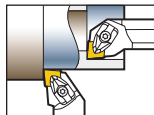
-PM / GC4235

ISO/
ANSI**P M****SREDNJA OBRADA ČELIKA**

Negativne pločice



Dvostrane pločice		 r_e	REŽIMI OBRADE, CMC 02.1 / HB 180						Brzina rezanja v_c (m/min)				
			GC4205	GC4215	GC4215	GC4225	GC4225	GC4235	Dubina rezanja a_p mm	Pomak f_n mm/obr	GC4205	GC4215	GC4225
	CNMG	12 04 08-WMX	☆		★		☆	3 (0.5-5)	0.45 (0.15-0.7)	390	350	290	
		12 04 12-WMX			★		☆	3.5 (0.8-6)	0.5 (0.2-0.75)	370	335	275	
		16 06 08-WMX	☆		★		☆	3 (0.5-5)	0.45 (0.15-0.7)	390	350	290	
		16 06 12-WMX	☆		★		☆	3.5 (0.8-6)	0.5 (0.2-0.75)	370	335	275	
	DNMX	15 06 08-WMX	☆		★		3 (0.5-5)	0.45 (0.15-0.7)	390	350	290		
		15 06 12-WMX	☆		★		3.5 (0.8-6)	0.5 (0.2-0.75)	370	335	275		
		15 06 16-WMX	☆		★		3.5 (0.5-6)	0.5 (0.2-0.8)	370	335	275		
	TNMX	16 04 08-WMX	☆		★		3 (0.5-5)	0.45 (0.15-0.7)	390	350	290		
		16 04 12-WMX	☆		★		3.5 (0.8-6)	0.5 (0.2-0.75)	370	335	275		
	WNMG	06 04 08-WMX	☆		★		3 (0.5-5)	0.45 (0.15-0.7)	390	350	290		
		06 04 12-WMX	☆		★		3.5 (0.8-6)	0.5 (0.2-0.75)	370	335	275		
		08 04 08-WMX	☆		★		3 (0.5-5)	0.45 (0.15-0.7)	390	350	290		
		08 04 12-WMX	☆		★		3.5 (0.8-6)	0.5 (0.2-0.75)	370	335	275		
	CNMG	09 03 04-PM		☆		★	☆	2 (0.4-4)	0.2 (0.1-0.3)		475	395	240
		09 03 08-PM		☆		★	☆	2 (0.5-4)	0.3 (0.15-0.5)		415	345	210
		12 04 04-PM		☆		★	☆	3 (0.4-5.5)	0.2 (0.1-0.3)		475	395	240
		12 04 08-PM		☆		★	☆	3 (0.5-5.5)	0.3 (0.15-0.5)		415	345	210
		12 04 12-PM		☆		★	☆	3 (0.8-5.5)	0.35 (0.18-0.6)		390	325	195
		12 04 16-PM		☆		★	☆	3 (1-5.5)	0.4 (0.23-0.65)		370	305	185
		16 06 08-PM		☆		★	☆	4 (0.5-7.2)	0.3 (0.15-0.5)		415	345	210
		16 06 12-PM		☆		★	☆	4 (0.8-7.2)	0.35 (0.18-0.6)		390	325	195
		16 06 16-PM		☆		★	☆	4 (1-7.2)	0.4 (0.23-0.65)		370	305	185
	DNMG	11 04 04-PM		☆		★	☆	2 (0.4-5)	0.2 (0.1-0.3)		475	395	240
		11 04 08-PM		☆		★	☆	2 (0.5-5)	0.3 (0.15-0.5)		415	345	210
		11 04 12-PM		☆		★	☆	2 (0.8-5)	0.35 (0.18-0.5)		390	325	195
		15 06 04-PM		☆		★	☆	3 (0.4-6)	0.2 (0.1-0.3)		475	395	240
		15 06 08-PM		☆		★	☆	3 (0.5-6)	0.3 (0.15-0.5)		415	345	210
		15 06 12-PM		☆		★	☆	3 (0.8-6)	0.35 (0.18-0.6)		390	325	195
		15 06 16-PM		☆		★	☆	3 (1-6)	0.4 (0.23-0.65)		370	305	185
	SNMG	09 03 04-PM		☆		★	☆	2 (0.4-4.5)	0.2 (0.1-0.3)		475	395	240
		09 03 08-PM		☆		★	☆	2 (0.5-4.5)	0.3 (0.15-0.5)		415	345	210
		12 04 04-PM		☆		★	☆	3 (0.4-6)	0.2 (0.1-0.3)		475	395	240
		12 04 08-PM		☆		★	☆	3 (0.5-6)	0.3 (0.15-0.5)		415	345	210
		12 04 12-PM		☆		★	☆	3 (0.8-6)	0.35 (0.18-0.6)		390	325	195
		12 04 16-PM		☆		★	☆	3 (1-6)	0.4 (0.23-0.65)		370	305	185
		15 06 12-PM		☆		★	☆	4 (0.8-7.5)	0.35 (0.18-0.6)		390	325	195
		15 06 16-PM		☆		★	☆	4 (1-7.5)	0.4 (0.23-0.65)		370	305	185
			TNMG	16 04 04-PM		☆		★	☆	3 (0.4-5)	0.2 (0.1-0.3)		470
16 04 08-PM				☆		★	☆	3 (0.5-5)	0.3 (0.15-0.5)		415	345	210
16 04 12-PM				☆		★	☆	3 (0.8-5)	0.35 (0.18-0.6)		390	325	195
22 04 04-PM				☆		★	☆	4 (0.4-6.6)	0.2 (0.1-0.3)		475	395	240
22 04 08-PM				☆		★	☆	4 (0.5-6.6)	0.3 (0.15-0.5)		415	345	210
22 04 12-PM				☆		★	☆	4 (0.8-6.6)	0.35 (0.18-0.6)		390	325	195
22 04 16-PM				☆		★	☆	4 (1-6.6)	0.4 (0.23-0.65)		370	305	185
	VNMG	16 04 08-PM		☆		★	☆	2 (0.5-4)	0.3 (0.15-0.5)		415	345	210
		16 04 12-PM		☆		★	☆	2 (0.8-4)	0.35 (0.18-0.6)		390	325	195
	WNMG	06 04 08-PM		☆		★	☆	2 (0.5-3)	0.3 (0.15-0.5)		415	345	210
		06 04 12-PM		☆		★	☆	2 (0.8-3)	0.35 (0.18-0.6)		390	325	195
		08 04 08-PM		☆		★	☆	2.5 (0.5-4)	0.3 (0.15-0.5)		415	345	210
		08 04 12-PM		☆		★	☆	2.5 (0.8-4)	0.35 (0.18-0.6)		390	325	195
		08 04 16-PM		☆		★	3 (1-4)	0.4 (0.23-0.65)		370	305	185	



GRUBA OBRADA ČELIKA

Nisko legirani čelik, HB 180

ISO/
ANSI

P

R

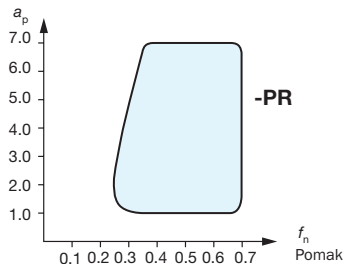
T-MAX P

Dvostrane pločice

CNMG 12 04 12-PR

 $a_p = 1.0 - 7.0 \text{ mm}$ $f_n = 0.25 - 0.7 \text{ mm/obr}$

Dubina rezanja



-PR

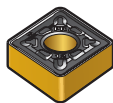
Operacije: uzdužno i čeono struganje, profilisanje**Komponente:** vratila, osovine, zupčanci i sl.**Prednosti:** univerzalna geometrija za dvostrane pločice za visokim mogućnostima za grubu obradu čime povećava ekonomičnost korišćenja

DOBRI USLOVI OBRADJE



- Kontinualan rez.
- Predobrađeni ili sa malom korom.

NORMALAN POMAK



-PR / GC4215

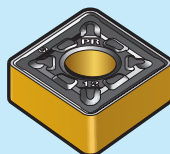
Prvi izbor

PROSEČNI USLOVI OBRADJE



Operacije opšte namene.

NORMALAN POMAK



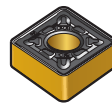
-PR / GC4225

TEŠKI USLOVI OBRADJE



- Prekidan rez.
- Pripremak sa teškom korom.

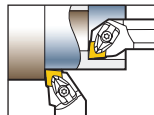
NORMALAN POMAK









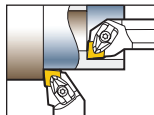
-PR / GC4235

ISO/
ANSI**P R****GRUBA OBRADA ČELIKA**

Negativne pločice



KATALOŠKA OZNAKA			REŽIMI OBRADJE, CMC 02.1 / HB 180						
Dvostrane pločice	 r_c	GC4215	GC4225	GC4235	Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)		
							GC4215	GC4225	GC4235
	CNMG 12 04 08-PR	☆	★	☆	4 (0.7-7)	0.35 (0.2-0.5)	390	325	195
	12 04 12-PR	☆	★	☆	4 (1-7)	0.4 (0.25-0.7)	370	305	185
	12 04 16-PR	☆	★	☆	4 (1.5-7)	0.5 (0.32-0.75)	335	275	170
	16 06 08-PR	☆	★	☆	5 (0.7-8)	0.35 (0.2-0.5)	390	325	195
	16 06 12-PR	☆	★	☆	5 (1-8)	0.4 (0.25-0.7)	370	305	185
	16 06 16-PR	☆	★	☆	5 (1.5-8)	0.5 (0.3-0.8)	335	275	170
	16 06 24-PR	☆	★	☆	5 (2-8)	0.5 (0.32-0.9)	335	275	170
	19 06 08-PR	☆	★	☆	5 (0.7-10)	0.35 (0.2-0.5)	390	325	195
	19 06 12-PR	☆	★	☆	5 (1-10)	0.4 (0.25-0.7)	370	305	185
	19 06 16-PR	☆	★	☆	5 (1.5-10)	0.5 (0.3-0.8)	335	275	170
19 06 24-PR	☆	★	☆	5 (2-10)	0.5 (0.32-0.9)	335	275	170	
	DNMG 15 06 08-PR	☆	★	☆	4 (0.7-6)	0.35 (0.2-0.5)	390	325	195
	15 06 12-PR	☆	★	☆	4 (1-6)	0.4 (0.25-0.7)	370	305	185
	15 06 16-PR	☆	★	☆	4 (1.5-6)	0.5 (0.32-0.75)	335	275	170
	SNMG 12 04 08-PR	☆	★	☆	4 (0.7-7)	0.35 (0.2-0.5)	390	325	195
	12 04 12-PR	☆	★	☆	4 (1-7)	0.4 (0.25-0.7)	370	305	185
	15 06 08-PR	☆	★	☆	5 (1.5-8)	0.35 (0.2-0.5)	390	325	195
	15 06 12-PR	☆	★	☆	5 (1-8)	0.4 (0.25-0.7)	370	305	185
	15 06 16-PR	☆	★	☆	5 (1.5-8)	0.5 (0.3-0.8)	335	275	170
	15 06 24-PR	☆	★	☆	5 (2-8)	0.5 (0.32-0.9)	335	275	170
	19 06 12-PR	☆	★	☆	5 (1-10)	0.4 (0.25-0.7)	370	305	185
	19 06 16-PR	☆	★	☆	5 (1.5-10)	0.5 (0.3-0.8)	335	275	170
	19 06 24-PR	☆	★	☆	5 (2-10)	0.5 (0.32-0.9)	335	275	170
	TNMG 16 04 08-PR	☆	★	☆	3 (0.7-6)	0.35 (0.2-0.55)	390	325	195
	16 04 12-PR	☆	★	☆	3 (1-6)	0.4 (0.25-0.65)	370	305	185
	22 04 08-PR	☆	★	☆	4 (0.7-7)	0.35 (0.2-0.55)	390	325	195
	22 04 12-PR	☆	★	☆	4 (1-7)	0.4 (0.25-0.65)	370	305	185
	22 04 16-PR	☆	★	☆	4 (1.5-7)	0.5 (0.32-0.75)	335	275	170
	WNMG 06 04 08-PR	☆	★	☆	3 (0.7-3.5)	0.3 (0.2-0.45)	415	345	210
	06 04 12-PR	☆	★	☆	3 (0.8-3.5)	0.35 (0.25-0.55)	390	325	
	08 04 08-PR	☆	★	☆	4 (0.7-5)	0.35 (0.2-0.55)	390	325	195
	08 04 12-PR	☆	★	☆	4 (1-5)	0.4 (0.25-0.7)	370	305	185
	08 04 16-PR	☆	★	☆	4 (1.5-5)	0.5 (0.32-0.75)	335	275	170



GRUBA OBRADA ČELIKA

Nisko legirani čelik, HB 180

ISO/
ANSI

P

R

T-MAX P

Jednostrane pločice

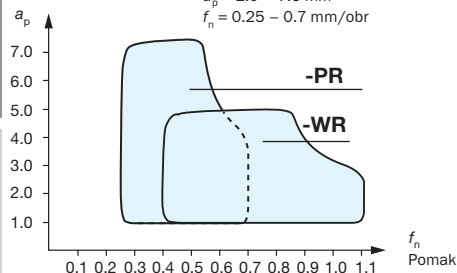
CNMM 12 04 12-WR

 $a_p = 1.0 - 5.0$ mm $f_n = 0.4 - 1.1$ mm/obr

CNMM 12 04 12-PR

 $a_p = 1.0 - 7.5$ mm $f_n = 0.25 - 0.7$ mm/obr

Dubina rezanja



WR – za produktivno grubo struganje

Operacije: Uzdužno i čeono struganje

Komponente: osovine, vratila, zupčanice i sl.

Prednosti: jaka jednostrana geometrija za visoku produktivnost sa velikom stabilnošću pločice u sedištu.

-PR

Operacije: uzdužno i čeono struganje, profilisanje

Komponente: vratila, osovine, zupčanici i sl.

Prednosti: Pozitivna geometrija za grubu obradu koja generiše male sile rezanja, široka primena, visoka stabilnost kod jednos-tranih pločica

DOBRI USLOVI OBRADJE



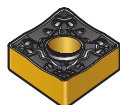
- Kontinualan rez.
- Predobrađeni ili sa malom korom.

VELIKI POMAK



-WR / GC4205

NORMALAN POMAK



-PR / GC4215

PROSEČNI USLOVI OBRADJE



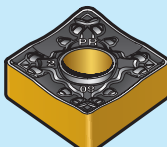
Operacije opšte namene.

VELIKI POMAK



-WR / GC4215

NORMALAN POMAK



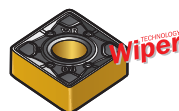
-PR / GC4225

TEŠKI USLOVI OBRADJE



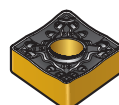
- Prekidan rez.
- Pripremak sa teškom korom.

VELIKI POMAK



-WR / GC4225

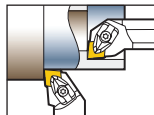
NORMALAN POMAK















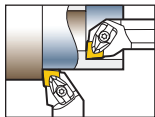
-PR / GC4235

ISO/
ANSI**P R****GRUBA OBRADA ČELIKA**

Negativne pločice



KATALOŠKA OZNAKA		REŽIMI OBRABE, CMC 02.1 / HB 180						Brzina rezanja v_c (m/min)				
Jednostrane pločice  r_e							Dubina rezanja a_p mm	Pomak f_n mm/obr	GC4205	GC4215	GC4225	GC4235
 CNMM 12 04 08-WR ☆ 12 04 12-WR ☆ 12 04 16-WR ☆ 16 06 12-WR ☆ 16 06 16-WR ☆ 19 06 16-WR ☆		☆	★	☆	☆	☆	2.5 (0.8-5)	0.6 (0.3-0.8)	335	305	250	
		☆	★	☆	☆	☆	2.5 (1-5)	0.8 (0.4-1.1)	285	260	215	
		☆	★	☆	☆	☆	2.5 (1.2-5)	0.8 (0.44-1.2)	285	260	215	
		☆	★	☆	☆	☆	3 (1.2-6)	0.8 (0.42-1.2)	285	260		
		☆	★	☆	☆	☆	3 (1.4-6)	0.9 (0.46-1.2)	265		200	
		☆	★	☆	☆	☆	3.3(1.6-6.7)	1.0 (0.48-1.2)	245	225	185	
 TNMX 22 04 12-WR			★				2.5 (1-5)	0.8 (0.4-1.1)		260		
 CNMM 12 04 08-PR ☆ 12 04 12-PR ☆ 12 04 16-PR ☆ 16 06 08-PR ☆ 16 06 12-PR ☆ 16 06 16-PR ☆ 19 06 12-PR ☆ 19 06 16-PR ☆ 19 06 24-PR ☆		☆	★	☆	☆	☆	5 (0.7-7.5)	0.4 (0.2-0.55)	370	305	185	
		☆	★	☆	☆	☆	5 (1-7.5)	0.5 (0.25-0.7)	335	275	170	
		☆	★	☆	☆	☆	5 (1.5-7.5)	0.55 (0.32-0.9)	320	265		
		☆	★	☆	☆	☆	6 (0.7-9.5)	0.4 (0.2-0.55)	370	305	185	
		☆	★	☆	☆	☆	6 (1-9.5)	0.5 (0.25-0.7)	335	275	170	
		☆	★	☆	☆	☆	6 (1.5-9.5)	0.55 (0.32-0.9)	320	265	160	
		☆	★	☆	☆	☆	6 (1-12)	0.5 (0.25-0.7)	335	275	170	
		☆	★	☆	☆	☆	6 (1.5-12)	0.55 (0.32-0.9)	320	265	160	
 DNMM 15 06 08-PR ☆ 15 06 12-PR ☆ 15 06 16-PR ☆		☆	★	☆	☆	☆	5 (0.7-6)	0.4 (0.2-0.55)	370	305	185	
		☆	★	☆	☆	☆	5 (1-6)	0.5 (0.25-0.7)	335	275	170	
		☆	★	☆	☆	☆	5 (1.5-6)	0.55 (0.32-0.9)	320	265	160	
 SNMM 12 04 08-PR ☆ 12 04 12-PR ☆ 15 06 12-PR ☆ 15 06 16-PR ☆ 19 06 12-PR ☆ 19 06 16-PR ☆ 19 06 24-PR ☆		☆	★	☆	☆	☆	5 (0.7-7.5)	0.4 (0.2-0.55)	370	305	185	
		☆	★	☆	☆	☆	5 (1-7.5)	0.5 (0.25-0.7)	335	275	170	
		☆	★	☆	☆	☆	6 (1-9)	0.5 (0.25-0.7)	335	275	170	
		☆	★	☆	☆	☆	6 (1.5-9)	0.55 (0.32-0.9)	320	265	160	
		☆	★	☆	☆	☆	6 (1-12)	0.5 (0.25-0.7)	335	275	170	
		☆	★	☆	☆	☆	6 (1.5-12)	0.55 (0.32-0.9)	320	265	160	
		☆	★	☆	☆	☆	6 (2-12)	0.55 (0.35-1.2)	320	265	160	
 TNMM 16 04 08-PR ☆ 16 04 12-PR ☆ 22 04 08-PR ☆ 22 04 12-PR ☆ 22 04 16-PR ☆		☆	★	☆	☆	☆	4 (0.7-6)	0.4 (0.2-0.55)	370	305	185	
		☆	★	☆	☆	☆	4 (1-6)	0.5 (0.25-0.7)	335	275	170	
		☆	★	☆	☆	☆	5 (0.7-8)	0.4 (0.2-0.55)	370	305	185	
		☆	★	☆	☆	☆	5 (1-8)	0.5 (0.25-0.7)	335	275	170	
		☆	★	☆	☆	☆	5 (1.5-8)	0.55 (0.32-0.9)	320	265	160	



ZAVRŠNA OBRADA NERĐAJUĆEG ČELIKA

Nerđajući čelik, austenitni HB 180

ISO/
ANSI

M

F

T-MAX P

Dvostrane
pločice

CNMG 12 04 08-WF

$a_p = 0.25 - 4.0$ mm

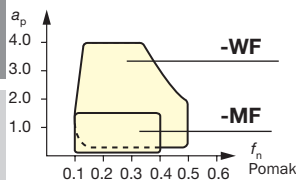
$f_n = 0.1 - 0.5$ mm/obr

CNMG 12 04 08-MF

$a_p = 0.1 - 1.5$ mm

$f_n = 0.1 - 0.4$ mm/obr

Dubina rezanja



WF – za produktivnu završnu obradu struganjem

Operacije: uzdužno i čeoно struganje

Komponente: krute osovine, vratila, zupčanic i sl..

Prednosti: Dvostruki pomak sa istim kvalitetom površine ili duplo bolja površina sa istim pomakom.

-MF

Operacije: finalne operacije generalno

Komponente: Komponente od nerđajućeg čelika

Prednosti: pozitivna rezna geometrija, male sile rezanja pogodne za vitka vratila, tankozidne i slabo stegnute pripreme.

DOBRI USLOVI OBRAD E



- Kontinualan rez
- Predobrađeni ili sa malom korom.

VELIKI POMAK



-WF / GC2015

NORMALAN POMAK



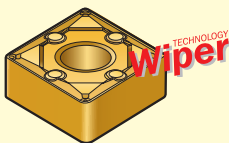
-MF / GC2015

PROSEČNI USLOVI OBRAD E



Operacije opšte namene.

VELIKI POMAK



-WF / GC2015

NORMALAN POMAK



-MF / GC2015

TEŠKI USLOVI OBRAD E



- Prekidan rez.
- Pripremak sa debelom korom.

VELIKI POMAK



-WF / GC2015

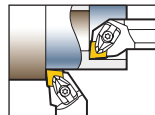
NORMALAN POMAK

















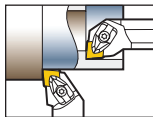
-MF / GC2025

ISO/
ANSI**M F****ZAVRŠNA OBRADA NERĐAJUĆEG ČELIKA**

Negativne pločice



KATALOŠKA OZNAKA				REŽIMI REZANJA, CMC 05.21 / HB 180				
Dvostrane pločice  r_c					Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)	
							GC2015	GC2025
	CNMG 12 04 04-WF	☆	★	☆	0.4 (0.25-3)	0.15 (0.05-0.25)	290	
	12 04 08-WF	☆	★	☆	1 (0.25-4)	0.3 (0.1-0.5)	220	
 <i>Wiper</i>	DNMX 11 04 04-WF	☆	★	☆	1 (0.2-1.5)	0.2 (0.08-0.3)	290	
	11 04 08-WF	☆	★	☆	1 (0.2-3)	0.3 (0.1-0.4)	270	
	15 06 08-WF	☆	★	☆	1.5 (0.2-3)	0.3 (0.1-0.4)	270	
	TNMX 16 04 04-WF	☆	★	☆	1 (0.2-3)	0.2 (0.08-0.3)	290	
	16 04 08-WF	☆	★	☆	1.5 (0.2-3)	0.3 (0.1-0.4)	270	
	WNMG 06 04 04-WF	☆	★	☆	0.4 (0.25-2)	0.15 (0.05-0.25)	290	
	06 04 08-WF	☆	★	☆	1 (0.25-3)	0.3 (0.1-0.5)	270	
	08 04 04-WF	☆	★	☆	0.4 (0.25-3)	0.15 (0.05-0.25)	290	
	08 04 08-WF	☆	★	☆	1 (0.25-4)	0.3 (0.1-0.5)	270	
	CNMG 12 04 04-MF	☆	★	☆	0.4 (0.1-1.5)	0.1 (0.05-0.2)	290	265
	12 04 08-MF	☆	★	☆	0.4 (0.1-1.5)	0.2 (0.1-0.4)	290	240
	DNMG 11 04 04-MF	☆	★	☆	0.4 (0.1-1.5)	0.1 (0.05-0.2)	290	265
	11 04 08-MF	☆	★	☆	0.4 (0.1-1.5)	0.2 (0.1-0.4)	290	240
	15 06 04-MF	☆	★	☆	0.4 (0.1-1.5)	0.1 (0.05-0.2)	290	265
	15 06 08-MF	☆	★	☆	0.4 (0.1-1.5)	0.2 (0.1-0.4)	290	240
	SNMG 12 04 04-MF	☆	★	☆	0.4 (0.1-1.5)	0.1 (0.05-0.2)	290	265
	12 04 08-MF	☆	★	☆	0.4 (0.1-1.5)	0.2 (0.1-0.4)	290	240
	TNMG 16 04 04-MF	☆	★	☆	0.4 (0.1-1.5)	0.1 (0.05-0.2)	290	265
	16 04 08-MF	☆	★	☆	0.4 (0.1-1.5)	0.2 (0.1-0.4)	290	240
	VNMG 16 04 04-MF	☆	★	☆	0.4 (0.1-1.5)	0.1 (0.05-0.2)	290	265
	16 04 08-MF	☆	★	☆	0.8 (0.2-2.5)	0.15 (0.08-0.3)	290	260
	WNMG 06 04 04-MF	☆	★	☆	0.4 (0.1-1.5)	0.1 (0.05-0.2)	290	265
	06 04 08-MF	☆	★	☆	0.4 (0.1-1.5)	0.2 (0.1-0.4)	290	240
	08 04 04-MF	☆	★	☆	0.4 (0.1-1.5)	0.1 (0.05-0.2)	290	265
	08 04 08-MF	☆	★	☆	0.4 (0.1-1.5)	0.2 (0.1-0.4)	290	240



SREDNJA OBRADA NERĐAJUĆEG ČELIKA

Nerđajući čelik, austenitni HB 180

ISO/
ANSI

M M

T-MAX P

Dvostrane
pločice

CNMG 12 04 08-WMX

$a_p = 0.5 - 5.0$ mm

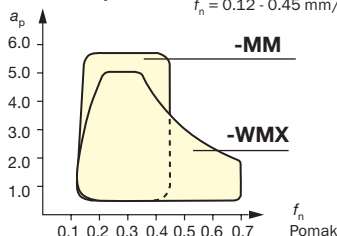
$f_n = 0.15 - 0.5$ mm/obr

CNMG 12 04 08-MM

$a_p = 0.5 - 5.7$ mm

$f_n = 0.12 - 0.45$ mm/obr

Dubina rezanja



WMX - za produktivnu srednju obradu struganjem

Operacije: uzdužno i čeono struganje

Komponente: krute osovine, vratila, zupčanici i sl.

Prednosti: Utrošučite konvencionalne pomake sa poboljšanim kvalitetom završne obrade. Idealan kada je kvalitet obrad-jene površine prioritet. Može da zameni i operaciju brušenja. Poboľjšano je i lomljenje strugotine usled većih pomaka. Poboľjšan vek alata (komponenti/ivici) usled kraćeg vremena provedenog u zahvatu

-MM

Operacije: uzdužno i čeono struganje, profilisanje

Komponente: Komponente od nerđajućeg čelika

Prednosti: pouzdanost koja omogućava obradu bez problema

DOBRI USLOVI OBRADJE



- Kontinualan rez
- Predobrađeni ili sa malom korom.

VELIKI POMAK



-WMX / GC2015

NORMALAN POMAK



-MM / GC2015

Prvi izbor

PROSEČNI USLOVI OBRADJE



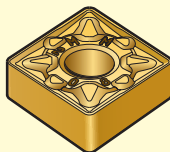
Operacije opšte namene.

VELIKI POMAK



-WMX / GC2015

NORMALAN POMAK



-MM / GC2025

TEŠKI USLOVI OBRADJE



- Prekidan rez.
- Pripremak sa debelom korom.

VELIKI POMAK

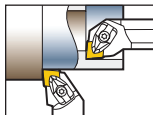


-WMX / GC2015

NORMALAN POMAK



-MM / GC2035



GRUBA OBRADA NERĐAJUĆEG ČELIKA

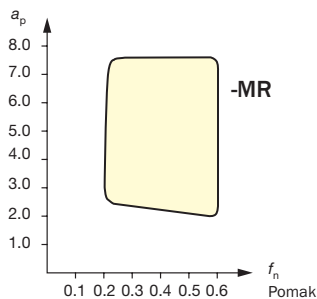
Nerđajući čelik, austenitni HB 180

ISO/
ANSI**M R****T-MAX P****Dvostrane pločice**

CNMG 12 04 12-MR

 $a_p = 2.0 - 7.6 \text{ mm}$ $f_n = 0.2 - 0.6 \text{ mm/obr}$

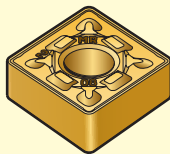
Dubina rezanja

**-MR****Operacije:** uzdužno i čeono struganje, profilisanje**Komponente:** Komponente od nerđajućeg čelika**Prednosti:** široka primena za grubu obradu, dvostrana pločica za produktivnu grubu obradu koja doprinosi ekonomičnosti**DOBRI USLOVI OBRADJE**

- Kontinualan rez
- Predobrađeni ili sa malom korom.

NORMALAN POMAK**-MR / GC2025****Prvi izbor****PROSEČNI USLOVI OBRADJE**

Operacije opšte namene.

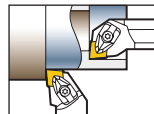
NORMALAN POMAK**-MR / GC2025****TEŠKI USLOVI OBRADJE**

- Prekidan rez.
- Pripremak sa debelom korom.

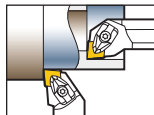
NORMALAN POMAK**-MR / GC2025**

ISO/
ANSI**M R****GRUBA OBRADA NERĐAJUĆEG ČELIKA**

Negativne pločice



KATALOŠKA OZNAKA					REŽIMI REZANJA, CMC 05.21 / HB 180		
Dvostrane pločice r_c		GC2025	GC2025	GC2025	Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)
							GC2025
	CNMG 12 04 08-MR	☆	★	☆	3 (2-7.6)	0.3 (0.15-0.55)	205
	12 04 12-MR	☆	★	☆	3 (2-7.6)	0.35 (0.2-0.6)	190
	12 04 16-MR	☆	★	☆	3 (2-7.6)	0.4 (0.25-0.7)	175
	16 06 12-MR	☆	★	☆	4 (2-10)	0.35 (0.2-0.6)	190
	16 06 16-MR	☆	★	☆	4 (2-10)	0.4 (0.25-0.7)	175
	DNMG 15 06 08-MR	☆	★	☆	3 (2-6)	0.3 (0.15-0.55)	205
	15 06 12-MR	☆	★	☆	3 (2-6)	0.35 (0.2-0.6)	190
	SNMG 12 04 08-MR	☆	★	☆	3 (2-7.6)	0.3 (0.15-0.55)	205
	12 04 12-MR	☆	★	☆	3 (2-7.6)	0.35 (0.2-0.6)	190
	15 06 12-MR	☆	★	☆	4 (2-9.6)	0.35 (0.2-0.6)	190
	15 06 16-MR	☆	★	☆	4 (2-9.6)	0.4 (0.25-0.7)	175
	TNMG 16 04 08-MR	☆	★	☆	3 (2-5.6)	0.3 (0.15-0.55)	205
	16 04 12-MR	☆	★	☆	3 (2-5.6)	0.35 (0.2-0.6)	190
	22 04 08-MR	☆	★	☆	4 (2-7.7)	0.3 (0.15-0.55)	205
	22 04 12-MR	☆	★	☆	4 (2-7.7)	0.35 (0.2-0.6)	190
	WNMG06 04 08-MR	☆	★	☆	2 (1.5-3)	0.3 (0.15-0.55)	205
	06 04 12-MR	☆	★	☆	2 (1.5-3)	0.35 (0.2-0.6)	190
	08 04 08-MR	☆	★	☆	2.5 (2-4)	0.3 (0.15-0.55)	205
	08 04 12-MR	☆	★	☆	2.5 (2-4)	0.35 (0.2-0.6)	190

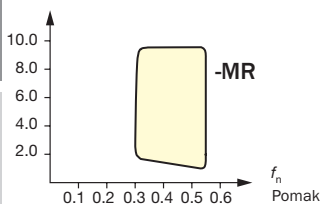


GRUBA OBRADA NERĐAJUĆEG ČELIKA

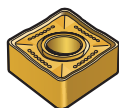
Nerđajući čelik, austenitni HB 180

ISO/
ANSI**M R****T-MAX P****Jednostrane pločice**

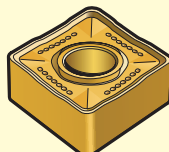
CNMM 16 06 08-MR

 $a_p = 1.0 - 9.5 \text{ mm}$ $f_n = 0.3 - 0.55 \text{ mm/obr}$ **-MR****Operacije:** uzdužno i čeono struganje, profilisanje**Komponente:** valjci, vratila, osovine i sl.**Prednosti:** Jaka rezna ivica za grubu obradu, široka primena, jednostrana, veoma stabilna pločica.Dubina
rezanja
 a_p **DOBRI USLOVI OBRADJE**

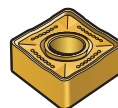
- Kontinualan rez
- Predobrađeni ili sa malom korom.

NORMALAN POMAK**-MR / GC2025****Prvi izbor****PROSEČNI USLOVI OBRADJE**

Operacije opšte namene.

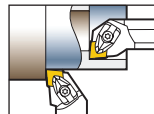
NORMALAN POMAK**-MR / GC2025****TEŠKI USLOVI OBRADJE**

- Prekidan rez.
- Pripremak sa debelom korom.

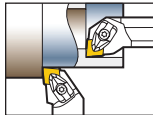
NORMALAN POMAK**-MR / GC2035**

ISO/
ANSI**M R****GRUBA OBRADA NERĐAJUĆEG ČELIKA**

Negativne pločice



KATALOŠKA OZNAKA					REŽIMI REZANJA, CMC 05.21 / HB 180			
Jednostrane pločice r_c		GC2025	GC2025	GC2035	Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)	
		GC2025	GC2025	GC2035			GC2025	GC2035
	CNMM 12 04 08-MR	☆	★	☆	3 (0.7-7.5)	0.35 (0.2-0.55)	190	155
	12 04 12-MR	☆	★		3 (1-7.5)	0.4 (0.25-0.7)	175	
	12 04 16-MR	☆	★		3 (1.5-7.5)	0.5 (0.32-0.9)	150	
	16 06 08-MR	☆	★		6 (1-9.5)	0.4 (0.3-0.55)	175	
	16 06 12-MR	☆	★		6 (1.2-9.5)	0.45 (0.32-0.65)	165	
	16 06 16-MR	☆	★		6 (1.5-9.5)	0.5 (0.35-0.8)	150	
	DNMM 15 06 08-MR	☆	★		3 (0.7-6)	0.35 (0.2-0.55)	190	
	15 06 12-MR	☆	★		3 (1-6)	0.4 (0.25-0.7)	175	
	15 06 16-MR	☆	★		3 (1.5-6)	0.5 (0.32-0.9)	150	
	SNMM 12 04 08-MR	☆	★	☆	3 (0.7-7.5)	0.35 (0.2-0.55)	190	155
	12 04 12-MR	☆	★	☆	3 (1-7.5)	0.4 (0.25-0.7)	175	145
	12 04 16-MR	☆	★	☆	3 (1.5-7.5)	0.5 (0.32-0.9)	150	130
	15 06 12-MR	☆	★		4 (1-9)	0.4 (0.25-0.7)	175	
	15 06 16-MR	☆	★		4 (1.5-9)	0.5 (0.32-0.9)	150	
	TNMM 16 04 08-MR	☆	★	☆	3 (0.7-7.5)	0.35 (0.2-0.55)	190	155
	16 04 12-MR			★	5 (1-7.5)	0.4 (0.25-0.7)		145
	22 04 08-MR	☆	★		3 (0.7-8)	0.35 (0.2-0.55)	190	
	22 04 12-MR	☆	★		3 (1-8)	0.4 (0.25-0.7)	175	
22 04 16-MR	☆	★		3 (1.5-8)	0.5 (0.32-0.9)	150		
	WNMM 08 04 08-MR	☆	★	☆	3 (0.7-6)	0.35 (0.2-0.55)	190	155
	08 04 12-MR	☆	★	☆	3 (1-6)	0.4 (0.25-0.7)	175	145
	08 04 16-MR	☆	★		3 (1.5-6)	0.5 (0.32-0.9)	150	



ZAVRŠNA OBRADA SIVOG I NODULARNOG LIVA

Visoka zatezna čvrstoća, HB 220 / HB 250

ISO/
ANSI**K****F**

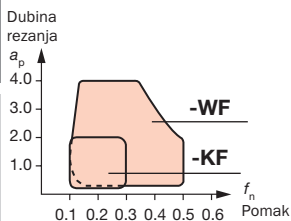
T-Max P

Dvostrane pločice

CNMG 12 04 08-WF

 $a_p = 0.25 - 4.0$ mm $f_n = 0.1 - 0.5$ mm/obr

CNMG 12 04 08-KF

 $a_p = 0.15 - 2.0$ mm $f_n = 0.1 - 0.3$ mm/obr

-WF – za produktivnu završnu obradu

Operacije: uzdužno i čeono struganje

Komponente: stabilna vratila, osovine, zupčanici i sl.

Prednosti: Duplira konvencionalne pomake uz isti kvalitet obrađene površine ili daje duplo bolji kvalitet uz iste pomake. Idealan kada je dobar kvalitet obrađene površine prioritet.

-KF

Operacije: uzdužno i čeono struganje, profilisanje

Komponente: Komponente od sivog liva

Prednosti: pozitivna geometrija sa malim silama rezanja, prednost za komponente sklone vibracijama i loše stegnute pripreme.

DOBRI USLOVI OBRADJE



Kontinualan rez.

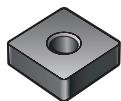
Predobrađen komad ili sa malom korom

VELIKI POMAK



-WF / GC3215

NORMALAN POMAK



.NGA / CC650

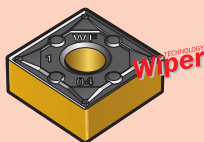
Keramika

Prvi izbor SREDNJI USLOVI OBRADJE



Opšte operacije.

VELIKI POMAK



-WF / GC3215

NORMALAN POMAK



-KF / GC3215

TEŠKI USLOVI OBRADJE



Prekinut rez.

Debela kora od livenja.

VELIKI POMAK



-WF / GC3215

NORMALAN POMAK

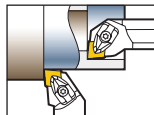


-KF / GC3215

Za najbolju primenu keramičkih pločica koristiti specijalno konstruisane nosače. Videti glavni katalog.

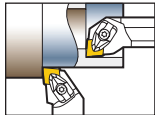
ISO/
ANSI**K F****ZAVRŠNA OBRADA SIVOG I NODULARNOG
LIVA**

Negativne pločice



KATALOŠKA OZNAKA		REŽIMI OBRADE, CMC 08.2 ¹⁾ / HB 220							
					Brzina rezanja v_c (m/min)				
Dvostrane pločice	r_c	CC650	GC3215	GC3215	GC3215	Dubina rezanja a_p mm	Pomak f_n mm/obr	CC650	GC3215
	CNMG 09 03 08-WF		☆	★	☆	1 (0.3-2)	0.3 (0.1-0.5)		190
	12 04 04-WF		☆	★	☆	0.4 (0.25-3)	0.15 (0.05-0.25)		225
	12 04 08-WF		☆	★	☆	1 (0.25-4)	0.3 (0.1-0.5)		190
	12 04 12-WF		☆	★	☆	1.5 (0.4-4)	0.5 (0.2-0.6)		160
	DNMX 11 04 04-WF		☆	★	☆	1 (0.2-1.5)	0.2 (0.08-0.3)		215
	11 04 08-WF		☆	★	☆	1 (0.2-3)	0.3 (0.1-0.4)		190
	15 06 08-WF		☆	★	☆	1.5 (0.2-3)	0.3 (0.1-0.4)		190
	15 06 12-WF		☆	★	☆	1.5 (0.4-3.5)	0.4 (0.15-0.55)		175
	TNMX 16 04 04-WF		☆	★	☆	1 (0.2-3)	0.2 (0.08-0.3)		215
	16 04 08-WF		☆	★	☆	1.5 (0.2-3)	0.3 (0.1-0.4)		190
	WNMG06 04 04-WF		☆	★	☆	0.4 (0.25-2)	0.15 (0.05-0.25)		225
	06 04 08-WF		☆	★	☆	1 (0.25-3)	0.3 (0.1-0.5)		190
	08 04 04-WF		☆	★	☆	0.4 (0.25-3)	0.15 (0.05-0.25)		225
	08 04 08-WF		☆	★	☆	1 (0.25-4)	0.3 (0.1-0.5)		190
	08 04 12-WF		☆	★	☆	1.5 (0.4-4)	0.5 (0.2-0.6)		160
	CNMG 12 04 04-KF			★	☆	0.5 (0.15-2)	0.15 (0.08-0.25)		225
	12 04 08-KF			★	☆	0.5 (0.15-2)	0.2 (0.1-0.3)		215
	12 04 12-KF			★	☆	1 (0.2-2.5)	0.25 (0.1-0.35)		200
	CNGA 12 04 08 T01020		★			3.6 (0.1-6)	0.2 (0.05-0.36)		610
	12 04 12 T01020		★			3.6 (0.1-6)	0.3 (0.05-0.54)		540
	16 06 08 T01020		★			4.8 (0.1-8)	0.2 (0.05-0.36)		610
	16 06 12 T01020		★			4.8 (0.1-8)	0.3 (0.05-0.54)		540
	DNMG 11 04 04-KF			★	☆	0.5 (0.15-2)	0.15 (0.08-0.25)		225
	11 04 08-KF			★	☆	0.5 (0.15-2)	0.2 (0.1-0.3)		215
	15 06 04-KF			★	☆	0.5 (0.15-2)	0.15 (0.08-0.25)		225
	15 06 08-KF			★	☆	0.5 (0.15-2)	0.2 (0.1-0.3)		215
	SNGA 12 04 08 T01020		★			3.6 (0.1-6)	0.2 (0.05-0.36)		610
	12 04 12 T01020		★			3.6 (0.1-6)	0.3 (0.05-0.54)		540
	TNMG 16 04 04-KF			★	☆	0.5 (0.15-2)	0.15 (0.08-0.25)		225
	16 04 08-KF			★	☆	0.5 (0.15-2)	0.2 (0.1-0.3)		215
	TNGA 16 04 08 T01020		★			4.8 (0.1-8)	0.2 (0.05-0.36)		610
	16 04 12 T01020		★			4.8 (0.1-8)	0.3 (0.05-0.54)		540
	WNMG 06 04 04-KF			★	☆	0.5 (0.15-2)	0.15 (0.08-0.25)		225
	08 04 04-KF			★	☆	0.5 (0.15-2)	0.15 (0.08-0.25)		225
	08 04 08-KF			★	☆	0.5 (0.15-2)	0.2 (0.1-0.3)		215
	08 04 12-KF			★	☆	1 (0.2-2.5)	0.25 (0.1-0.35)		200

¹⁾ Za CMC 09.2 smanjite brzinu rezanja (v_c) za 10%.



SREDNJA OBRADA SIVOG I NODULARNOG LIVA

Visoka zatezna čvrstoća, HB 220

ISO/
ANSI

K

M

T-Max P

Dvostrane pločice

CNMG 12 04 08-WMX

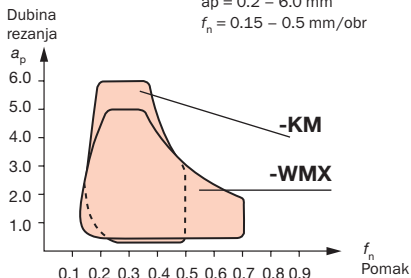
$a_p = 0.5 - 5.0$ mm

$f_n = 0.15 - 0.6$ mm/obr

CNMG 12 04 08-KM

$a_p = 0.2 - 6.0$ mm

$f_n = 0.15 - 0.5$ mm/obr



-WMX – za produktivnu srednju obradu

Operacije: uzdužno i čeono struganje

Komponente: stabilna vratila, osovine, zupčanići i sl.

Prednosti: Utrostručite konvencionalne pomake sa poboljšanim kvalitetom završne obrade. Idealan kada je kvalitet obradene površine prioritet. Može da zameni i operaciju brušenja. Poboljšano je i lomljenje strugotine usled većih pomaka. Poboljšan vek alata (komponenti/ivici) usled kraćeg vremena provedenog u zahvatu.

-KM

Operacije: uzdužno i čeono struganje, profilisanje

Komponente: Komponente od sivog liva

Prednosti: pouzdana obrada bez prisutnih problema. Od završne do lako grube obrade

Pločice za nodularni liv, videti stranu 44.

DOBRI USLOVI OBRADJE



Kontinualan rez.

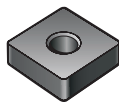
Predobrađen komad ili sa malom korom

VELIKI POMAK



-WMX / GC3215

NORMALAN POMAK



Keramika

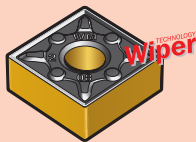
.NGA / CC6190

SREDNJI USLOVI OBRADJE



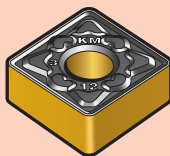
Opšte operacije.

VELIKI POMAK



-WMX / GC3215

NORMALAN POMAK



-KM / GC3205

TEŠKI USLOVI OBRADJE



Prekinut rez.

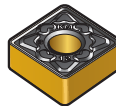
Debela kora od livenja.

VELIKI POMAK



-WMX / GC3215

NORMALAN POMAK

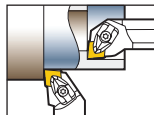

















-KM / GC3215

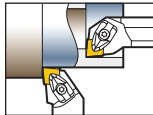
Za najbolju primenu keramičkih pločica koristiti specijalno konstruisane nosače. Videti glavni katalog.

ISO/
ANSI**K M****SREDNJA OBRADA SIVOG I NODULARNOG LIVA**

Negativne pločice



Dvostrane pločice  r_s		REŽIMI OBRADE, CMC 08.2 / HB 220					Brzina rezanja v_c (m/min)				
		CC6190	GC3215	GC3205	GC3215	GC3215	Dubina rezanja a_p mm	Pomak f_n mm/obr	CC6190	GC3205	GC3215
	CNMG 12 04 08-WMX		☆		★	☆	3 (0.5-5)	0.45 (0.15-0.7)			170
	12 04 12-WMX		☆		★	☆	3.5 (0.8-6)	0.5 (0.2-0.75)			160
	16 06 08-WMX		☆		★	☆	3 (0.5-5)	0.45 (0.15-0.7)			170
	16 06 12-WMX		☆		★	☆	3.5 (0.8-6)	0.5 (0.2-0.75)			160
	DNMX 15 06 08-WMX		☆		★	☆	3 (0.5-5)	0.45 (0.15-0.7)			170
	15 06 12-WMX		☆		★	☆	3.5 (0.8-6)	0.5 (0.2-0.75)			160
	15 06 16-WMX		☆		★	☆	3.5 (0.5-6)	0.5 (0.2-0.8)			160
	TNMX 16 04 08-WMX		☆		★	☆	3 (0.5-5)	0.45 (0.15-0.7)			170
	16 04 12-WMX		☆		★	☆	3.5 (0.8-6)	0.5 (0.2-0.75)			160
	WNMG06 04 08-WMX		☆		★	☆	3 (0.5-5)	0.45 (0.15-0.7)			170
	06 04 12-WMX		☆		★	☆	3.5 (0.8-6)	0.5 (0.2-0.75)			160
	08 04 08-WMX		☆		★	☆	3 (0.5-5)	0.45 (0.15-0.7)			170
	08 04 12-WMX		☆		★	☆	3.5 (0.8-6)	0.5 (0.2-0.75)			160
	CNMG 12 04 08-KM			★	☆	☆	3 (0.2-6)	0.35 (0.15-0.5)		325	185
	12 04 12-KM			★	☆	☆	3 (0.3-6)	0.4 (0.15-0.6)		310	175
	12 04 16-KM			★	☆	☆	3 (0.3-6)	0.45 (0.2-0.7)		295	170
	16 06 08-KM			★	☆	☆	4 (0.2-8)	0.35 (0.15-0.5)		325	185
	16 06 12-KM			★	☆	☆	4 (0.3-8)	0.4 (0.15-0.6)		310	175
	16 06 16-KM			★	☆	☆	4 (0.3-8)	0.45 (0.2-0.7)		295	170
	CNGA 12 04 08T02520	★					3 (2-4)	0.5 (0.3-0.56)	490		
	12 04 12T02520	★					3 (2-4)	0.5 (0.3-0.6)	490		
	12 04 16T02520	★					3 (2-4)	0.5 (0.3-0.6)	490		
	16 06 12T02520	★					4.8 (0.1-8)	0.3 (0.15-0.54)	620		
	16 06 16T02520	★					4.8 (0.1-8)	0.4 (0.15-0.6)	550		
	DNMG 11 04 08-KM				★	☆	2 (0.2-3.5)	0.35 (0.15-0.5)			185
	11 04 12-KM				★	☆	2 (0.3-3.5)	0.4 (0.15-0.6)			175
	15 06 08-KM			★	☆	☆	2.5 (0.2-5)	0.35 (0.15-0.5)	325		185
	15 06 12-KM			★	☆	☆	2.5 (0.3-5)	0.4 (0.15-0.6)	310		175
	SNMG 09 03 08-KM				★	☆	2.5 (0.2-4.5)	0.35 (0.15-0.5)			185
	12 04 08-KM			★	☆	☆	3 (0.2-6)	0.35 (0.15-0.5)	325		185
	12 04 12-KM			★	☆	☆	3 (0.3-6)	0.4 (0.15-0.6)	310		175
	12 04 16-KM			★	☆	☆	3 (0.3-6)	0.45 (0.2-0.7)	295		170
	15 06 12-KM			★	☆	☆	4 (0.3-8)	0.4 (0.15-0.6)	310		175
	15 06 16-KM			★	☆	☆	4 (0.3-8)	0.45 (0.2-0.7)	295		170
	SNGA 12 04 08 T02520	★					3 (2-4)	0.5 (0.3-0.56)	490		
	12 04 12 T02520	★					3 (2-4)	0.5 (0.3-0.6)	490		
	12 04 16 T02520	★					3 (2-4)	0.5 (0.3-0.6)	490		
	TNMG 16 04 08-KM			★	☆	☆	3 (0.2-5.5)	0.35 (0.15-0.5)		325	185
	16 04 12-KM			★	☆	☆	3 (0.3-5.5)	0.4 (0.15-0.6)		310	175
	22 04 08-KM			★	☆	☆	4 (0.2-8)	0.35 (0.15-0.5)		325	185
	22 04 12-KM			★	☆	☆	4 (0.3-8)	0.4 (0.15-0.6)		310	175
	22 04 16-KM			★	☆	☆	4 (0.3-8)	0.45 (0.2-0.7)		295	170
	TNGA 16 04 08 T02520	★					3 (2-4)	0.5 (0.3-0.56)	490		
	16 04 12 T02520	★					3 (2-4)	0.5 (0.3-0.6)	490		
	16 04 16 T02520	★					4.8 (0.1-8)	0.4 (0.15-0.6)	550		
	VNMG 16 04 08-KM			★	☆	☆	2 (0.2-3.5)	0.3 (0.15-0.4)		340	190
	16 04 12-KM			★	☆	☆	2 (0.3-3.5)	0.35 (0.15-0.5)		325	185
	WNMG 06 04 08-KM				★	☆	2 (0.2-4)	0.35 (0.15-0.5)			185
	06 04 12-KM				★	☆	2 (0.3-4)	0.4 (0.15-0.6)			175
	08 04 08-KM			★	☆	☆	2.5 (0.2-5)	0.35 (0.15-0.5)	325		185
	08 04 12-KM			★	☆	☆	2.5 (0.3-5)	0.4 (0.15-0.6)	310		175
	08 04 16-KM			★	☆	☆	2.5 (0.3-5)	0.45 (0.2-0.7)	295		170
	WNGA 08 04 08T02520	★					3 (0.1-5)	0.2 (0.15-0.36)	700		
	08 04 12T02520	★					3 (0.1-5)	0.3 (0.15-0.54)	620		
	08 04 16T02520	★					3 (0.1-5)	0.4 (0.15-0.6)	550		



SREDNJA OBRADA NODULARNOG LIVA

ISO/
ANSI

K M

Visoka zatezna čvrstoća, HB 250

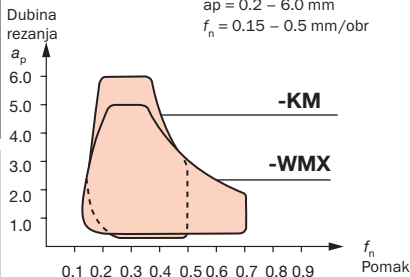
T-Max P

Dvostrane pločice

CNMG 12 04 08-WMX

 $a_p = 0.5 - 5.0 \text{ mm}$ $f_n = 0.15 - 0.6 \text{ mm/obr}$

CNMG 12 04 08-KM

 $a_p = 0.2 - 6.0 \text{ mm}$ $f_n = 0.15 - 0.5 \text{ mm/obr}$ 

-WMX – za produktivnu srednju obradu

Operacije: uzdužno i čeono struganje

Komponente: stabilna vratila, osovine, zupčaniци i sl.

Prednosti: Utrostručite konvencionalne pomake sa poboljšanim kvalitetom završne obrade. Idealan kada je kvalitet obradjene površine prioritet. Može da zameni i operaciju brušenja. Poboljšano je i lomljenje strugotine usled većih pomaka. Poboljšan vek alata (komponenti/ivici) usled kraćeg vremena provedenog u zahvatu.

-KM

Operacije: uzdužno i čeono struganje, profilisanje

Komponente: Komponente od sivog liva

Prednosti: pouzdana obrada bez prisutnih problema. Od završne do lako grube obrade

Pločice za sivi liv, videti stranu 42

DOBRI USLOVI OBRADJE



Kontinualan rez.

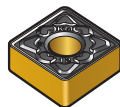
Predobrađen komad ili sa malom korom

VELIKI POMAK



-WMX / GC3210

NORMALAN POMAK



-KM / GC3210

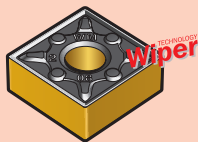
Prvi izbor

SREDNJI USLOVI OBRADJE



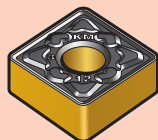
Opšte operacije.

VELIKI POMAK



-WMX / GC3210

NORMALAN POMAK



-KM / GC3210

TEŠKI USLOVI OBRADJE



Prekinut rez.

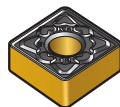
Debela kora od livenja.

VELIKI POMAK

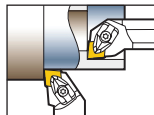


-WMX / GC3215

NORMALAN POMAK

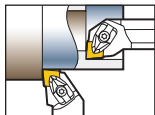


-KM / GC3215

ISO/
ANSI**K M****SREDNJA OBRADA NODULARNOG LIVA**

Negativne pločice

KATALOŠKA OZNAKA		REŽIMI OBRADE, CMC 09.2 / HB 250			Brzina rezanja v_c (m/min)		
		GC3210	GC3210	GC3215	GC3210	GC3215	
Dvostrane pločice r_c				Dubina rezanja a_p mm	Pomak f_n mm/obr		
	CNMG12 04 08-WMX 12 04 12-WMX 16 06 08-WMX 16 06 12-WMX	☆ ☆ ☆ ☆	★ ★ ★ ★	☆ ☆ ☆ ☆	3 (0.5-5) 3.5 (0.8-6) 3 (0.5-5) 3.5 (0.8-6)	0.45 (0.15-0.7) 0.5 (0.2-0.75) 0.45 (0.15-0.7) 0.5 (0.2-0.75)	245 170 235 160 245 170 235 160
	DNMX15 06 08-WMX 15 06 12-WMX 15 06 16-WMX	☆ ☆ ☆	★ ★ ★	☆ ☆ ☆	3 (0.5-5) 3.5 (0.8-6) 3.5 (0.5-6)	0.45 (0.15-0.7) 0.5 (0.2-0.75) 0.5 (0.2-0.8)	245 170 235 160 235 160
	TNMX16 04 08-WMX 16 04 12-WMX	☆ ☆	★ ★	☆ ☆	3 (0.5-5) 3.5 (0.8-6)	0.45 (0.15-0.7) 0.5 (0.2-0.75)	245 170 235 160
	WNMG06 04 08-WM 06 04 12-WM 08 04 08-WM 08 04 12-WM	☆ ☆ ☆ ☆	★ ★ ★ ★	☆ ☆ ☆ ☆	3 (0.5-5) 3.5 (0.8-6) 3 (0.5-5) 3.5 (0.8-6)	0.45 (0.15-0.7) 0.5 (0.2-0.75) 0.45 (0.15-0.7) 0.5 (0.2-0.75)	245 170 235 160 245 170 235 160
	CNMG12 04 08-KM 12 04 12-KM 12 04 16-KM 16 06 08-KM 16 06 12-KM 16 06 16-KM	☆ ☆ ☆ ☆ ☆ ☆	★ ★ ★ ★ ★ ★	☆ ☆ ☆ ☆ ☆ ☆	3 (0.2-6) 3 (0.3-6) 3 (0.3-6) 4 (0.2-8) 4 (0.3-8) 4 (0.3-8)	0.35 (0.15-0.5) 0.4 (0.15-0.6) 0.45 (0.2-0.7) 0.35 (0.15-0.5) 0.4 (0.15-0.6) 0.45 (0.2-0.7)	270 185 255 175 245 170 270 185 255 175 245 170
	DNMG11 04 08-KM 11 04 12-KM 15 06 08-KM 15 06 12-KM	☆ ☆ ☆ ☆	★ ★ ★ ★	☆ ☆ ☆ ☆	2 (0.2-3.5) 2 (0.3-3.5) 2.5 (0.2-5) 2.5 (0.3-5)	0.35 (0.15-0.5) 0.4 (0.15-0.6) 0.35 (0.15-0.5) 0.4 (0.15-0.6)	270 185 255 175 270 185 255 175
	SNMG09 03 08-KM 12 04 08-KM 12 04 12-KM 12 04 16-KM 15 06 12-KM 15 06 16-KM	☆ ☆ ☆ ☆ ☆ ☆	★ ★ ★ ★ ★ ★	☆ ☆ ☆ ☆ ☆ ☆	2.5 (0.2-4.5) 3 (0.2-6) 3 (0.3-6) 3 (0.3-6) 4 (0.3-8) 4 (0.3-8)	0.35 (0.15-0.5) 0.35 (0.15-0.5) 0.4 (0.15-0.6) 0.45 (0.2-0.7) 0.4 (0.15-0.6) 0.45 (0.2-0.7)	270 185 270 185 255 175 245 170 255 175 245 170
	TNMG16 04 08-KM 16 04 12-KM 22 04 08-KM 22 04 12-KM 22 04 16-KM	☆ ☆ ☆ ☆ ☆	★ ★ ★ ★ ★	☆ ☆ ☆ ☆ ☆	3 (0.2-5.5) 3 (0.3-5.5) 4 (0.2-8) 4 (0.3-8) 4 (0.3-8)	0.35 (0.15-0.5) 0.4 (0.15-0.6) 0.35 (0.15-0.5) 0.4 (0.15-0.6) 0.45 (0.2-0.7)	270 185 255 175 270 185 255 175 245 170
	VNMG16 04 08-KM 16 04 12-KM	☆ ☆	★ ★	☆ ☆	2 (0.2-3.5) 2 (0.3-3.5)	0.3 (0.15-0.4) 0.35 (0.15-0.5)	285 190 270 185
	WNMG06 04 08-KM 06 04 12-KM 08 04 08-KM 08 04 12-KM 08 04 16-KM	☆ ☆ ☆ ☆ ☆	★ ★ ★ ★ ★	☆ ☆ ☆ ☆ ☆	2 (0.2-4) 2 (0.3-4) 2.5 (0.2-5) 2.5 (0.3-5) 2.5 (0.3-5)	0.35 (0.15-0.5) 0.4 (0.15-0.6) 0.35 (0.15-0.5) 0.4 (0.15-0.6) 0.45 (0.2-0.7)	270 185 255 175 270 185 255 175 245 170



GRUBA OBRADA SIVOG LIVA

Visoka zatezna čvrstoća, HB 220

ISO/
ANSI

K

R

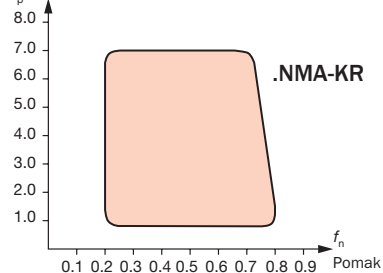
T-Max P

Dvostrane pločice

CNMA 12 04 12-KR

 $a_p = 0,3 - 8,0 \text{ mm}$ $f_n = 0,2 - 0,8 \text{ mm/obr}$

Dubina rezanja

 a_p 

.NMA-KR

Operacije: uzdužno i čeono struganje i delimično profilisanje

Komponente: Komponente od sivog liva

Prednosti: široka primena za grubu obradu

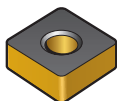
Pločice za nodularni liv, videti stranu 48

DOBRI USLOVI OBRADJE



Kontinualan rez.
Predobrađen komad ili sa malom korom

NORMALAN POMAK



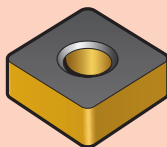
-KR / GC3205

SREDNJI USLOVI OBRADJE



Opšte operacije.

NORMALAN POMAK



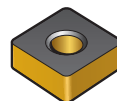
-KR / GC3205

TEŠKI USLOVI OBRADJE



Prekinut rez.
Debela kora od livenja.

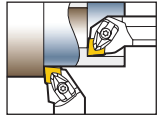
NORMALAN POMAK












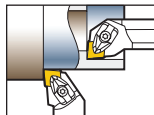
-KR / GC3215

ISO/
ANSI**K R****GRUBA OBRADA SIVOG LIVA**

Negativne pločice



KATALOŠKA OZNAKA				REŽIMI OBRADE, CMC 08.2 / HB 220				
Dvostrane pločice  r_e					Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)	
		GC3205	GC3205	GC3215			GC3205	GC3215
	CNMA 12 04 04-KR	☆	★	☆	2.5 (0.2-5)	0.2 (0.1-0.3)	375	215
	12 04 08-KR	☆	★	☆	4 (0.2-8)	0.35 (0.15-0.6)	325	185
	12 04 12-KR	☆	★	☆	4 (0.3-8)	0.45 (0.2-0.8)	295	170
	12 04 16-KR	☆	★	☆	4 (0.3-8)	0.55 (0.2-1)	275	155
	16 06 12-KR	☆	★	☆	5 (0.3-10)	0.45 (0.2-0.8)	295	170
	16 06 16-KR	☆	★	☆	5 (0.3-10)	0.55 (0.2-1)	275	155
	19 06 08-KR	☆	★	☆	6 (0.2-12)	0.35 (0.15-0.6)	325	185
	19 06 12-KR	☆	★	☆	6 (0.3-12)	0.45 (0.2-0.8)	295	170
	19 06 16-KR	☆	★	☆	6 (0.3-12)	0.55 (0.2-1)	275	155
19 06 24-KR	☆	★	☆	6 (0.4-12)	0.6 (0.2-1.19)	265	150	
	DNMA 15 06 08-KR	☆	★	☆	3 (0.2-6)	0.35 (0.15-0.6)	325	185
	15 06 12-KR	☆	★	☆	3 (0.3-6)	0.45 (0.2-0.8)	295	170
	15 06 16-KR	☆	★	☆	3 (0.3-6)	0.55 (0.2-1)	275	155
	SNMA 09 03 08-KR	☆	★	☆	2.5 (0.38-4.5)	0.38 (0.19-0.53)	315	180
	12 04 08-KR	☆	★	☆	4 (0.2-8)	0.35 (0.15-0.6)	325	185
	12 04 12-KR	☆	★	☆	4 (0.3-8)	0.45 (0.2-0.8)	295	170
	12 04 16-KR	☆	★	☆	4 (0.3-8)	0.55 (0.2-1)	275	155
	15 06 12-KR	☆	★	☆	5 (0.3-10)	0.45 (0.2-0.8)	295	170
	15 06 16-KR	☆	★	☆	5 (0.3-10)	0.55 (0.2-1)	275	155
	19 06 08-KR	☆	★	☆	6 (0.2-12)	0.35 (0.15-0.6)	325	185
	19 06 12-KR	☆	★	☆	6 (0.3-12)	0.45 (0.2-0.8)	295	170
	19 06 16-KR	☆	★	☆	6 (0.3-12)	0.55 (0.2-1)	275	155
	TNMA 16 04 04-KR	☆	★	☆	2.5 (0.2-5)	0.2 (0.1-0.3)	375	215
	16 04 08-KR	☆	★	☆	3.5 (0.2-7)	0.35 (0.15-0.6)	325	185
	16 04 12-KR	☆	★	☆	3.5 (0.3-7)	0.45 (0.2-0.8)	295	170
	16 04 16-KR	☆	★	☆	3.5 (0.3-7)	0.55 (0.2-1)	275	155
	22 04 04-KR	☆	★	☆	2.5 (0.2-10)	0.2 (0.1-0.3)	375	215
	22 04 08-KR	☆	★	☆	5 (0.2-10)	0.35 (0.15-0.6)	325	185
	22 04 12-KR	☆	★	☆	5 (0.3-10)	0.45 (0.2-0.8)	295	170
	22 04 16-KR	☆	★	☆	5 (0.3-10)	0.55 (0.2-1)	275	155
	22 04 16-KR	☆	★	☆	5 (0.3-10)	0.55 (0.2-1)	275	155
	WNMA 06 04 08-KR	☆	★	☆	2.5 (0.2-4)	0.35 (0.15-0.6)	325	185
	06 04 12-KR	☆	★	☆	2.5 (0.3-4)	0.45 (0.2-0.8)	295	170
	08 04 08-KR	☆	★	☆	3 (0.2-5)	0.35 (0.15-0.6)	325	185
	08 04 12-KR	☆	★	☆	3 (0.3-5)	0.45 (0.2-0.8)	295	170
	08 04 16-KR	☆	★	☆	3 (0.3-5)	0.55 (0.2-1)	275	155



GRUBA OBRADA NODULARNOG LIVA

ISO/
ANSI**K****R**

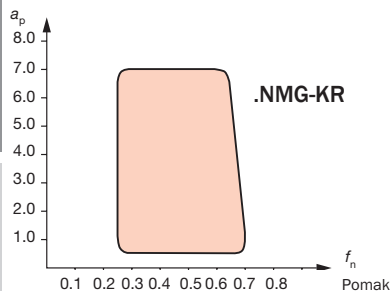
Visoka zatezna čvrstoća, HB 250

T-Max P

Dvostrane pločice

Dubina rezanja

CNMG 12 04 12-KR

 $a_p = 0.5 - 7.0 \text{ mm}$ $f_n = 0.25 - 0.7 \text{ mm/obr}$ 

.NMG-KR

Operacije: uzdužno i čeono struganje i delimično profilisanje**Komponente:** Komponente od sivog liva**Prednosti:** široka primena za grubu obradu, dvostrana pločica kao alternativa za grubu obradu, doprinos ekonomičnosti

Pločice za sivi liv, videti stranu 46

DOBRI USLOVI OBRADJE



Kontinualan rez.

Predobrađen komad ili sa malom korom

NORMALAN POMAK

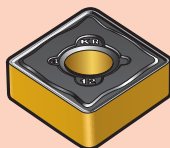


-KR / GC3210

Prvi izbor
SREDNJI USLOVI OBRADJE

Opšte operacije.

NORMALAN POMAK



-KR / GC3210

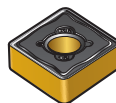
TEŠKI USLOVI OBRADJE



Prekinut rez.

Debela kora od livenja.

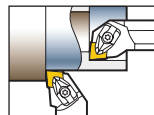
NORMALAN POMAK









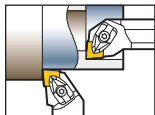
-KR / GC3215

ISO/
ANSI**K R****GRUBA OBRADA NODULARNOG LIVA**

Negativne pločice



KATALOŠKA OZNAKA			REŽIMI OBRADE, CMC 09.2/HB 250						
			○	◐	●	Brzina rezanja v_c (m/min)			
Dvostrane pločice  r_e			GC3210	GC3210	GC3215	Dubina rezanja a_p mm	Pomak f_n mm/obr	GC3210	GC3215
	CNMG 12 04 08-KR	☆	★	☆	3.5 (0.38-7)	0.38 (0.19-0.53)	260	180	
	12 04 12-KR	☆	★	☆	3.5 (0.5-7)	0.5 (0.25-0.7)	235	160	
	12 04 16-KR	☆	★	☆	3.5 (0.75-7)	0.61 (0.28-0.85)	215	150	
	16 06 12-KR	☆	★	☆	4.7 (0.8-9.3)	0.55 (0.28-0.77)	225	155	
	16 06 16-KR	☆	★	☆	4.7 (1-9.3)	0.61 (0.3-0.85)	215	150	
	19 06 12-KR	☆	★	☆	7 (1-14)	0.55 (0.28-0.77)	225	155	
	19 06 16-KR	☆	★	☆	7 (1.5-14)	0.61 (0.3-0.85)	215	150	
	DNMG 15 06 08-KR	☆	★	☆	3.5 (0.38-7)	0.34 (0.17-0.47)	270	185	
	15 06 12-KR	☆	★	☆	3.5 (0.5-7)	0.45 (0.23-0.63)	245	170	
	15 06 16-KR	☆	★	☆	3.5 (0.75-7)	0.5 (0.25-0.69)	235	160	
	SNMG 12 04 08-KR	☆	★	☆	3.5 (0.38-7)	0.38 (0.19-0.53)	260	180	
	12 04 12-KR	☆	★	☆	3.5 (0.5-7)	0.5 (0.28-0.7)	235	160	
	12 04 16-KR	☆	★	☆	3.5 (0.75-7)	0.55 (0.28-0.77)	225	155	
	15 06 12-KR	☆	★	☆	4.4 (0.63-8.8)	0.55 (0.28-0.77)	225	155	
	15 06 16-KR	☆	★	☆	4.4 (0.94-8.8)	0.61 (0.3-0.85)	215	150	
	19 06 16-KR	☆	★	☆	6.1 (1.3-12.3)	0.61 (0.3-0.85)	215	150	
	TNMG 16 04 08-KR	☆	★	☆	3.2 (0.34-6.2)	0.3 (0.17-0.42)	285	190	
	16 04 12-KR	☆	★	☆	3.2 (0.45-6.3)	0.4 (0.2-0.56)	255	175	
	16 04 16-KR	☆	★	☆	3.2 (0.68-6.2)	0.44 (0.22-0.62)	245	170	
	22 04 08-KR	☆	★	☆	3.5 (0.38-7)	0.38 (0.19-0.53)	260	180	
	22 04 12-KR	☆	★	☆	3.5 (0.5-7)	0.5 (0.25-0.7)	235	160	
	22 04 16-KR	☆	★	★	3.5 (0.75-7)	0.55 (0.28-0.77)	235	155	
	WNMG06 04 08-KR	☆	★	☆	2.2 (0.24-4.5)	0.3 (0.17-0.42)	285	190	
	06 04 12-KR	☆	★	☆	2.2 (0.32-4.5)	0.4 (0.2-0.56)	255	175	
	08 04 08-KR	☆	★	☆	2.7 (0.29-5.5)	0.34 (0.17-0.47)	270	185	
	08 04 12-KR	☆	★	☆	2.7 (0.39-5.5)	0.45 (0.23-0.63)	245	170	



ZAVRŠNA OBRADA SUPER LEGURA

Vatrootporne i super legure, HB 350

ISO/
ANSI**S****F**

T-MAX P

Dvostrane pločice

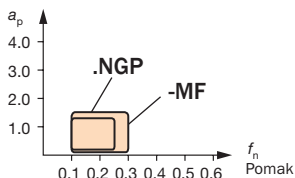
CNGP 12 04 08

 $a_p = 0.2 - 1.3$ mm $f_n = 0.1 - 0.25$ mm/obr

CNMG 12 04 08-MF

 $a_p = 0.7 - 1.5$ mm $f_n = 0.1 - 0.3$ mm/obr

Dubina rezanja

**.NGP****Operacije:** završna obrada**Komponente:** HRSA komponente

Prednosti: pozitivna geometrija sa malim silama rezanja, dobra alternativa za vitke osovine, tankozidne komponente i loše stegnute pripremk. Pozitivna geometrija smanjuje izgledje za stvaranje naslaga na reznoj ivici, ostvarujuću dobar kvalitet obrađene površine i dugu postojanost.

-MF**Operacije:** završna obrada**Komponente:** HRSA komponente

Prednosti: pozitivna geometrija sa malim silama rezanja, dobra alternativa za vitke osovine, tankozidne komponente i loše stegnute pripremk. Pozitivna geometrija smanjuje tendencije ka stvaranju naslaga na reznoj ivici, ostvarujuću dobar kvalitet obrađene površine i dugu postojanost.

DOBRI USLOVI OBRADJE



- Kontinualan rez.
- Predobrađena površina

NORMALAN POMAK

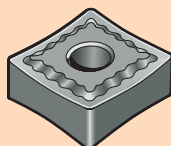
**.NGP / S05F**

Prvi izbor
SREDNJI USLOVI OBRADJE



Opšte operacije.

NORMALAN POMAK

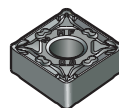
**.NGP / GC1105**

TEŠKI USLOVI OBRADJE



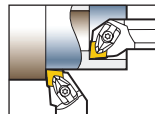
- Prekidan rez.
- Teški uslovi, kora kod otkovaka







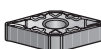
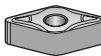
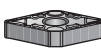
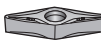


NORMALAN POMAK

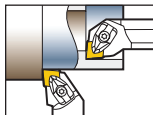
**MF / GC1115**

ISO/
ANSI**S F****ZAVRŠNA OBRADA SUPER LEGURA**

Negativne pločice



KATALOŠKA OZNAKA			REŽIMI OBRADE, CMC 20.22/HB 350							
Dvostrane pločice		r_c				Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)		
			S05F	GC1105	GC1115			S05F	GC1105	GC1115
	CNMG 12 04 04-MF	☆	★	☆	0.4 (0.1-1.5)	0.1 (0.05-0.2)	90	80	65	
	12 04 08-MF	☆	★	☆	0.4 (0.1-1.5)	0.15 (0.1-0.3)	85	80	65	
	CNGP 12 04 02		★	☆	0.3 (0.05-1)	0.1 (0.05-0.15)		80	65	
	12 04 04	☆	★	☆	0.6 (0.1-1.3)	0.11 (0.06-0.15)	90	80	65	
	12 04 08	☆	★	☆	0.6 (0.2-1.3)	0.17 (0.1-0.25)	80	75	60	
	DNMG 15 06 04-MF	☆	★	☆	0.4 (0.1-1.5)	0.1 (0.05-0.2)	90	80	65	
	15 06 08-MF	☆	★	☆	0.4 (0.1-1.5)	0.15 (0.1-0.3)	85	80	65	
	DNGP 15 04 04		★	☆	0.17 (0.1-0.25)	0.1 (0.05-0.15)		80	65	
	15 04 08		★	☆	0.17 (0.1-0.25)	0.3 (0.15-0.5)		75	60	
	15 06 04	☆	★		0.17 (0.1-0.25)	0.1 (0.05-0.15)	90	80		
	15 06 08	☆	★		0.3 (0.15-0.5)	0.17 (0.1-0.25)	80	75		
	VNMG 16 04 04-MF	☆	★	☆	0.4 (0.1-1.5)	0.1 (0.05-0.2)	90	80	65	
	16 04 08-MF	☆	★	☆	0.4 (0.2-1.5)	0.1 (0.05-0.25)	90	80	65	
	VNGP 16 04 04	☆	★	☆	0.17 (0.1-0.25)	0.1 (0.05-0.15)	90	80	65	
	16 04 08	☆	★	☆	0.3 (0.15-0.5)	0.17 (0.1-0.25)	80	75	60	
	WNMG 08 04 08-MF	☆	★	☆	0.4 (0.1-1.5)	0.15 (0.1-0.3)	85	80	65	
	WNGP 08 04 04		★		0.6 (0.1-1.3)	0.11 (0.06-0.15)		80		
	08 04 08		★		0.6 (0.2-1.3)	0.17 (0.1-0.25)		75		



SREDNJA OBRADA SUPER LEGURA

Vatrootporne i super legure

ISO/
ANSI

S

M

T-MAX P

Dvostrane
pločice

CNMG 12 04 08-23

$a_p = 0.36 - 3.6$ mm

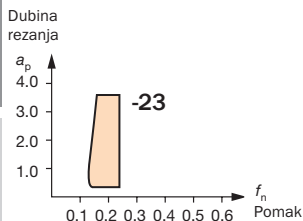
$f_n = 0.13 - 0.24$ mm/obr

-23 – od fine do srednje obrade

Operacije: uzdužno i čeonu struganje, profilisanje

Komponente: obični polufina i fina obrada nerđajućih čelika i HRSA

Prednosti: oštra, pozitivna geometrija koja generiše male sile rezanja. Omogućava obradu vitkih osovinu, tankozidnih komponenti i loše stegnutih pripremak. Pozitivna geometrija smanjuje izgled za stvaranje naslaga na reznjivoj ivici, ostvarujući dobar kvalitet obrađene površine i dugu postojanost.

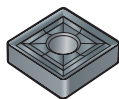


DOBRI USLOVI OBRADJE



- Kontinualan rez.
- Predobrađena površina

NORMALAN POMAK



-23 / GC1105

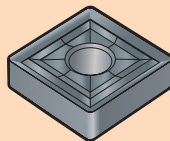
SREDNJI USLOVI OBRADJE

Prvi izbor



Opšte operacije.

NORMALAN POMAK



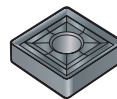
-23 / GC1105

TEŠKI USLOVI OBRADJE



- Prekidan rez.
- Teški uslovi, kora kod otkovaka

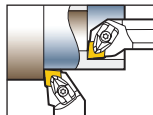
NORMALAN POMAK













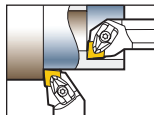
-23 / H13A

ISO/
ANSI**S M****SREDNJA OBRADA SUPER LEGURA**

Negativne pločice



KATALOŠKA OZNAKA			REŽIMI OBRADE, CMC 20.22/HB 350						
Dvostrane pločice		 r_c				Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)	
			GC1105	GC1105	H13A			GC1105	H13A
	CNMG 12 04 04-23	☆	★	☆	1.5 (0.18-3.6)	0.14 (0.1-0.18)	80	40	
	12 04 08-23	☆	★	☆	2.4 (0.36-3.6)	0.18 (0.13-0.24)	75	40	
	12 04 12-23	☆	★	☆	2.4 (0.43-3.6)	0.22 (0.16-0.29)	65	35	
	DNMG 15 06 04-23	☆	★	☆	1.5 (0.18-3.6)	0.14 (0.1-0.18)	80	40	
	15 06 08-23	☆	★	☆	2.4 (0.36-3.6)	0.18 (0.13-0.5)	75	40	
	15 06 12-23	☆	★	☆	2.4 (0.43-3.6)	0.22 (0.16-0.29)	65	35	
	SNMG 12 04 04-23			★	1.5 (0.2-3.6)	0.14 (0.1-0.18)		40	
	12 04 08-23	☆	★	☆	2.4 (0.36-3.6)	0.18 (0.13-0.24)	75	40	
	12 04 12-23	☆	★	☆	2.4 (0.43-3.6)	0.22 (0.16-0.29)	65	35	
	TNMG 16 04 04-23	☆	★	☆	2 (0.15-3)	0.11 (0.08-0.15)	80	40	
	16 04 08-23	☆	★	☆	2 (0.3-3)	0.15 (0.11-0.2)	80	40	
	16 04 12-23	☆	★	☆	2 (0.36-3)	0.18 (0.13-0.24)	75	40	
	22 04 08-23	☆	★	☆	2.4 (0.36-3.6)	0.18 (0.13-0.24)	75	40	
	22 04 12-23	☆	★	☆	2.4 (0.43-3.6)	0.22 (0.16-0.29)	65		
	VNMG 16 04 04-23	☆	★	☆	2 (0.4-4)	0.15 (0.1-0.2)	80	40	
	16 04 08-23	☆	★	☆	2.5 (0.5-4)	0.2 (0.15-0.25)	70	35	
	WNMG06 04 04-23	☆	★	☆	2 (0.5-3)	0.15 (0.1-0.3)	80	40	
	06 04 08-23	☆	★	☆	2.5 (0.7-4)	0.25 (0.2-0.35)	60	35	
	08 04 04-23	☆	★	☆	2.5 (0.5-4)	0.15 (0.1-0.3)	80	40	
	08 04 08-23	☆	★	☆	2.5 (0.7-4)	0.25 (0.2-0.35)	60	35	



GRUBA OBRADA SUPER LEGURA

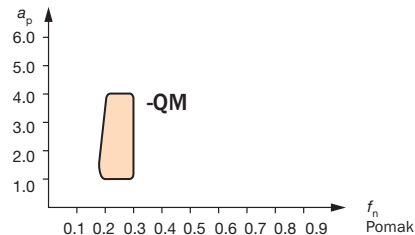
Vatrootporne i super legure, HB 350

ISO/
ANSI**S****R**

T-MAX P

Dvostrane
pločice

CNMG 12 04 08-QM

 $a_p = 0.96 - 4.0$ mm $f_n = 0.18 - 0.3$ mm/obr**-QM****Operacije:** uzdužno i čeonu struganje, profilisanje**Komponente:** obično za univerzalne operacije na nerđajućem čeliku i HRSA**Prednosti:** široka primena za polu finu do polu grube obrade za različite materijale, dostupna u mnogo kvalitetaDubina
rezanja

DOBRI USLOVI OBRADJE



- Kontinualan rez.
- Predobrađena površina

NORMALAN POMAK

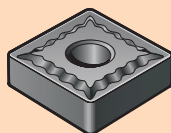
**-QM / 1105**

SREDNJI USLOVI OBRADJE



Opšte operacije.

NORMALAN POMAK

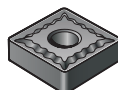
**-QM / GC1115**

TEŠKI USLOVI OBRADJE



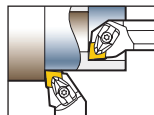
- Prekidan rez.
- Teški uslovi, kora kod otkovaka











NORMALAN POMAK

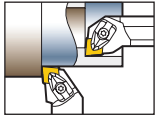
**-QM / H13A**

ISO/
ANSI**S R****GRUBA OBRADA SUPER LEGURA**

Negativne pločice



KATALOŠKA OZNAKA			REŽIMI OBRADE, CMC 20.22/HB 350							
Dvostrane pločice  r_c			 GC1105	 GC1115	 H13A	Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)		
								GC1105	GC1115	H13A
	CNMG	12 04 04-QM	★	☆	☆	1.5 (0.48-4)	0.18 (0.14-0.23)	75	60	40
		12 04 08-QM	★	☆	☆	2.4 (0.96-4)	0.22 (0.18-0.3)	65	55	35
		12 04 12-QM	★	☆	☆	2.4 (1.2-4)	0.25 (0.2-0.34)	60	50	35
		12 04 16-QM	★	☆	☆	2.4 (1.3-4)	0.28 (0.23-0.38)	55	45	30
		16 06 08-QM			★	3 (1-6)	0.25 (0.2-0.35)			35
		16 06 12-QM	★	☆	☆	3 (1-6)	0.3 (0.25-0.4)	50	40	30
	DNMG	15 06 04-QM	★	☆	☆	2.4 (1-4)	0.2 (0.18-0.3)		55	35
		15 06 08-QM	★	☆	☆	2.4 (0.96-4)	0.22 (0.18-0.3)	65	55	35
		15 06 12-QM	★	☆	☆	2.4 (1.2-4)	0.25 (0.2-0.34)	60	50	35
	SNMG	09 03 08-QM			★	2.5 (1-3)	0.25 (0.2-0.3)			35
		12 04 08-QM	★	☆	☆	2.4 (0.96-4)	0.22 (0.18-0.3)	65	55	35
		12 04 12-QM	★	☆	☆	2.4 (1-4)	0.24 (0.19-0.32)	65	50	35
		12 04 16-QM	★	☆	☆	2.4 (1.2-4)	0.35 (0.3-0.4)	45	35	25
	TNMG	16 04 04-QM			★	2 (1-3.5)	0.2 (0.18-0.23)			35
		16 04 08-QM	★	☆	☆	2 (1-3.5)	0.18 (0.15-0.25)	75	60	40
		16 04 12-QM	★	☆		2 (1-3.5)	0.21 (0.17-0.28)	70	55	
		22 04 04-QM			★	3 (1-5)	0.2 (0.18-0.25)			35
		22 04 08-QM			★	3 (1-5)	0.25 (0.2-0.3)			35
		22 04 12-QM			★	3 (1-5)	0.3 (0.25-0.35)			30
	VNMG	16 04 04-QM	★	☆	☆	0.9 (0.4-2)	0.13 (0.1-0.17)		65	40
		16 04 08-QM	★	☆	☆	1.1 (0.8-2)	0.18 (0.15-0.22)	75	60	40
	WNMG	08 04 04-QM	★	☆	☆	2.1 (0.8-3.5)	0.18 (0.15-0.23)	75	60	40
		08 04 08-QM	★	☆	☆	2.1 (0.8-3.5)	0.2 (0.16-0.3)	70	55	35
		08 04 12-QM	★	☆	☆	2.1 (1-3.5)	0.25 (0.18-0.34)	60	50	35



ZAVRŠNA OBRADA KALJENIH ČELIKA

Kaljeni materijali, HRC 60

ISO/
ANSI

H

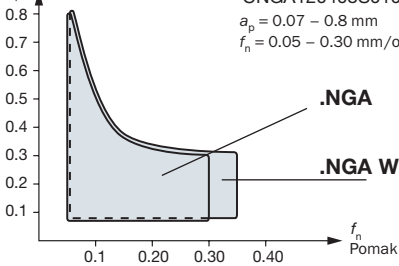
F

T-MAX P

CNGA120408T01030AWH

 $a_p = 0.07 - 0.8$ mm $f_n = 0.05 - 0.35$ mm/obr

CNGA120408S01030A

 $a_p = 0.07 - 0.8$ mm $f_n = 0.05 - 0.30$ mm/obrDubina
rezanja a_p 

.NGA

.NGA WH

 f_n
Pomak

.NGA

Operacije: uzdužno i čeono struganje, profilisanje.**Komponente:** Kaljena kućišta i drugi pogonski elementi**Prednosti:** odlična završna obrada kaljenih materijala. Uštede u poređenju sa brušenjem.

Konfiguracija oborene ivice

S-tip

Oborena ivica
sa honovan-
jem

T-tip

Oborena ivica
bez honovanja

DOBRI USLOVI OBRADJE



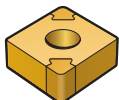
- Kontinualan rez.
- Predobrađena površina.

VELIKI POMAK



.NGA WH / CB7015

NORMALAN POMAK



.NGA / CB7015

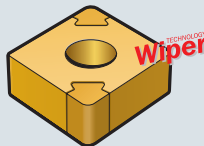
Prvi izbor

SREDNJI USLOVI OBRADJE



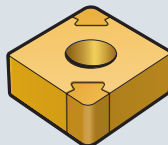
- Kontinualan ili lako preki-
dan rez.
- Površine visokog kvaliteta.

VELIKI POMAK



.NGA WH / CB7015

NORMALAN POMAK



.NGA / CB7015

TEŠKI USLOVI OBRADJE



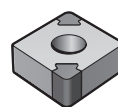
- Prekidan rez.

VELIKI POMAK

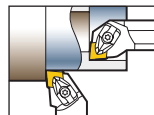


.NGA WH / CB7025



















NORMALAN POMAK

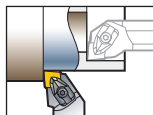


.NGA / CB7025

ISO/
ANSI**H F****ZAVRŠNA OBRADA KALJENIH ČELIKA**

Negativne pločice

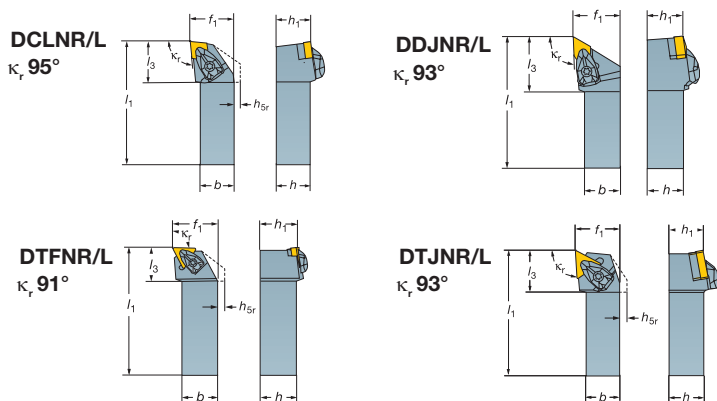
KATALOŠKA OZNAKA			REŽIMI OBRADE, CMC 04.1 / HRC 60						
Dvostrane pločice  r_c			 CB7015	 CB7015	 CB7025	Brzina rezanja v_c (m/min)			
						Dubina rezanja a_p mm	Pomak f_n mm/obr	CB7015	CB7025
	CNGA	12 04 04 T01030AWH	☆	★		0.1 (0.07-0.4)	0.18 (0.05-0.25)	180	
		12 04 08 T01030AWH	☆	★		0.1 (0.07-0.8)	0.28 (0.05-0.35)	155	
		12 04 12 T01030AWH	☆	★		0.2 (0.07-1.2)	0.32 (0.05-0.4)	145	
	CNGA	12 04 04 S01030AWH			★	0.1 (0.07-0.4)	0.18 (0.05-0.25)		145
		12 04 08 S01030AWH			★	0.1 (0.07-0.8)	0.28 (0.05-0.35)		130
		12 04 12 S01030AWH			★	0.2 (0.07-1.2)	0.32 (0.05-0.4)		125
	WNGA	08 04 04 T01030AWH	☆	★		0.1 (0.07-0.4)	0.18 (0.05-0.25)	180	
		08 04 08 T01030AWH	☆	★		0.1 (0.07-0.8)	0.28 (0.05-0.35)	155	
		08 04 12 T01030AWH	☆	★		0.2 (0.07-1.2)	0.32 (0.05-0.4)	145	
	WNGA	08 04 04 S01030AWH			★	0.1 (0.07-0.4)	0.18 (0.05-0.25)		145
		08 04 08 S01030AWH			★	0.1 (0.07-0.8)	0.28 (0.05-0.35)		130
		08 04 12 S01030AWH			★	0.2 (0.07-1.2)	0.32 (0.05-0.4)		125
	CNGA	12 04 04 S01030A	☆	★		0.1 (0.07-0.4)	0.1 (0.05-0.2)	215	
		12 04 08 S01030A	☆	★		0.2 (0.07-0.8)	0.15 (0.05-0.3)	190	
		12 04 12 S01030A	☆	★		0.2 (0.07-1.2)	0.2 (0.05-0.3)	175	
	CNGA	12 04 04 S01030A			★	0.1 (0.07-0.4)	0.1 (0.05-0.2)		165
		12 04 08 S01030A			★	0.2 (0.07-0.8)	0.15 (0.05-0.3)		150
		12 04 12 S01030A			★	0.2 (0.07-1.2)	0.2 (0.05-0.3)		140
	DNGA	15 04 04 S01030A	☆	★		0.1 (0.07-0.4)	0.1 (0.05-0.2)	215	
		15 04 08 S01030A	☆	★		0.2 (0.07-0.8)	0.15 (0.05-0.3)	190	
		15 04 12 S01030A	☆	★		0.2 (0.07-1.2)	0.2 (0.05-0.3)	175	
	DNGA	15 04 04 S01030A			★	0.1 (0.07-0.4)	0.1 (0.05-0.2)		165
		15 04 08 S01030A			★	0.2 (0.07-0.8)	0.15 (0.05-0.3)		150
		15 04 12 S01030A			★	0.2 (0.07-1.2)	0.2 (0.05-0.3)		140
	SNGA	12 04 08 S01030A	☆	★		0.2 (0.07-0.8)	0.15 (0.05-0.3)	190	
		12 04 12 S01030A	☆	★		0.2 (0.07-1.2)	0.2 (0.05-0.3)	175	
	SNGA	12 04 08 S01030A			★	0.2 (0.07-0.8)	0.15 (0.05-0.3)		150
		12 04 12 S01030A			★	0.2 (0.07-1.2)	0.2 (0.05-0.3)		140
	TNGA	16 04 04 S01030A	☆	★		0.1 (0.07-0.4)	0.1 (0.05-0.2)	215	
		16 04 08 S01030A	☆	★		0.2 (0.07-0.8)	0.15 (0.05-0.3)	190	
		16 04 12 S01030A	☆	★		0.2 (0.07-1.2)	0.2 (0.05-0.3)	175	
	TNGA	16 04 04 S01030A			★	0.1 (0.07-0.4)	0.1 (0.05-0.2)		165
		16 04 08 S01030A			★	0.2 (0.07-0.8)	0.15 (0.05-0.3)		150
		16 04 12 S01030A			★	0.2 (0.07-1.2)	0.2 (0.05-0.3)		140
	WNGA	08 04 04 S01030A	☆	★		0.1 (0.07-0.4)	0.1 (0.05-0.2)	215	
		08 04 08 S01030A	☆	★		0.2 (0.07-0.8)	0.15 (0.05-0.3)	190	
		08 04 12 S01030A	☆	★		0.2 (0.07-1.2)	0.2 (0.05-0.3)	175	
	WNGA	08 04 04 S01030A			★	0.1 (0.07-0.4)	0.1 (0.05-0.2)		165
		08 04 08 S01030A			★	0.2 (0.07-0.8)	0.15 (0.05-0.3)		150
		08 04 12 S01030A			★	0.2 (0.07-1.2)	0.2 (0.05-0.3)		140



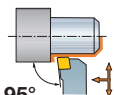
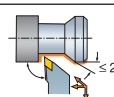
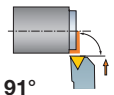
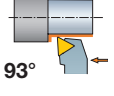


Spoljašnja obrada sa T-MAX P, negativnim pločicama

Drške u veličinama 1616 – 3232

CoroTurn® RC stabilan sistem stezanja



Desna verzija prikazana

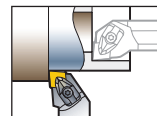
Pločica	Kataloška oznaka	Dimenzije, mm								Nm		
		h	h ₁	b	l ₁	l ₃	f ₁	h _{sr}	r _ε ¹⁾			
 95°	C	DCLNR/L 1616H09	16	16	16	100	24.8	20	–	0.8	9IP 1.7	
		2020K09	20	20	20	125	24.8	25	–	0.8		
		2525M09	25	25	25	150	24.8	32	–	0.8		
		DCLNR/L 1616H12	16	16	16	100	32.2	20	4.5	0.8		15IP 3.9
		2020K12	20	20	20	125	32.0	25	–	0.8		
 93°	D	2525M12	25	25	25	150	32.0	32	–	0.8	20IP 6.4	
		3225P12	32	32	25	170	32.0	32	–	0.8		
		DCLNR/L 2525M16	25	25	25	150	39.0	32	–	1.2		20IP 6.4
		3225P16	32	32	25	170	39.0	32	–	1.2		
		DCLNR/L 2525M19	25	25	25	150	43.7	32	1.0	1.2		20IP 6.4
3225P19	25	32	25	170	43.2	32	–	1.2				
 93°	D	3225P19	32	32	32	170	43.4	40	–	–	9IP 1.7	
		DDJNR/L 1616H11	16	16	16	100	30.1	20	–	0.8		
		2020K11	20	20	20	125	30.1	25	–	0.8		
		2525M11	25	25	25	150	30.2	32	–	0.8		
		3225P11	32	32	25	170	30.2	32	–	0.8		
 91°	T	DDJNR/L 2020K15	20	20	20	125	39.4	25	–	0.8	15IP 3.9	
		2525M15	25	25	25	150	39.4	32	–	0.8		
		3225P15	32	32	25	170	39.4	32	–	0.8		
		DTFNR/L 1616H16	16	16	16	100	24.0	20	2.0	0.8		9IP 1.7
		2020K16	20	20	20	125	23.6	25	–	0.8		
 93°	T	2525M16	25	25	25	150	23.6	32	–	0.8	15IP 3.9	
		3225P16	32	32	25	170	24.1	32	–	0.8		
		DTFNR/L 2525M22	25	25	25	150	31.1	32	–	0.8		
		3225P22	32	32	25	170	31.1	32	–	0.8		
		3232P22	32	32	32	170	31.1	40	–	0.8		
 93°	T	DTJNR/L 1616H16	16	16	16	100	24.9	20	1.0	0.8	9IP 1.7	
		2020K16	20	20	20	125	24.9	25	–	0.8		
		2525M16	25	25	25	150	24.9	32	–	0.8		
		3225P16	32	32	25	170	25.3	32	–	0.8		
		DTJNR/L 2525M22	25	25	25	150	32.6	32	–	0.8		15IP 3.9
3225P22	32	32	25	170	32.6	32	–	0.8				
3232P22	32	32	32	170	32.6	40	–	0.8				

¹⁾ r_ε = radijus vrha rezne pločice

Primer poručivanja: 2 komada DCLNR 1616H09

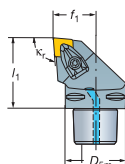
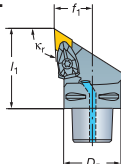
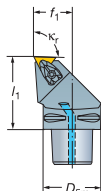
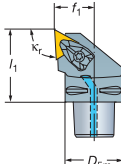
(R = Desna verzija, L = Leva verzija)

Spoljšanja obrada sa T-MAX P, negativnim pločicama


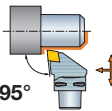
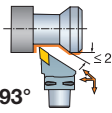
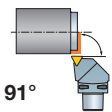
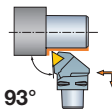


Coromant Capto u veličinama C4 – C6

CoroTurn® RC stabilan sistem stezanja

DCLNR/L $\kappa_r 95^\circ$ **DDJNR/L** $\kappa_r 93^\circ$ **DTFNR/L** $\kappa_r 91^\circ$ **DTJNR/L** $\kappa_r 93^\circ$ 

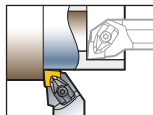
Desna verzija prikazana

	Pločica	Veličina	Kataloška oznaka	Dimenzije, mm						
				D_{5m}	l_1	f_1	$r_s^{1)}$			
 95°	C	09	C4	C4-DCLNR/L -27050-09	40	50	27	0.8	9IP 1.7	
		12	C4	C4-DCLNR/L -27050-12	40	50	27	0.8	15IP 3.9	
			C5	C5-DCLNR/L -35060-12	50	60	35	0.8		
			C6	C6-DCLNR/L -45065-12	63	65	45	0.8		
			16	C4	C4-DCLNR/L -27055-16	40	55	27	1.2	20IP 6.4
			C5	C5-DCLNR/L -35060-16	50	60	35	1.2		
			C6	C6-DCLNR/L -45065-16	63	65	45	1.2		
			19	C5	C5-DCLNR/L -35060-19	50	60	35	1.2	
	C6	C6-DCLNR/L -45065-19	63	65	45	1.2				
 93°	D	11	C4	C4-DDJNR/L -27050-11	40	50	27	0.8	9IP 1.7	
			C5	C5-DDJNR/L -35060-11	50	60	35	0.8		
			C6	C6-DDJNR/L -45065-11	63	65	45	0.8		
			15	C4	C4-DDJNR/L -27055-15	40	55	27	0.8	15IP 3.9
			C5	C5-DDJNR/L -35060-15	50	60	35	0.8		
			C6	C6-DDJNR/L -45065-15	63	65	45	0.8		
 91°	T	16	C4	C4-DTFNR/L -27050-16	40	50	27	0.8	9IP 1.7	
			C5	C5-DTFNR/L -35060-16	50	60	35	0.8		
			C6	C6-DTFNR/L -45065-16	63	65	45	0.8		
			22	C4	C4-DTFNR/L -27050-22	40	50	27	0.8	15IP 3.9
			C5	C5-DTFNR/L -35060-22	50	60	35	0.8		
			C6	C6-DTFNR/L -45065-22	63	65	45	0.8		
 93°	T	16	C4	C4-DTJNR/L -27050-16	40	50	27	0.8	9IP 1.7	
			C5	C5-DTJNR/L -35060-16	50	60	35	0.8		
			C6	C6-DTJNR/L -45065-16	63	65	45	0.8		
			22	C4	C4-DTJNR/L -27050-22	40	50	27	0.8	15IP 3.9
			C5	C5-DTJNR/L -35060-22	50	60	35	0.8		
			C6	C6-DTJNR/L -45065-22	63	65	45	0.8		

¹⁾ r_s = radijus vrha rezne pločice

Primer poručivanja: 2 komada C4-DCLNR-27050-09

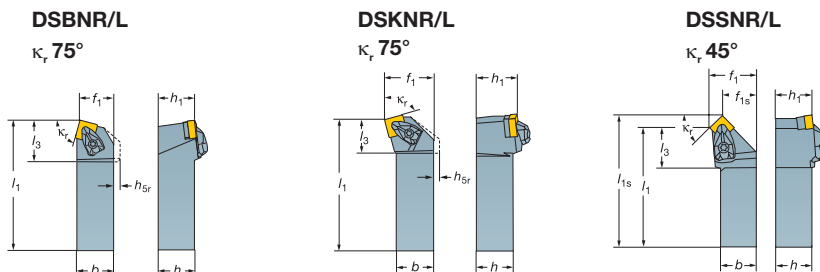
(R = Desna verzija, L = Leva verzija)



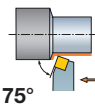
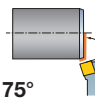
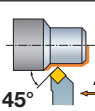
Spoljašnja obrada sa T-MAX P, negativnim ploščama

Drške u veličinama 1616 – 3232

CoroTurn® RC stabilan sistem stezanja



Desna verzija prikazana

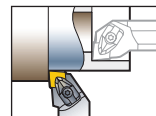
Pločica	Kataloška oznaka	Dimenzije, mm										Nm			
		h	h ₁	b	l ₁	l _{1s}	l ₃	f ₁	f _{1s}	h _{5r}	r _ε ¹⁾				
 75°	S	09	DSBNR/L 1616H09	16	16	16	100	-	26.7	13	-	1.0	0.8	9IP	1.7
			2020K09	20	20	20	125	-	26.7	17.4	-	-	0.8	15IP	3.9
			2525M09	25	25	25	150	-	26.7	22	-	-	0.8	20IP	6.4
	S	12	DSBNR/L 2020K12	20	20	20	125	-	34.2	17	-	-	0.8	15IP	3.9
			2525M12	25	25	25	150	-	34.3	22	-	-	0.8	20IP	6.4
S		3225P12	32	32	25	170	-	34.3	22	-	-	0.8	20IP	6.4	
	15	DSBNR/L 2525M15	25	25	25	150	-	41.6	22	-	-	1.2	20IP	6.4	
		3225P15	32	32	25	170	-	41.7	22	-	-	1.2	20IP	6.4	
		3232P15	32	32	32	170	-	41.5	27	-	-	1.2	20IP	6.4	
S		3232P19	32	32	32	170	-	46.4	27	-	-	1.2	20IP	6.4	
	 75°	09	DSKNR/L 2020K09	20	20	20	125	-	18.2	25	-	-	0.8	9IP	1.7
		12	DSKNR/L 2020K12	20	20	20	125	-	23.6	25	-	4.5	0.8	15IP	3.9
			2525M12	25	25	25	150	-	23.6	32	-	-	0.8	20IP	6.4
		3225P12	32	32	25	170	-	23.5	32	-	-	0.8	20IP	6.4	
S		3232P15	32	32	32	170	-	28.9	40	-	-	1.2	20IP	6.4	
	15	DSKNR/L 3232P15	32	32	32	170	-	32.1	40	-	-	1.2	20IP	6.4	
	19	DSKNR/L 3232P19	32	32	32	170	-	32.1	40	-	-	1.2	20IP	6.4	
	 45°	S	09	DSSNR/L 1616H09	16	16	16	100	106.1	21.3	20	13.9	-	0.8	9IP
			2020K09	20	20	20	125	131.1	21.3	25	18.9	-	0.8	15IP	3.9
			2525M09	25	25	25	150	156.1	21.3	32	25.9	-	0.8	20IP	6.4
S		12	DSSNR/L 2020K12	20	20	20	125	133.3	28.8	25	16.7	-	0.8	15IP	3.9
			2525M12	25	25	25	150	158.3	28.8	32	23.7	-	0.8	20IP	6.4
			3225P12	32	32	25	170	178.3	28.8	32	23.7	-	0.8	20IP	6.4
S			3232P12	32	32	32	170	178.3	27.4	40	31.7	-	0.8	20IP	6.4
		15	DSBNR/L 2525M15	25	25	25	150	160.2	34.9	32	21.8	-	1.2	20IP	6.4
			3225P15	25	32	25	170	180.2	34.9	32	21.8	-	1.2	20IP	6.4
S			3232P15	32	32	32	170	180.2	34.9	40	29.8	-	1.2	20IP	6.4
		19	DSBNR/L 3232P19	32	32	32	170	182.5	35.9	40	27.5	-	1.2	20IP	6.4

¹⁾ r_ε = radijus vrha rezne pločice

Primer poručivanja: 2 komada DSBNR 1616H09

(R = Desna verzija, L = Leva verzija)

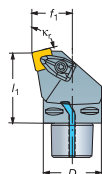
Spoljašnja obrada sa T-MAX P, negativnim pločicama



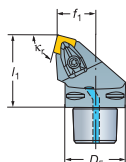
Coromant Capto u veličinama C4 – C6

CoroTurn® RC stabilan sistem stezanja

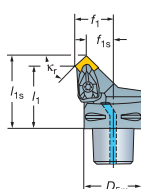
DSKNR/L

 $\kappa_r 75^\circ$ 

DSRRR/L

 $\kappa_r 75^\circ$ 

DSSNR/L

 $\kappa_r 45^\circ$ 

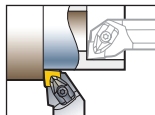
Desna verzija prikazana

	Pločica	Veličina	Kataloška oznaka	Dimenzije, mm						Nm	
				D_{5m}	l_1	l_{1s}	f_1	f_{1s}	$r_c^{1)}$		
 75°	S	12	C4	C4-DSKNR/L -27050-12	40	50	-	27	-	0.8	15IP 3.9
		C5	C5-DSKNR/L -35060-12	50	60	-	35	-	0.8		
		C6	C6-DSKNR/L -45065-12	63	65	-	45	-	0.8		
		15	C5	C5-DSKNR/L -35060-15	50	60	-	35	-	1.2	20IP 6.4
		C6	C6-DSKNR/L -45065-15	63	65	-	45	-	1.2		
		19	C5	C5-DSKNR/L -35060-19	50	60	-	35	-	1.2	20IP 6.4
C6	C6-DSKNR/L -45065-19	63	65	-	45	-	1.2				
 75°	S	12	C4	C4-DSRRR/L -22050-12	40	50	-	22	-	0.8	15IP 3.9
		C5	C5-DSRRR/L -27060-12	50	60	-	27	-	0.8		
		C6	C6-DSRRR/L -35065-12	63	65	-	35	-	0.8		
		15	C5	C5-DSRRR/L -27060-15	50	60	-	27	-	1.2	20IP 6.4
		C6	C6-DSRRR/L -35065-15	63	65	-	35	-	1.2		
		19	C5	C5-DSRRR/L -27060-19	50	60	-	27	-	1.2	20IP 6.4
C6	C6-DSRRR/L -35065-19	63	65	-	35	-	1.2				
 45°	S	12	C4	C4-DSSNR/L -27042-12	40	42	50.3	27	18.7	0.8	15IP 3.9
		C5	C5-DSSNR/L -35052-12	50	52	60.3	35	26.7	0.8		
		C6	C6-DSSNR/L -45056-12	63	56	64.3	45	36.7	0.8		
		15	C4	C4-DSSNR/L -27045-15	40	45	55.2	27	16.8	1.2	20IP 6.4
		C5	C5-DSSNR/L -35050-15	50	50	60.2	35	24.8	1.2		
		C6	C6-DSSNR/L -45054-15	63	54	64.2	45	34.8	1.2		
		19	C5	C5-DSSNR/L -35048-19	50	48	60.5	35	24.8	1.2	
		C6	C6-DSSNR/L -45052-19	63	52	64.5	45	34.8	1.2		

¹⁾ r_c = radijus vrha rezne pločice

Primer poručivanja: 2 komada C4-DSKNR-27050-12

(R = Desna verzija, L = Leva verzija)



Spoljašnja obrada sa T-MAX P, negativnim pločicama

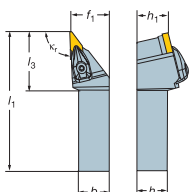
Drške u veličinama 1616 – 3225

CoroTurn® RC stabilan sistem stezanja

T-Max P stezanje klinom i polugom

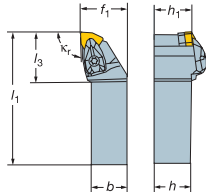
DVJNR/L

$\kappa_r 93^\circ$



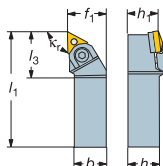
DWLNR/L

$\kappa_r 95^\circ$


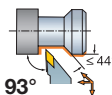


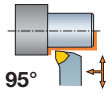


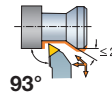





MTJNR/L

$\kappa_r 93^\circ$



Desna verzija prikazana

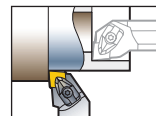
	Pločica	Kataloška oznaka	Dimenzije, mm							$r_s^{1)}$	 Nm
			h	h_1	b	l_1	l_3	f_1			
 <p>93° $\leq 44^\circ$</p>	 <p>16 V</p>	DVJNR/L 2020K16	20	20	20	125	46.6	25	0.8	 15IP 3.0	
		DVJNR/L 2525M16	25	25	25	150	46.6	32	0.8		
		DVJNR/L 3225P16	32	32	25	170	46.6	32	0.8		
		DVJNR/L 3232P16	32	32	32	170	46.6	40	0.8		
 <p>95°</p>	 <p>06 W</p>	DWLNR/L 1616H06	16	16	16	100	26.4	20	0.8	 9IP 1.7	
		DWLNR/L 2020K06	20	20	20	125	27.1	25	0.8		
		DWLNR/L 2525M06	25	25	25	150	27.1	32	0.8		
		DWLNR/L 3225M06	32	32	25	150	27.1	32	0.8		
 <p>93° $\leq 22^\circ$</p>	 <p>16 T</p>	MTJNR/L 2020K16M1	20	20	20	125	30.8	25	0.8	 2.5 mm	
		MTJNR/L 2525M16M1	25	25	25	150	30.8	32	0.8		
		MTJNR/L 3225P16M1	32	32	25	170	30.8	32	0.8		
		MTJNR/L 2525M22M1	25	25	25	150	34.8	32	0.8		
		MTJNR/L 3225P22M1	32	32	25	170	34.8	32	0.8	 3.0 mm	

¹⁾ r_s = radius vrha rezne pločice

Primer poručivanja: 2 komada DVJNR 2020K16

(R = Desna verzija, L= Leva verzija)

Spoljašnja obrada sa T-MAX P, negativnim pločicama

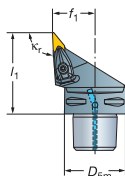


Coromant Capto u veličinama C4 – C6

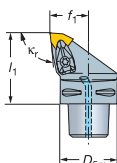
CoroTurn® stabilan sistem stezanja

T-Max P stezanje klinom i polugom

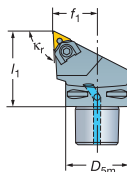
DVJNR/L

 $\kappa_r 93^\circ$ 

DWLNR/L

 $\kappa_r 95^\circ$ 

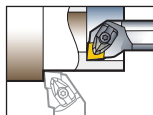
MTJNR/L

 $\kappa_r 93^\circ$ 

Desna verzija prikazana

	Pločica	Veličina	Kataloška oznaka	Dimenzije, mm				Nm		
				D_{sm}	l_1	f_1	$r_s^{1)}$			
 93°	 16 V	C4	C4-DVJNR/L -27062-16	40	62	27	0.8	15IP 3.0		
		C5	C5-DVJNR/L -35065-16	50	65	35	0.8			
		C6	C6-DVJNR/L -45065-16	63	65	45	0.8			
 95°	 06 08 W	C4	C4-DWLNR/L-27050-06	40	50	27	0.8	9IP 1.7		
		C5	C5-DWLNR/L-35060-06	50	60	35	0.8			
		C6	C6-DWLNR/L-45065-06	63	65	45	0.8			
				C4	C4-DWLNR/L-27050-08	40	50	27	0.8	15IP 3.9
				C5	C5-DWLNR/L-35060-08	50	60	35	0.8	
				C6	C6-DWLNR/L-45065-08	63	65	45	0.8	
 93°	 16 T	C4	C4-MTJNR/L -27050-16	40	50	27	0.8	2.5 mm		
		C5	C5-MTJNR/L -35060-16	50	60	35	0.8			

¹⁾ r_s = radijus vrha rezne pločicePrimer poručivanja: 2 komada C4-DVJNR-27062-16
(R = Desna verzija, L = Leva verzija)



Unutrašnja obrada sa T-MAX P, negativnim ploščicama

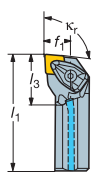
Prečnik drške 25 – 40 mm

CoroTurn® RC stabilan sistem stezanja

Cilindrična drška sa ravnim delom za stezanje

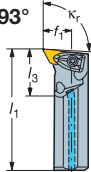
DCLNR/L

κ_r 95°



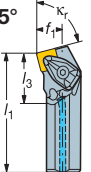
DDUNR/L

κ_r 93°



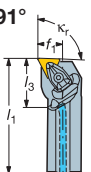
DSKNR/L

κ_r 75°



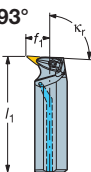
DTFNR/L

κ_r 91°



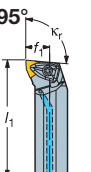
DVUNR/L

κ_r 93°



DWLNRL


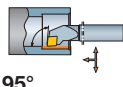
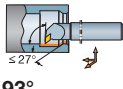
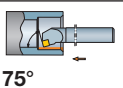
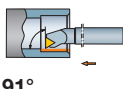
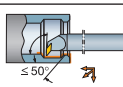
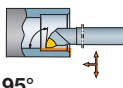
κ_r 95°



Sa hlađenjem kroz dršku alata

Maksimalan prepusat 4 x dm_m

Desna verzija prikazana

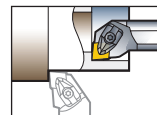
	Pločica	Kataloška oznaka	Dimenzije, mm				l_1	l_3	$r_6^{1)}$		Nm
			dm_m	$D_{m \min}$	f_1	h					
 95°	C	A25T- DCLNR/L09	25	32	17	23	300	31	0.8	9IP	1.7
		A25T- DCLNR/L12	25	32	17	23	300	31	0.8	15IP	3.9
		A32T- DCLNR/L12	32	40	22	30	300	30	0.8		
		A40T- DCLNR/L12	40	50	27	37	300	32	0.8		
 93°	D	A25T- DDUNR/L11	25	32	17	23	300	28	0.8	9IP	1.7
		A32T- DDUNR/L11	32	40	22	30	300	30	0.8		
		A40T- DDUNR/L15	40	50	27	37	300	36	0.8	15IP	3.9
 75°	S	A25T- DSKNR/L09	25	32	17	23	300	30	0.8	9IP	1.7
		A25T- DSKNR/L12	25	32	17	23	300	30	0.8	15IP	3.9
		A32T- DSKNR/L12	32	40	22	30	300	33	0.8		
		A40T- DSKNR/L12	40	50	27	37	300	34	0.8		
 91°	T	A25T- DTFNR/L16	25	32	17	23	300	32	0.8	9IP	1.7
		A32T- DTFNR/L16	32	40	22	30	300	33	0.8		
		A40T- DTFNR/L16	40	50	27	37	300	36	0.8	15IP	3.9
 93°	V	A40T-DVUNR/L16	40	50	27	37	300	36	0.8	15IP	3.0
 95°	W	A25T-DWLNRL/L06	25	32	17	23	300	31	0.8	9IP	1.7
		A32T-DWLNRL/L06	32	40	22	30	300	33	0.8		
		A40T-DWLNRL/L06	40	50	27	37	300	36	0.8		
	08	A25T-DWLNRL/L08	25	33	17	23	300	31	0.8	15IP	3.9
		A32T-DWLNRL/L08	32	40	22	30	300	33	0.8		
A40T-DWLNRL/L08	40	50	27	37	300	36	0.8				

¹⁾ r_6 = radijus vrha rezne pločice

Primer poručivanja: 2 komada A25T-DCLNR 09

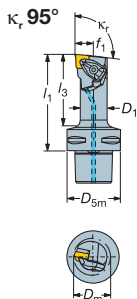
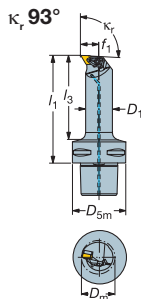
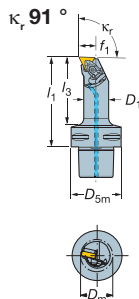
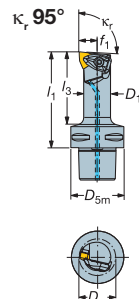
(R = Desna verzija, L = Leva verzija)

Unutrašnja obrada sa T-MAX P, negativnim pločicama

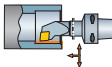
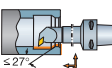
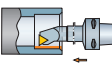
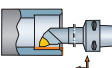


Coromant Capto u veličinama C4 – C6

CoroTurn® RC stabilan sistem stezanja

DCLNR/L**DDUNR/L****DTFNR/L****DWLNRL**

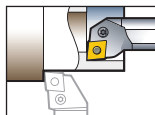
Desna verzija prikazana

95°	Pločica	Veličina	Kataloška oznaka	Dimenzije, mm							Nm
				D_m min	D_1	D_{5m}	f_1	l_1	l_3	$r_6^{1)}$	
	09	C4	C4-DCLNR/L -13080-09	25	20	40	13	80	57	0.8	9IP 1.7
		C5	C5-DCLNR/L -13080-09	25	20	50	13	80	56	0.8	
	C	C4	C4-DCLNR/L -17090-12	32	25	40	17	90	68	0.8	15IP 3.9
		C5	C5-DCLNR/L -17090-12	32	25	50	17	90	66	0.8	
		C6	C6-DCLNR/L -17100-12	32	25	63	17	100	72	0.8	
		C6	C6-DCLNR/L -27140-16	50	40	63	27	140	114	1.2	20IP 6.4
	11	C4	C4-DDUNR/L -17090-11	32	25	40	17	90	68	0.8	9IP 1.7
		C5	C5-DDUNR/L -17090-11	32	25	50	17	90	66	0.8	
	D	C4	C4-DDUNR/L -27080-15	50	39.7	40	27	80	59	0.8	15IP 3.9
		C5	C5-DDUNR/L -27140-15	50	40	50	27	140	118	0.8	
		C6	C6-DDUNR/L -27140-15	50	40	63	27	140	114	0.8	
		C6	C6-DDUNR/L -27140-15	50	40	63	27	140	114	0.8	
	16	C4	C4-DTFNR/L -17090-16	32	25	40	17	90	68	0.8	9IP 1.7
		C5	C5-DTFNR/L -17090-16	32	25	50	17	90	66	0.8	
	06 08 W	C4	C4-DWLNRL/L -13075-06	27	20	40	13	75	52	0.8	9IP 1.7
		C4	C4-DWLNRL/L -17090-08	33	25	40	17	90	68	0.8	15IP 3.9
		C5	C5-DWLNRL/L -17090-08	33	25	50	17	90	66	0.8	

¹⁾ r_6 = radijus vrha rezne pločice

Primer poručivanja: 2 komada C4-DCLNR-13080-09

(R = Desna verzija, L = Leva verzija)



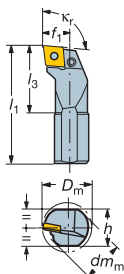
Unutrašnja obrada sa T-MAX P, negativnim ploščicama

Prečnik drške 16 – 40 mm

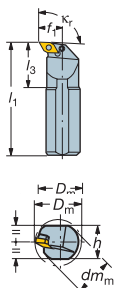
T-MAX P stezanje polugom

Cilindrična drška sa ravnim delom za stezanje

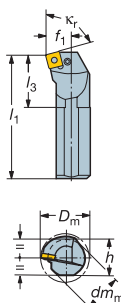
PCLNR/L

 $\kappa_r 95^\circ$ 

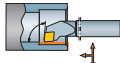
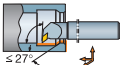
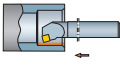
PDUNR/L

 $\kappa_r 93^\circ$ 

PSKNR/L

 $\kappa_r 75^\circ$ Maksimalan preput 4 x dm_m

Desna verzija prikazana

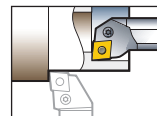
	Pločica	Kataloška oznaka	Dimenzije, mm						
			dm_m	D_m min	f_1	h	l_1	l_3	$r_\epsilon^{1)}$
 95°	C	S16R-PCLNR/L 09	16	20	11	15	200	26	0.8
		S20S-PCLNR/L 09	20	25	13	18	250	29	0.8
		S25T-PCLNR/L 09	25	32	17	23	300	33	0.8
		S25T-PCLNR/L 12	25	32	17	23	300	37	0.8
		S32U-PCLNR/L 12	32	40	22	30	350	40	0.8
S40V-PCLNR/L 12	40	50	27	37	400	56	0.8		
 93°	D	S25T-PDUNR/L 11	25	32	17	23	300	35	0.8
		S32U-PDUNR/L 11	32	40	22	30	350	40	0.8
		S40V-PDUNR/L 15	40	50	27	37	400	56	0.8
 75°	S	S25T-PSKNR/L 12	25	32	17	23	300	36.8	0.8
		S32U-PSKNR/L 12	32	40	22	30	350	37.8	0.8
		S40V-PSKNR/L 12	40	50	27	37	400	49.8	0.8

¹⁾ r_ϵ = radijus vrha rezne pločice

Primer poručivanja: 2 komada S16R-PCLNR 09

(R = Desna verzija, L= Leva verzija)

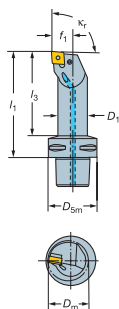
Unutrašnja obrada sa T-MAX P, negativnim pločicama



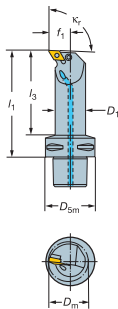
Coromant Capto u veličinama C4 – C6

T-MAX P stezanje polugom

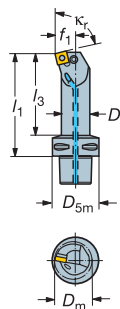
PCLNR/L

 $\kappa_r 95^\circ$ 


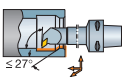
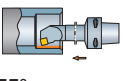
PDUNR/L

 $\kappa_r 93^\circ$ 

PSKNR/L

 $\kappa_r 75^\circ$ 

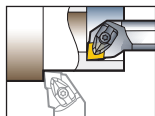
Desna verzija prikazana

	Pločica	Veličina	Kataloška oznaka	Dimenzije, mm							
				D_m min	D_1	D_{5m}	f_1	l_1	l_3	$r_\epsilon^{1)}$	
 95°	C	C4	C4-PCLNR/L -13080-09	25	20	40	13	80	58	0.8	
		C5	C5-PCLNR/L -13080-09	25	20	50	13	80	56	0.8	
		12	C4	C4-PCLNR/L -17090-12	32	25	40	17	90	69	0.8
				-22110-12	40	32	40	22	110	89	0.8
				-27080-12	50	40	40	27	80	60	0.8
				-27120-12	50	40	40	27	120	100	0.8
	C5	C5-PCLNR/L -17090-12	32	25	50	17	90	67	0.8		
		-22110-12	40	32	50	22	110	88	0.8		
		-27140-12	50	40	50	27	140	119	0.8		
	C6	C6-PCLNR/L -17100-12	32	25	63	17	100	73	0.8		
		-22110-12	40	32	63	22	110	84	0.8		
		16	C6	C6-PCLNR/L -27140-16	50	40	63	27	140	115	1.2
 93°	D	C4	C4-PDUNR/L -17090-11	32	25	40	17	90	69	0.8	
			-22110-11	40	32	40	22	110	89	0.8	
		C5	C5-PDUNR/L -17090-11	32	25	50	17	90	67	0.8	
			-22110-11	40	32	50	22	110	88	0.8	
		C6	C6-PDUNR/L -17100-11	32	25	63	17	100	74	0.8	
		15	C4	C4-PDUNR/L -27080-15	50	40	40	27	80	60	0.8
			-27120-15	50	40	40	27	120	100	0.8	
	C5		C5-PDUNR/L -27140-15	50	40	50	27	140	119	0.8	
	C6		C6-PDUNR/L -22110-15	40	32	63	22	110	84	0.8	
		-27140-15	50	40	63	27	140	115	0.8		
 75°	S	C4	C4-PSKNR -17090-12	32	25	40	17	90	89	0.8	
		C5	C5-PSKNR -17090-12	32	25	50	17	90	67	0.8	
			-22110-12	40	32	50	22	110	88	0.8	
			-27140-12	50	40	50	27	140	119	0.8	
		C6	C6-PSKNR -22110-12	40	32	63	22	110	84	0.8	
			-27140-12	50	40	63	27	140	115	0.8	

¹⁾ r_ϵ = radijus vrha rezne pločice

Primer poručivanja: 2 komada C4-PCLNR-13080-09

(R = Desna verzija, L = Leva verzija)



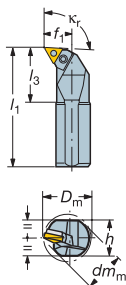
Unutrašnja obrada sa T-MAX P, negativnim pločicama

Prečnik drške 20 – 40 mm

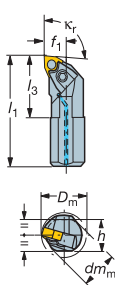
T-MAX P stezanje klinom
Cilindrična drška sa ravnim delom za stezanje

T-MAX P stezanje klinom i polugom
Sa unutrašnjim hladjenjem

PTFNR/L
 $\kappa_r 91^\circ$

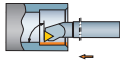
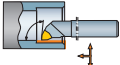


MWLNRL
 $\kappa_r 95^\circ$



Maksimalan preput 4 x dm_m

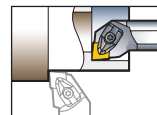
Desna verzija prikazana

Pločica	Kataloška oznaka	Dimenzije, mm							
		dm_m	D_m min	f_1	h	l_1	l_3	$r_s^{1)}$	
 91° T	S25T-PTFNR/L16-W	25	32	17	23	300	36.8	0.8	
	S32U-PTFNR/L16-W	32	40	22	30	350	45.0	0.8	
 95° W	Dovođenje rashladnog sredstva kroz alat								
	A20S-MWLNRL/L 06	20	25	13	18	250	32.3	0.8	
	A25T-MWLNRL/L 06	25	32	17	23	300	31.7	0.8	
	A32U-MWLNRL/L 06	32	40	22	30	350	40.0	0.8	
	A25T-MWLNRL/L 08	25	32	17	23	300	39.9	0.8	
A32U-MWLNRL/L 08	32	40	22	30	350	40.0	0.8		
A40V-MWLNRL/L 08	40	50	27	37	400	56.0	0.8		

¹⁾ r_s = radius vrha rezne pločice

Primer poručivanja: 2 komada S25T-PTFNR16-W
(R = Desna verzija, L= Leva verzija)

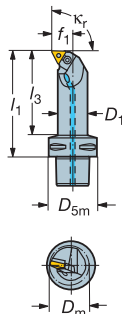
Unutrašnja obrada sa T-MAX P, negativnim pločicama



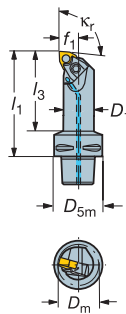
Coromant Capto u veličinama C4 – C6

T-MAX P stezanje
klinom

PTFNR/L

 $\kappa_r 91^\circ$ T-MAX P stezanje
klinom i polugom

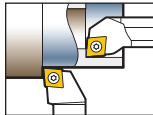
MWLNR/L

 $\kappa_r 95^\circ$ 

Desna verzija prikazana

	Pločica	Veličina	Kataloška oznaka	Dimenzije, mm						
				D_m min	D_1	D_{5m}	f_1	l_1	l_3	$r_s^{1)}$
 91°	 16 T	C4	C4-PTFNR/L -17090-16W	32	25	40	17	90	75	0.8
			C4-PTFNR/L -22110-16W	40	32	40	22	110	69	0.8
			C4-PTFNR/L -27120-16W	50	40	40	27	120	89	0.8
		C5	C5-PTFNR/L -17090-16W	32	25	50	17	90	67	0.8
			C5-PTFNR/L -22110-16W	40	32	50	22	110	88	0.8
			C5-PTFNR/L -27140-16W	50	40	50	27	140	119	0.8
	C6	C6-PTFNR/L -22110-16W	40	32	63	22	110	84	0.8	
		C6-PTFNR/L -27140-16W	50	40	63	27	140	115	0.8	
		C4	C4-PTFNR -27120-22W	50	40	40	27	120	100	0.8
C5	C5-PTFNR/L -27140-22W		50	40	50	27	140	119	0.8	
C6	C6-PTFNR/L -27140-22W		50	40	63	27	140	115	0.8	
 95°	 06 W	C4	C4-MWLNR/L -13075-06	25	20	40	13	75	53	0.8
			C4-MWLNR/L -17090-06M1	32	25	40	17	90	69	0.8
	C4	C4-MWLNR/L -17090-08	32	25	40	17	90	69	0.8	
		C4-MWLNR/L -22110-08	40	32	40	22	110	89	0.8	
		C4-MWLNR/L -27120-08	50	40	40	27	120	100	0.8	
	C5	C5-MWLNR/L -17090-08	32	25	50	17	90	67	0.8	
		C5-MWLNR/L -22110-08	40	32	50	22	110	88	0.8	
		C5-MWLNR/L -27140-08	50	40	50	27	140	119	0.8	
		C5-MWLNR/L -27140-08	50	40	50	27	140	119	0.8	

¹⁾ r_s = radijus vrha rezne pločicePrimer poručivanja: 2 komada C4-PTFNR-17090-16W
(R = Desna verzija, L= Leva verzija)



ZAVRŠNA OBRADA ČELIKA

Niskolegirani čelici, HB 180

ISO/
ANSI

P

F

CoroTurn® 107

Jednostrane pločice

CCMT 09 T3 04-WF

$a_p = 0.3 - 3.0$ mm

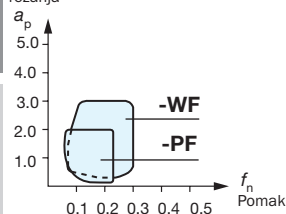
$f_n = 0.07 - 0.3$ mm/obr

CCMT 09 T3 04-PF

$a_p = 0.11 - 2.0$ mm

$f_n = 0.06 - 0.23$ mm/obr

Dubina
rezanja



-WF – za produktivnu završnu obradu struganjem

Operacije: uzdužno struganje, čeono struganje

Prednosti: Duplira konvencionalne pomake uz isti kvalitet obrađene površine ili daje duplo bolji kvalitet uz iste pomake. Idealan kada je kvalitet završne obrade prioritet.

Komponente: stabilnija vratila, osovine i zupčanike kada je kvalitet obrađene površine prioritet

-PF

Operacije: uzdužno struganje, čeono struganje, profilisanje i struganje unazad

Komponente: vratila, osovine, zupčanici i sl.

Prednosti: lako-rezna, pozitivna geometrija daje male sile rezanja pogodna za vitke, tankozide i slabo stegnute komponente

DOBRI USLOVI



- Kontinualan rez.
- Predobrađeni komadi i laka kora.

VELIKI POMACI



-WF / GC4215

NORMALNI POMACI



-PF / GC4215

Prvi izbor

PROSEČNI USLOVI



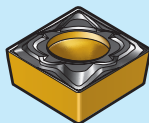
Operacije opšte namene.

VELIKI POMACI



-WF / GC4215

NORMALNI POMACI



-PF / GC4215

TEŠKI USLOVI



- Prekinuti rez.
- Male brzine rezanja.
- Teška kora kod otkovaka.

VELIKI POMACI



-WF / GC4215

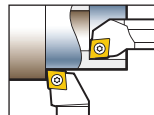
NORMALNI POMACI












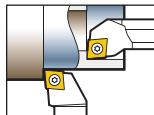
-PF / GC4225

ISO/
ANSI**P F****ZAVRŠNA OBRADA ČELIKA**

Pozitivne pločice



KATALOŠKA OZNAKA		REŽIMI REZANJA, CMC 02.1 / HB 180							
		Dubina rezanja		Pomak		Brzina rezanja v_c (m/min)			
Jednostrane pločice	 r_c	GC4215	GC4215	GC4215	GC4225	a_p mm	f_n mm/obr	GC4215	GC4225
			CCMT 06 02 04-WF 06 02 08-WF 09 T3 04-WF 09 T3 08-WF	☆ ★ ☆ ☆	★ ★ ★ ★	☆ ☆ ☆ ☆		0.8 (0.3-2) 0.8 (0.3-2) 1 (0.3-3) 1 (0.3-3)	0.12 (0.05-0.3) 0.15 (0.09-0.35) 0.2 (0.07-0.3) 0.25 (0.12-0.5)
	DCMX 07 02 04-WF 07 02 08-WF 11 T3 04-WF 11 T3 08-WF	☆ ☆ ☆ ☆	★ ★ ★ ★	☆ ☆ ☆ ☆		0.7 (0.3-2) 0.7 (0.3-2) 1 (0.3-3) 1 (0.3-3)	0.12 (0.05-0.25) 0.15 (0.09-0.35) 0.2 (0.07-0.3) 0.25 (0.12-0.4)	540 515 475 445	
	TCMX 09 02 04-WF 11 03 04-WF 11 03 08-WF 16 T3 08-WF	☆ ☆ ☆ ☆	★ ★ ★ ★	☆ ☆ ☆ ☆		0.7 (0.3-2) 1 (0.3-2.5) 1 (0.3-2.5) 1.2 (0.3-3.5)	0.12 (0.05-0.3) 0.2 (0.07-0.3) 0.25 (0.12-0.4) 0.25 (0.12-0.5)	540 475 445 445	
	CCMT 06 02 02-PF 06 02 04-PF 09 T3 02-PF 09 T3 04-PF 09 T3 08-PF	☆ ☆ ☆ ☆ ☆	★ ★ ★ ★ ★		★	0.3 (0.06-1.7) 0.3 (0.1-1.7) 0.35 (0.08-2) 0.35 (0.11-2) 0.35 (0.15-2)	0.06 (0.03-0.11) 0.08 (0.05-0.17) 0.08 (0.04-0.15) 0.11 (0.06-0.23) 0.15 (0.08-0.3)	480 570 470 450 425	
	DCMT 07 02 02-PF 07 02 04-PF 11 T3 02-PF 11 T3 04-PF 11 T3 08-PF	☆ ☆ ☆ ☆ ☆	★ ★ ★ ★ ★		★	0.26 (0.06-1.5) 0.26 (0.08-1.5) 0.35 (0.08-2) 0.35 (0.11-2) 0.35 (0.15-2)	0.06 (0.03-0.11) 0.08 (0.05-0.17) 0.08 (0.04-0.15) 0.11 (0.06-0.23) 0.15 (0.08-0.3)	480 470 470 450 425	
	SCMT 09 T3 04-PF 09 T3 08-PF	☆ ☆	★ ★		☆	0.35 (0.11-2) 0.35 (0.15-2)	0.11 (0.06-0.23) 0.15 (0.08-0.3)	450 425	545 515
	TCMT 09 02 02-PF 09 02 04-PF 11 03 02-PF 11 03 04-PF 11 03 08-PF 16 T3 04-PF	☆ ☆ ☆ ☆ ☆ ☆	★ ★ ★ ★ ★ ★		★	0.3 (0.06-1.7) 0.3 (0.1-1.7) 0.3 (0.06-1.7) 0.3 (0.1-1.7) 0.3 (0.13-1.7) 0.35 (0.11-2)	0.06 (0.03-0.13) 0.1 (0.05-0.19) 0.06 (0.03-0.13) 0.1 (0.05-0.19) 0.13 (0.07-0.26) 0.11 (0.06-0.23)	480 460 480 460 440 450	550 550 530 545
	VBMT 11 03 02-PF 11 03 04-PF 11 03 08-PF 11 03 12-PF 16 04 04-PF 16 04 08-PF 16 04 12-PF	☆ ☆ ☆ ☆ ☆ ☆ ☆	★ ★ ★ ★ ★ ★ ★		★	0.3 (0.06-1.7) 0.3 (0.1-1.7) 0.3 (0.13-1.7) 0.3 (0.3-1.7) 0.32 (0.1-1.8) 0.32 (0.14-1.8) 0.32 (0.14-1.8)	0.06 (0.03-0.13) 0.1 (0.05-0.19) 0.13 (0.07-0.26) 0.15 (0.08-0.31) 0.1 (0.05-0.2) 0.14 (0.07-0.27) 0.16 (0.09-0.32)	480 460 440 440 460 430 430	550 530 515 550 525 505



SREDNJA OBRADA ČELIKA

Niskolegirani čelici, HB 180

ISO/
ANSI

P M

CoroTurn® 107

Jednostrane pločice

CCMT 09 T3 08-WM

$a_p = 0.5 - 4.0$ mm

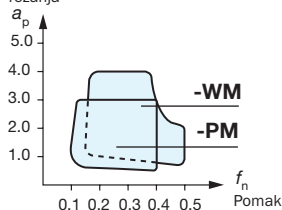
$f_n = 0.12 - 0.4$ mm/obr

CCMT 09 T3 08-PM

$a_p = 0.5 - 3.0$ mm

$f_n = 0.1 - 0.3$ mm/obr

Dubina rezanja
 a_p



-WM – za produktivnu srednju obradu

Operacije: uzdužno struganje, čeono struganje

Komponente: stabilna vratila, osovine, zupčanic i sl.

Prednosti: Duplira konvencionalne pomake uz isti kvalitet obrađene površine ili daje duplo bolji kvalitet uz iste pomake. Idealan kada je dobar kvalitet obrađene površine prioritet.

-PM

Operacije: uzdužno struganje, čeono struganje i profilisanje

Komponente: vratila, osovine, zupčanic i sl.

Prednosti: univerzalna, pouzdana obrada bez prisutnih problema

DOBRI USLOVI



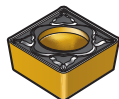
- Kontinualan rez.
- Predobrađeni komadi i laka kora.

VELIKI POMACI



-WM / GC4215

NORMALNI POMACI



-PM / GC4215

Prvi izbor

PROSEČNI USLOVI



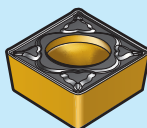
Operacije opšte namene.

VELIKI POMACI



-WM / GC4215

NORMALNI POMACI



-PM / GC4225

TEŠKI USLOVI



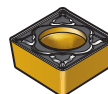
- Prekinuti rez.
- Male brzine rezanja.
- Teška kora kod otkovaka.

VELIKI POMACI



-WM / GC4225

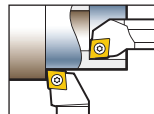
NORMALNI POMACI



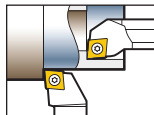
-PM / GC4235

ISO/
ANSI**P M****SREDNJA OBRADA ČELIKA**

Positivne pločice



KATALOŠKA OZNAKA			REŽIMI REZANJA, CMC 02.1 / HB 180					Brzina rezanja v_c (m/min)		
Jednostrane pločice		r_c				Dubina rezanja a_p mm	Pomak f_n mm/obr	GC4215	GC4225	GC4235
			GC4215	GC4215	GC4225					
	CCMT 06 02 08-WM		☆	★	☆	1.2 (0.5-2.5)	0.2 (0.1-0.4)	475	395	
	CCMT 09 T3 04-WM		☆	★	☆	1.5 (0.5-4)	0.25 (0.12-0.4)	445	365	
	09 T3 08-WM		☆	★	☆	1.5 (0.7-4)	0.3 (0.15-0.5)	415	345	
	DCMX 11 T3 04-WM		☆	★	☆	1.5 (0.5-4)	0.25 (0.12-0.4)	445	365	
	11 T3 08-WM		☆	★	☆	1.5 (0.5-4)	0.3 (0.15-0.5)	415	345	
	TCMX 11 03 04-WM		☆	★		1.2 (0.5-3)	0.25 (0.12-0.35)	445		
	11 03 08-WM		☆	★	☆	1.2 (0.5-3)	0.3 (0.15-0.5)	415	345	
	16 T3 08-WM		☆	★	☆	1.5 (0.5-4)	0.3 (0.15-0.5)	415	345	
	CCMT 06 02 04-PM		☆	★		0.64 (0.2-2.4)	0.11 (0.06-0.17)	545		
	06 02 08-PM		☆	★		0.64 (0.4-2.4)	0.15 (0.08-0.23)	515		
	09 T3 04-PM		☆		★	0.64 (0.25-3)	0.15 (0.08-0.23)	515	425	265
	09 T3 08-PM		☆		★	0.8 (0.5-3)	0.2 (0.1-0.3)	475	395	240
	DCMT 07 02 04-PM		☆	★		0.6 (0.19-2.3)	0.11 (0.06-0.17)	545	450	295
	07 02 08-PM		☆	★		0.6 (0.38-2.3)	0.15 (0.08-0.23)	515	425	265
	11 T3 04-PM		☆	★		0.8 (0.25-3)	0.15 (0.08-0.23)	515	425	265
	11 T3 08-PM		☆	★		0.8 (0.5-3)	0.2 (0.1-0.3)	475	395	240
	11 T3 12-PM		☆	★		0.8 (0.6-3)	0.24 (0.12-0.36)	450	370	225
	SCMT 09 T3 04-PM		☆		★	0.8 (0.25-3)	0.15 (0.08-0.23)	515	425	265
	09 T3 08-PM		☆		★	0.8 (0.5-3)	0.2 (0.1-0.3)	475	395	240
	TCMT 09 02 04-PM		☆		★	0.6 (0.19-2.3)	0.11 (0.06-0.17)	545	450	295
	09 02 08-PM		☆		★	0.6 (0.38-2.3)	0.15 (0.08-0.23)	515	425	265
	11 03 04-PM		☆		★	0.67 (0.21-2.5)	0.13 (0.06-0.19)	530	440	280
	11 03 08-PM		☆		★	0.67 (0.42-2.5)	0.17 (0.09-0.26)	500	410	255
	11 03 12-PM		☆		★	0.67 (0.5-2.5)	0.2 (0.1-0.31)		395	
	16 T3 04-PM		☆		★	0.8 (0.25-3)	0.15 (0.08-0.23)	515	425	265
	VBMT 16 04 04-PM		☆		★	0.72 (0.23-2.7)	0.14 (0.07-0.2)	525	430	270
	16 04 08-PM		☆		★	0.72 (0.45-2.7)	0.18 (0.09-0.27)	490	405	250
	16 04 12-PM		☆		★	0.72 (0.54-2.7)	0.22 (0.11-0.32)	465	385	235
	RCMT 08 03 M0		☆		★	2 (0.8-3.2)	0.4 (0.08-0.8)	475	395	240
	10 T3 M0		☆		★	2.5 (1-4)	0.5 (0.1-1)	445	365	225
	12 04 M0		☆		★	3 (1.2-4.8)	0.6 (0.12-1.2)	415	345	210



GRUBA OBRADA ČELIKA

Niskolegirani čelici, HB 180

ISO/
ANSI

P

R

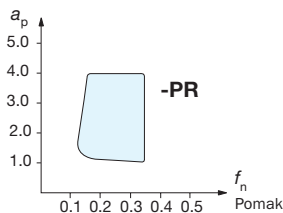
CoroTurn® 107

Jednostrane pločice

CCMT 09 T3 08-PR
 $a_p = 1.0 - 4.0$ mm
 $f_n = 0.12 - 0.35$ mm/obr

-PR**Operacije:** uzdužno struganje, čeono struganje i profilisanje**Komponente:** vratila, osovine, spojnice, zupčanici i sl.**Prednosti:** univerzalna, pozitivna geometrija sa dobrim mogućnostima za grubu obradu i dobrim balansom između visoke produktivnosti i minimalnih tendencija ka vibracijama

Dubina rezanja

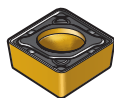


DOBRI USLOVI



- Kontinualan rez.
- Predobrađeni komadi i laka kora.

NORMALNI POMACI

**-PR / GC4215**

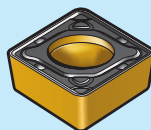
Prvi izbor

PROSEČNI USLOVI



Operacije opšte namene.

NORMALNI POMACI

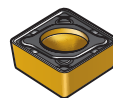
**-PR / GC4225**

TEŠKI USLOVI



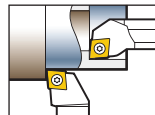
- Prekinuti rez.
- Male brzine rezanja.
- Teška kora kod otkovaka.










NORMALNI POMACI

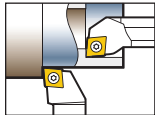
**-PR / GC4235**

ISO/
ANSI**P R****GRUBA OBRADA ČELIKA**

Pozitivne pločice



KATALOŠKA OZNAKA			REŽIMI REZANJA, CMC 02.1 / HB 180							
Jednostrane pločice  r_c						Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)		
			GC4215	GC4225	GC4235			GC4215	GC4225	GC4235
	CCMT 06 02 08-PR	☆	☆	★	★	1.6 (0.8-3.2)	0.19 (0.09-0.26)	485		245
	09 T3 08-PR	☆	★	☆	★	2 (1-4)	0.25 (0.12-0.35)	445	365	225
	09 T3 12-PR			★	☆	2 (1.2-4)	0.3 (0.14-0.42)		345	210
	DCMT 11 T3 08-PR	☆	★	☆	☆	2 (1-4)	0.25 (0.12-0.35)	445	365	225
	11 T3 12-PR	☆	★	☆	☆	2 (1.2-4)	0.3 (0.14-0.42)	415	345	210
	SCMT 09 T3 08-PR	☆	★	☆	☆	2 (1-4)	0.25 (0.12-0.35)	445	365	225
	09 T3 12-PR			★	☆	2 (1.2-4)	0.3 (0.14-0.42)		345	210
	TCMT 11 03 08-PR	☆	★	☆	☆	1.5 (0.75-3)	0.21 (0.1-0.3)	470	390	235
	11 03 12-PR			★	★	1.5 (0.9-3)	0.26 (0.12-0.36)		360	
	16 T3 08-PR	☆	★	☆	☆	2 (1-4)	0.25 (0.12-0.35)	445	365	225
	16 T3 12-PR	☆	★	☆	☆	2 (1.2-4)	0.3 (0.14-0.42)	415	345	210
	VBMT 16 04 08-PR	☆	★	☆	☆	1.8 (0.9-3.6)	0.23 (0.11-0.32)	455	380	230
	16 04 12-PR	☆	★	☆	☆	1.8 (1.1-3.6)	0.27 (0.13-0.38)	435	360	215



ZAVRŠNA OBRADA NERĐAJUĆIH ČELIKA

ISO/
ANSI
M F

Nerđajući čelici, austenitni, HB 180

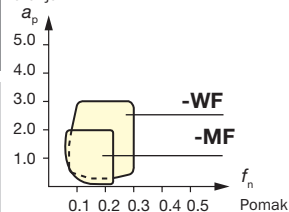
CoroTurn® 107

Jednostrane pločice

CCMT 09 T3 04-WF

 $a_p = 0.3 - 3.0$ mm $f_n = 0.07 - 0.3$ mm/obr

CCMT 09 T3 04-MF

 $a_p = 0.11 - 2.0$ mm $f_n = 0.06 - 0.23$ mm/obrDubina
rezanja

-WF – za produktivnu završnu obradu

Operacije: čeono struganje i profilisanje

Komponente: stabilnija vratila, osovine i zupčanike kada je kvalitet obrađene površine prioritet

Prednosti: Duplira konvencionalne pomake uz isti kvalitet obrađene površine ili daje duplo bolji kvalitet uz iste pomake. Idealan kada je dobar kvalitet obrađene površine prioritet.

-MF

Operacije: struganje, čeono struganje i profilisanje

Komponente: opšte komponente od nerđajućih čelika

Prednosti: lako-rezna, pozitivna geometrija daje male sile rezanja pogodno za vitke, tankozide i slabo stegnute komponente

DOBRI USLOVI



- Kontinualan rez.
- Predobrađeni komadi i laka kora.

VELIKI POMACI



-WF / GC2015

NORMALNI POMACI



-MF / GC2015

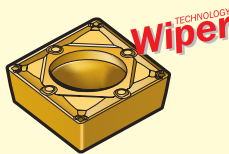
Prvi izbor

PROSEČNI USLOVI



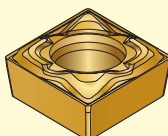
Operacije opšte namene.

VELIKI POMACI



-WF / GC2015

NORMALNI POMACI



-MF / GC2015

TEŠKI USLOVI



- Prekinuti rez.
- Male brzine rezanja.
- Teška kora kod otkovaka.

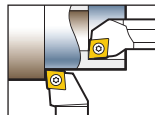
NORMALNI POMACI



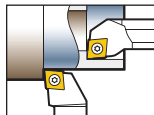
-MF / GC2025

ISO/
ANSI**M F****ZAVRŠNA OBRADA NERĐAJUĆIH ČELIKA**

Pozitivne pločice



KATALOŠKA OZNAKA					REŽIMI REZANJA, CMC 05.21 / HB 180			
Jednostrane pločice	r_e	GC2015	GC2015	GC2025	Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)	
							GC2015	GC2025
	CCMT 06 02 04-WF	☆	★		0.8 (0.3-2)	0.12 (0.05-0.3)	280	
	06 02 08-WF	☆	★		0.8 (0.3-2)	0.15 (0.09-0.35)	290	
	09 T3 04-WF	☆	★		1 (0.3-3)	0.2 (0.07-0.3)	290	
	09 T3 08-WF	☆	★		1 (0.3-3)	0.25 (0.12-0.5)	280	
	DCMX 07 02 04-WF	☆	★		0.7 (0.3-2)	0.12 (0.05-0.25)	280	
	07 02 08-WF	☆	★		0.7 (0.3-2)	0.15 (0.09-0.35)	290	
	11 T3 04-WF	☆	★		1 (0.3-3)	0.2 (0.07-0.3)	290	
	11 T3 08-WF	☆	★		1 (0.3-3)	0.25 (0.12-0.4)	280	
	TCMX 09 02 04-WF	☆	★		0.7 (0.3-2)	0.12 (0.05-0.3)	280	
	11 03 04-WF	☆	★		1 (0.3-2.5)	0.2 (0.07-0.3)	290	
	11 03 08-WF	☆	★		1 (0.3-2.5)	0.25 (0.12-0.4)	280	
	16 T3 08-WF	☆	★		1.2 (0.3-3.5)	0.25 (0.12-0.5)	280	
	CCMT 06 02 04-MF	☆	★		0.3 (0.1-1.7)	0.08 (0.05-0.17)	290	
	09 T3 04-MF	☆	★	☆	0.35 (0.11-2)	0.11 (0.06-0.23)	290	265
	09 T3 08-MF	☆	★	☆	0.35 (0.15-2)	0.15 (0.08-0.3)	290	260
	DCMT 07 02 04-MF	☆	★	☆	0.26 (0.08-1.5)	0.08 (0.05-0.17)	290	265
	11 T3 04-MF	☆	★	☆	0.35 (0.11-2)	0.11 (0.06-0.23)	290	265
	11 T3 08-MF	☆	★	☆	0.35 (0.15-2)	0.15 (0.08-0.3)	290	260
	SCMT 09 T3 04-MF			★	0.35 (0.11-2)	0.11 (0.06-0.23)		265
	09 T3 08-MF			★	0.35 (0.15-2)	0.15 (0.08-0.3)		260
	TCMT 09 02 04-MF	☆	★	☆	0.3 (0.1-1.7)	0.1 (0.05-0.19)	290	265
	11 03 04-MF	☆	★	☆	0.3 (0.1-1.7)	0.1 (0.05-0.19)	290	265
	11 03 08-MF	☆	★	☆	0.3 (0.13-1.7)	0.13 (0.07-0.26)	285	265
	16 T3 04-MF	☆	★	☆	0.35 (0.11-2)	0.11 (0.06-0.23)	290	265
	VBMT 11 03 04-MF	☆	★	☆	0.3 (0.1-1.7)	0.1 (0.05-0.19)	290	265
	11 03 08-MF	☆	★	☆	0.3 (0.13-1.7)	0.13 (0.07-0.26)	285	265
	16 04 04-MF	☆	★	☆	0.32 (0.1-1.8)	0.1 (0.05-0.2)	290	265
	16 04 08-MF	☆	★	☆	0.32 (0.14-1.8)	0.14 (0.07-0.27)	290	260
	16 04 12-MF	☆	★		0.32 (0.14-1.8)	0.16 (0.09-0.32)	290	



SREDNJA OBRADA NERĐAJUĆIH ČELIKA

Nerđajući čelici, austenitni, HB 180

ISO/
ANSI

M M

CoroTurn® 107

Jednostrane pločice

CCMT 09 T3 08-WM

$a_p = 0.7 - 4.0$ mm

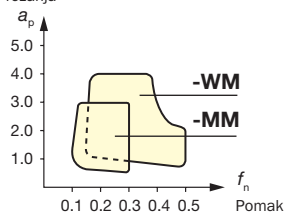
$f_n = 0.15 - 0.5$ mm/obr

CCMT 09 T3 08-MM

$a_p = 0.5 - 3.0$ mm

$f_n = 0.10 - 0.3$ mm/obr

Dubina rezanja



-WM – za produktivnu srednju obradu

Operacije: čeono struganje i profilisanje

Komponente: stabilna vratila, osovine, zupčanici i sl.

Prednosti: Duplira konvencionalne pomake uz isti kvalitet obrađene površine ili daje duplo bolji kvalitet uz iste pomake. Idealan kada je dobar kvalitet obrađene površine prioritet.

-MM

Operacije: struganje, čeono struganje i profilisanje

Prednosti: univerzalna, pouzdana obrada bez prisutnih problema

Komponente: opšte komponente od nerđajućih čelika

DOBRI USLOVI



- Kontinualan rez.
- Predobrađeni komadi i laka kora.

VELIKI POMACI



-WM / GC2015

NORMALNI POMACI



-MM / GC2015

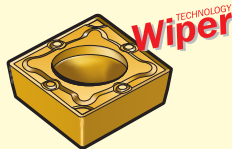
Prvi izbor

PROSEČNI USLOVI



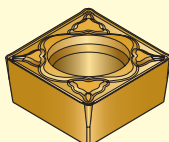
Operacije opšte namene.

VELIKI POMACI



-WM / GC2015

NORMALNI POMACI



-MM / GC2025

TEŠKI USLOVI



- Prekinuti rez.
- Male brzine rezanja.
- Teška kora kod otkovaka.

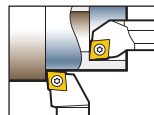
NORMALNI POMACI












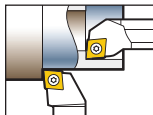
-MM / GC2035

ISO/
ANSI**M M****SREDNJA OBRADA NERĐAJUĆIH ČELIKA**

Pozitivne pločice



KATALOŠKA OZNAKA		○	◐	●	REŽIMI REZANJA, CMC 05.21 / HB 180					
Jednostrane pločice	 r_e	GC2015	GC2015	GC2025	GC2035	Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)		
								GC2015	GC2025	GC2035
	CCMT 09 T3 04-WM	☆	★			1.5 (0.5-4)	0.25 (0.12-0.4)	280		
	09 T3 08-WM	☆	★			1.5 (0.7-4)	0.3 (0.15-0.5)	270		
	DCMX 11 T3 04-WM	☆	★			1.5 (0.5-4)	0.25 (0.12-0.4)	280		
	11 T3 08-WM	☆	★			1.5 (0.5-4)	0.3 (0.15-0.5)	270		
	CCMT 06 02 04-MM	★				0.64 (0.2-2.4)	0.11 (0.06-0.17)	290		
	06 02 08-MM	★				0.64 (0.4-2.4)	0.15 (0.08-0.23)	290		
	09 T3 04-MM	☆		★	☆	0.64 (0.25-3)	0.15 (0.08-0.23)	290	260	170
	09 T3 08-MM	☆		★	☆	0.8 (0.5-3)	0.2 (0.1-0.3)	290	240	170
	DCMT 07 02 04-MM	☆		★	☆	0.6 (0.19-2.3)	0.11 (0.06-0.17)	290	265	170
	07 02 08-MM	☆		★	☆	0.6 (0.38-2.3)	0.15 (0.08-0.23)	290	260	170
	11 T3 04-MM	☆		★	☆	0.8 (0.25-3)	0.15 (0.08-0.23)	290	260	170
	11 T3 08-MM	☆		★	☆	0.8 (0.5-3)	0.2 (0.1-0.3)	290	240	170
	11 T3 12-MM	☆		★	☆	0.8 (0.6-3)	0.24 (0.12-0.36)	225	170	
	SCMT 09 T3 04-MM	☆		★	☆	0.8 (0.25-3)	0.15 (0.08-0.23)	290	260	170
	09 T3 08-MM	☆		★	☆	0.8 (0.5-3)	0.2 (0.1-0.3)	290	240	170
	TCMT 09 02 04-MM	☆		★	☆	0.6 (0.19-2.3)	0.11 (0.06-0.17)	290	265	170
	09 02 08-MM	☆		★	☆	0.6 (0.38-2.3)	0.15 (0.08-0.23)	290	260	170
	11 03 04-MM	☆		★	☆	0.67 (0.21-2.5)	0.13 (0.06-0.19)	290	265	170
	11 03 08-MM	☆		★	☆	0.67 (0.42-2.5)	0.17 (0.09-0.26)	290	250	170
	16 T3 04-MM	☆		★	☆	0.8 (0.25-3)	0.15 (0.08-0.23)	290	260	170
	16 T3 08-MM	☆		★	☆	0.8 (0.5-3)	0.2 (0.1-0.3)	290	240	170
	16 T3 12-MM	☆		★	☆	0.8 (0.6-3)	0.24 (0.12-0.36)	285	225	
	VBMT 16 04 04-MM	☆		★	☆	0.72 (0.23-2.7)	0.14 (0.07-0.27)	290	260	170
	16 04 08-MM	☆		★	☆	0.72 (0.45-2.7)	0.18 (0.09-0.27)	290	250	170
	16 04 12-MM	☆		★	☆	0.72 (0.54-2.7)	0.22 (0.11-0.32)	285	235	170
	RCMT 08 03 M0			★		2 (0.8-3.2)	0.4 (0.08-0.8)	240		
	10 T3 M0			★		2.5 (1-4)	0.5 (0.1-1)	225		
	12 04 M0			★		3 (1.2-4.8)	0.6 (0.12-1.2)	205		



GRUBA OBRADA NERĐAJUĆIH ČELIKA

Nerđajući čelici, austenitni, HB 180

ISO/
ANSI**M R**

CoroTurn® 107

Jednostrane
pločice

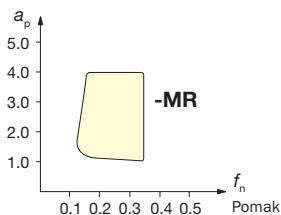
CCMT 09 T3 08-MR

 $a_p = 1.0 - 4.0$ mm $f_n = 0.12 - 0.35$ mm/obr**-MR**

Operacije: struganje, čeono struganje i profilisanje

Komponente: opšte komponente od nerđajućih čelika

Prednosti: univerzalna, pozitivna geometrija sa dobrim mogućnostima za grubu obradu i dobrim balansom između visoke produktivnosti i minimalnih tendencija ka vibracijama. Preporuka za operacije sa prekinutim rezom.

Dubina
rezanja

DOBRI USLOVI



- Kontinualan rez.
- Predobrađeni komadi i laka kora.

NORMALNI POMACI

**-MR / GC2015**

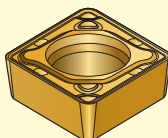
Prvi izbor

PROSEČNI USLOVI



Operacije opšte namene.

NORMALNI POMACI

**-MR / GC2025**

TEŠKI USLOVI



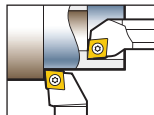
- Prekinuti rez.
- Male brzine rezanja.
- Teška kora kod otkovaka.










NORMALNI POMACI

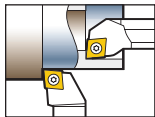
**-MR / GC2035**

ISO/
ANSI**M R****GRUBA OBRADA NERĐAJUĆIH ČELIKA**

Pozitivne pločice



KATALOŠKA OZNAKA			REŽIMI REZANJA, CMC 05.21 / HB 180						
Jednstrane pločice	 r_ϵ	 GC2015	 GC2025	 GC2035	Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)		
							GC2015	GC2025	GC2035
	CCMT 06 02 08-MR	☆	★	★	1.6 (0.8-3.2)	0.19 (0.09-0.26)	290		170
	09 T3 08-MR	☆	★	☆	2 (1-4)	0.25 (0.12-0.35)	280	225	165
	09 T3 12-MR		★	★	2 (1.2-4)	0.3 (0.14-0.42)		205	
	DCMT 11 T3 08-MR	☆	★	☆	2 (1-4)	0.25 (0.12-0.35)	280	225	165
	11 T3 12-MR	☆	★	☆	2 (1.2-4)	0.3 (0.14-0.42)	270	205	160
	SCMT 09 T3 08-MR	☆	★	☆	2 (1-4)	0.25 (0.12-0.35)	280	225	165
	09 T3 12-MR		★	★	2 (1.2-4)	0.3 (0.14-0.42)			160
	TCMT 11 03 08-MR		★	☆	1.5 (0.75-3)	0.21 (0.1-0.3)		235	170
	16 T3 08-MR	☆	★	☆	2 (1-4)	0.25 (0.12-0.35)	280	225	165
	16 T3 12-MR		★	☆	2 (1.2-4)	0.3 (0.14-0.42)		205	160
	VBMT 16 04 08-MR	☆	★	☆	1.8 (0.9-3.6)	0.23 (0.11-0.32)	285	230	170
	16 04 12-MR		★	☆	1.8 (1.1-3.6)	0.27 (0.13-0.38)		215	165



Završna obrada sivog i nodularnog liva

Visoka zatezna čvrstoća, HB 220 / HB 250

ISO/
ANSI

K

F

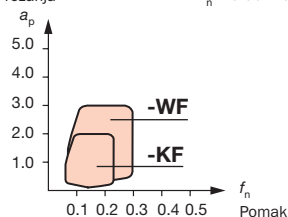
CoroTurn® 107

Jednostrane pločice

CCMT 09 T3 04-WF
 $a_p = 0.3 - 3.0$ mm
 $f_n = 0.07 - 0.3$ mm/obr

CCMT 09 T3 04-KF
 $a_p = 0.11 - 2.0$ mm
 $f_n = 0.06 - 0.23$ mm/obr

Dubina
rezanja



-WF – za produktivnu završnu obradu

Operacije: struganje i čeono struganje

Komponente: stabilnija vratila, osovine i zupčanici kada je kvalitet obrađene površine prioritet

Prednosti: duplira konvencionalne pomake uz isti kvalitet obrađene površine ili daje duplo bolji kvalitet uz iste pomake. Idealan kada je dobar kvalitet obrađene površine prioritet.

-KF

Operacije: struganje, čeono struganje i profilisanje

Komponente: komponente od sivog liva uopšteno.

Prednosti: lako-rezna, pozitivna geometrija daje male sile rezanja pogodne za vitke, tankozide i slabo stegnute komponente.

DOBRI USLOVI



- Kontinualan rez.
- Predobrađeni komadi i laka kora.

VELIKI POMACI



-WF / GC3215

NORMALNI POMACI



-KF / GC3005

Prvi izbor

PROSEČNI USLOVI



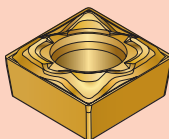
Operacije opšte namene.

VELIKI POMACI



-WF / GC3215

NORMALNI POMACI



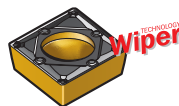
-KF / GC3005

TEŠKI USLOVI



- Prekinuti rez.
- Male brzine rezanja.
- Teška kora kod odlivaka.

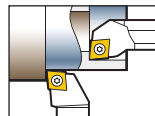
VELIKI POMACI













-WF / GC3215

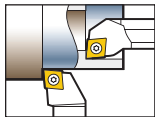
ISO/
ANSI**K F****Završna obrada sivog i nodularnog liva**

Pozitivne pločice



KATALOŠKA OZNAKA		○	◐	●	REŽIMI REZANJA, CMC 08.2 ¹⁾ / HB 220				
Jednostrane pločice	 r_c	GC3005	GC3215	GC3005	GC3215	Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)	
		☆	☆	★	☆			GC3005	GC3215
	CCMT 06 02 04-WF	☆		★	☆	0.8 (0.3-2)	0.12 (0.05-0.3)		235
	06 02 08-WF	☆		★	☆	0.8 (0.3-2)	0.15 (0.09-0.35)		225
	09 T3 04-WF	☆		★	☆	1 (0.3-3)	0.2 (0.07-0.3)		215
	09 T3 08-WF	☆		★	☆	1 (0.3-3)	0.25 (0.12-0.5)		200
	DCMX 11 T3 04-WF	☆		★	☆	1 (0.3-3)	0.2 (0.07-0.3)		215
	TCMX 09 02 04-WF	☆		★	☆	0,7 (0.3-2)	0.12 (0.05-0.3)		235
	09 02 08-WF	☆		★	☆	0,7 (0.3-2)	0.25 (0.1-0.35)		200
	11 03 04-WF	☆		★	☆	1 (0.3-2.5)	0.2 (0.07-0.3)		215
	16 T3 04-WF	☆		★	☆	1.2 (0.3-3.5)	0.2 (0.07-0.35)		215
	CCMT 06 02 04-KF	☆		★		0.3 (0.1-1.7)	0.08 (0.05-0.17)		250
	09 T3 04-KF	☆		★		0.35 (0.11-2)	0.11 (0.06-0.23)		245
	DCMT 07 02 04-KF	☆		★		0.26 (0.08-1.5)	0.08 (0.05-0.17)		250
	11 T3 04-KF	☆		★		0.35 (0.11-2)	0.11 (0.06-0.23)		245
	SCMT 09 T3 04-KF	☆		★		0.35 (0.11-2)	0.11 (0.06-0.23)		245
	09 T3 08-KF	☆		★		0.35 (0.15-2)	0.15 (0.08-0.3)		240
	TCMT 09 02 04-KF	☆		★		0.3 (0.1-1.7)	0.1 (0.05-0.19)		250
	11 03 04-KF	☆		★		0.3 (0.1-1.7)	0.1 (0.05-0.19)		250
	16 T3 04-KF	☆		★		0.35 (0.11-2)	0.11 (0.06-0.23)		245
	VBMT 11 03 04-KF	☆		★		0.3 (0.1-1.7)	0.1 (0.05-0.19)		250
	11 03 08-KF	☆		★		0.3 (0.13-1.7)	0.13 (0.07-0.26)		240
	16 04 04-KF	☆		★		0.32 (0.1-1.8)	0.1 (0.05-0.2)		250
	16 04 08-KF	☆		★		0.32 (0.14-1.8)	0.14 (0.07-0.27)		240
	RCMT 08 03 M0	☆		★	☆	2 (0.8-3.2)	0.4 (0.08-0.8)		215
	10 T3 M0	☆		★	☆	2.5 (1-4)	0.5 (0.1-1)		200
	12 04 M0	☆		★	☆	3 (1.2-4.8)	0.6 (0.12-1.2)		190

¹⁾ Za CMC 09.2 smanjiti brzinu rezanja (v_c) za 10%.



Srednja obrada sivog i nodularnog liva

Visoka zatezna čvrstoća, HB 220 / HB 250

ISO/
ANSI

K

M

CoroTurn® 107

Jednostrane pločice

CCMT 09 T3 08-WM

$a_p = 0.7 - 4.0$ mm

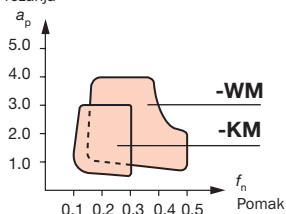
$f_n = 0.15 - 0.5$ mm/obr

CCMT 09 T3 08-KM

$a_p = 0.5 - 3.0$ mm

$f_n = 0.1 - 0.3$ mm/obr

Dubina
rezanja



-WM – za produktivnu srednju obradu struganje

Operacije: struganje i čeono struganje

Komponente: stabilna vratila, osovine, zupčanici i sl

Prednosti: duplira konvencionalne pomake uz isti kvalitet obrađene površine ili daje duplo bolji kvalitet uz iste pomake. Idealan kada je dobar kvalitet obrađene površine prioritet.

-KM

Operacije: struganje, čeono struganje i profilisanje

Komponente: komponente od sivog liva uopšteno.

Prednosti: univerzalna, pouzdana obrada bez prisutnih problema. Dobra, univerzalna geometrija za sivi i nodularni liv

DOBRI USLOVI



- Kontinualan rez.
- Predobrađeni komadi i laka kora.

VELIKI POMACI



-WM / GC3215

NORMALNI POMACI



-KM / GC3005

Prvi izbor

PROSEČNI USLOVI



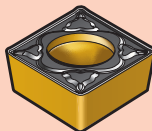
Operacije opšte namene.

VELIKI POMACI



-WM / GC3215

NORMALNI POMACI



-KM / GC3215

TEŠKI USLOVI



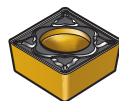
- Prekinuti rez.
- Male brzine rezanja.
- Teška kora kod odlivaka.

VELIKI POMACI



-WM / GC3215

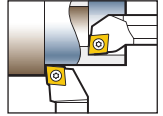
NORMALNI POMACI



-KM / GC3215

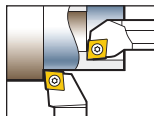
ISO/
ANSI**K M****Srednja obrada sivog i nodularnog liva**

Pozitivne pločice



KATALOŠKA OZNAKA			REŽIMI REZANJA, CMC 08.2 ¹⁾ / HB 220						
Jednostrane pločice		r_c				Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)	
			GC3005	GC3215	GC3215			GC3215	GC3005
	GCMT 09 T3 08-WM			☆	★	☆	1.5 (0.7-4)	0.3 (0.15-0.5)	190
	DCMX 11 T3 08-WM			☆	★	☆	1.5 (0.5-4)	0.3 (0.15-0.5)	190
	TCMX 11 03 08-WM			☆	★	☆	1.2 (0.5-3)	0.3 (0.15-0.5)	190
	16 T3 08-WM			☆	★	☆	1.5 (0.5-4)	0.3 (0.15-0.5)	190
	CCMT 06 02 04-KM		☆		★	☆	0.64 (0.2-2.4)	0.11 (0.06-0.17)	245 235
	06 02 08-KM		☆		★	☆	0.64 (0.4-2.4)	0.15 (0.08-0.23)	240 225
	09 T3 04-KM		☆		★	☆	0.64 (0.25-3)	0.15 (0.08-0.23)	240 225
	09 T3 08-KM		☆		★	☆	0.8 (0.5-3)	0.2 (0.1-0.3)	230 215
	DCMT 07 02 04-KM		☆		★	☆	0.6 (0.19-2.3)	0.11 (0.06-0.17)	245 235
	07 02 08-KM		☆		★	☆	0.6 (0.38-2.3)	0.15 (0.08-0.23)	240 225
	11 T3 04-KM		☆		★	☆	0.8 (0.25-3)	0.15 (0.08-0.23)	240 225
	11 T3 08-KM		☆		★	☆	0.8 (0.5-3)	0.2 (0.1-0.3)	230 215
	SCMT 09 T3 04-KM		☆		★	☆	0.8 (0.25-3)	0.15 (0.08-0.23)	240 225
	09 T3 08-KM		☆		★	☆	0.8 (0.5-3)	0.2 (0.1-0.3)	230 215
	TCMT 09 02 04-KM		☆		★	☆	0.6 (0.19-2.3)	0.11 (0.06-0.17)	245 235
	09 02 08-KM		☆		★	☆	0.6 (0.38-2.3)	0.15 (0.08-0.23)	240 225
	11 03 04-KM		☆		★	☆	0.67 (0.21-2.5)	0.13 (0.06-0.19)	240 230
	11 03 08-KM		☆		★	☆	0.67 (0.42-2.5)	0.17 (0.09-0.26)	235 220
	16 T3 04-KM		☆		★	☆	0.8 (0.25-3)	0.15 (0.08-0.23)	240 225
	16 T3 08-KM		☆		★	☆	0.8 (0.5-3)	0.2 (0.1-0.3)	230 215
	VBMT 16 04 04-KM		☆		★	☆	0.72 (0.23-2.7)	0.14 (0.07-0.2)	240 230
	16 04 08-KM		☆		★	☆	0.72 (0.45-2.7)	0.18 (0.09-0.27)	235 220
	RCMT 08 03 M0			☆	★	☆	2 (0.8-3.2)	0.4 (0.08-0.8)	215
	10 T3 M0			☆	★	☆	2.5 (1-4)	0.5 (0.1-1)	200
	12 04 M0			☆	★	☆	3 (1.2-4.8)	0.6 (0.12-1.2)	190

¹⁾ Za CMC 09.2 smanjiti brzinu rezanja (v_c) sa 10%.



Srednja obrada sivog i nodularnog liva

Visoka zatezna čvrstoća, HB 220 / HB 250

ISO/
ANSI

K

R

CoroTurn® 107

Jednostrane pločice

CCMT 09 T3 08-KR
 $a_p = 1.0 - 4.0$ mm
 $f_n = 0.12 - 0.35$ mm/obr

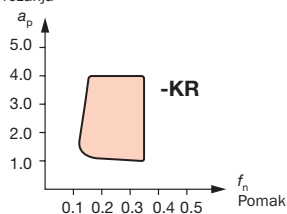
-KR

Operacije: struganje, čeono struganje i profilisanje

Komponente: komponente od sivog liva uopšteno

Prednosti: univerzalna, pozitivna geometrija sa dobrim mogućnostima za grubu obradu i dobrim balansom između visoke produktivnosti i minimalnih tendencija ka vibracijama. Pogodna za prekinuti rez.

Dubina rezanja

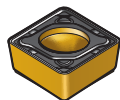


DOBRI USLOVI



- Kontinualan rez.
- Predobrađeni komadi i laka kora.

NORMALNI POMACI



-KR / GC3210

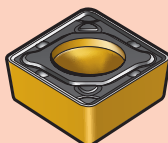
Prvi izbor

PROSEČNI USLOVI



Operacije opšte namene.

NORMALNI POMACI



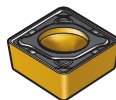
-KR / GC3210

TEŠKI USLOVI



- Prekinuti rez.
- Male brzine rezanja.
- Teška kora kod odlivaka.

NORMALNI POMACI

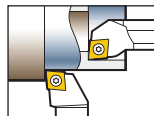











-KR / GC3215

Za sivi liv, CMC 08.2, koristite kvalitet GC3205.

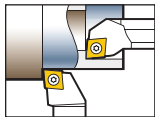
ISO/
ANSI**K R****Srednja obrada sivog i nodularnog liva**

Pozitivne pločice



KATALOŠKA OZNAKA		REŽIMI REZANJA, CMC 08.2 ¹⁾ / HB 220								
Jednostrane pločice  r_e					Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)			
		GC3205	GC3210	GC3205			GC3210	GC3215	GC3205	GC3210
	CCMT 06 02 08-KR				★	1.6 (0.8-3.2)	0.19 (0.09-0.26)			215
	09 T3 08-KR				★	2 (1-4)	0.25 (0.12-0.35)			200
	09 T3 12-KR				★	2 (1.2-4)	0.3 (0.14-0.42)			190
	DCMT 11 T3 08-KR	☆	☆	☆	★	2 (1-4)	0.25 (0.12-0.35)	355	300	200
	11 T3 12-KR	☆	☆	☆	★	2 (1.2-4)	0.3 (0.14-0.42)	340	285	190
	SCMT 09 T3 08-KR				★	2 (1-4)	0.25 (0.12-0.35)			200
	09 T3 12-KR				★	2 (1.2-4)	0.3 (0.14-0.42)			190
	TCMT 11 03 08-KR				★	1.5 (0.75-3)	0.21 (0.1-0.3)			210
	11 03 12-KR				★	1.5 (0.9-3)	0.26 (0.12-0.36)			200
	16 T3 08-KR	☆	☆	☆	★	2 (1-4)	0.25 (0.12-0.35)	355	300	200
	16 T3 12-KR	☆	☆	☆	★	2 (1.2-4)	0.3 (0.14-0.42)	340	285	190
	VBMT 16 04 08-KR	☆	☆	☆	★	1.8 (0.9-3.6)	0.23 (0.11-0.32)	365	305	205
	16 04 12-KR	☆	☆	☆	★	1.8 (1.1-3.6)	0.27 (0.13-0.38)	350	290	200

¹⁾ Za CMC 09.2 smanjiti brzinu rezanja (v_c) za 10%.



OBRADA ALUMINIJUMA

ISO/ANSI

N

Legure aluminijuma. livene

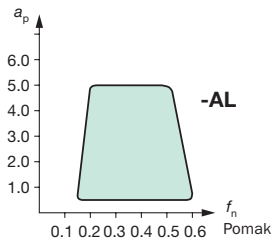
CoroTurn® 107

Jednostrane pločice

CCGX 09 T3 08-AL

 $a_p = 0.5 - 5.0 \text{ mm}$ $f_n = 0.15 - 0.6 \text{ mm/obr}$

Dubina rezanja



-AL- za obradu aluminijuma

Operacije: struganje, čeono struganje i profilisanje.

Komponente: aluminijum i ostale neferitne komponente uopšteno

Prednosti: pozitivna, otvorena geometrija daje male sile rezanja pri velikim brzinama rezanja

Povećana produktivnost



- Kontinualan rez
- Predobrađeni komadi
- akođe i za struganje aluminijuma >12% Si.

NORMALNI POMACI



Sa umetnutim vrhom
(dijamant)

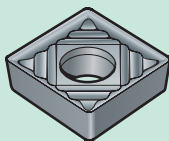
...F / CD10

Prvi izbor

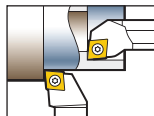


- Opšta namena
- Aluminijum $\leq 12\%$ Si

NORMALNI POMACI

















-AL / H10



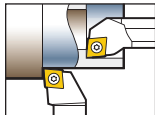
ISO/ANSI

N**OBRADA ALUMINIJUMA**

Pozitivne pločice

KATALOŠKA OZNAKA			CUTTING DATA, CMC 30.21 / HB 75				
Jednostrane pločice  r_e			 CD10	 H10	Dubina rezanja a_e mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)
	CGGX	06 02 02-AL		★	1 (0.3-3)	0.12 (0.05-0.15)	2000
		06 02 04-AL		★	1.5 (0.5-3)	0.2 (0.1-0.3)	2000
		09 T3 04-AL		★	1.5 (0.5-5)	0.2 (0.1-0.3)	2000
		09 T3 08-AL		★	1.5 (0.5-5)	0.3 (0.15-0.6)	2000
	CCMW	06 02 04FP	★		0.5 (0.1-2.3)	0.1 (0.05-0.2)	2000
		09 T3 04FP	★		0.5 (0.1-3.4)	0.1 (0.05-0.2)	2000
		09 T3 08FP	★		1 (0.1-3.4)	0.15 (0.05-0.4)	2000
	DCGX	07 02 02-AL		★	1 (0.3-4)	0.12 (0.05-0.15)	2000
		07 02 04-AL		★	1.5 (0.5-4)	0.2 (0.1-0.3)	2000
		11 T3 02-AL		★	1 (0.3-5.5)	0.12 (0.05-0.15)	2000
		11 T3 04-AL		★	1.5 (0.5-5.5)	0.2 (0.1-0.3)	2000
		11 T3 08-AL		★	1.5 (0.5-5.5)	0.3 (0.15-0.6)	2000
	DCMW	11 T3 04FP	★		0.5 (0.1-3.3)	0.1 (0.05-0.2)	2000
		11 T3 08FP	★		1 (0.1-3)	0.15 (0.05-0.4)	2000
	SCGX	09 T3 08-AL		★	1.5 (0.5-5)	0.3 (0.15-0.6)	2000
	TCGX	09 02 02-AL		★	1 (0.3-4)	0.12 (0.05-0.15)	2000
		09 02 04-AL		★	1.5 (0.5-4)	0.2 (0.1-0.3)	2000
		11 03 02-AL		★	1 (0.3-5)	0.12 (0.05-0.15)	2000
		11 03 04-AL		★	1.5 (0.5-5)	0.2 (0.1-0.3)	2000
		11 03 08-AL		★	1.5 (0.5-5)	0.3 (0.15-0.6)	2000
		16 T3 04-AL		★	1.5 (0.5-7)	0.2 (0.1-0.3)	2000
		16 T3 08-AL		★	1.5 (0.5-7)	0.3 (0.15-0.6)	2000
		16 T3 08-AL		★	1.5 (0.5-7)	0.3 (0.15-0.6)	2000
	TCMW	09 02 04FP	★		0.5 (0.1-2.2)	0.1 (0.05-0.2)	2000
		11 03 04FP	★		0.5 (0.1-2.2)	0.1 (0.05-0.2)	2000
		11 03 08FP	★		1 (0.1-1.9)	0.15 (0.05-0.4)	2000
		16 T3 04FP	★		0.5 (0.1-3.4)	0.1 (0.05-0.2)	2000
		16 T3 08FP	★		1 (0.1-3.1)	0.15 (0.05-0.4)	2000
	TCMW	16 T3 04FRP¹⁾	★		0.5 (0.1-7)	0.1 (0.05-0.2)	2000
		16 T3 04FLP¹⁾	★		0.5 (0.1-7)	0.1 (0.05-0.2)	2000
	VCGX	11 03 02-AL		★	1 (0.3-3)	0.12 (0.05-0.15)	2000
		11 03 04-AL		★	1.5 (0.5-3)	0.2 (0.1-0.3)	2000
		16 04 04-AL		★	1.5 (0.5-5)	0.2 (0.1-0.3)	2000
		16 04 08-AL		★	1.5 (0.5-5)	0.3 (0.15-0.6)	2000
		16 04 12-AL		★	1.5 (0.5-5)	0.4 (0.15-0.8)	2000
	VCMW	11 03 04FP	★		0.5 (0.1-3.5)	0.1 (0.05-0.2)	2000
		16 04 04FP	★		0.5 (0.1-3.5)	0.1 (0.05-0.2)	2000
		16 04 08FP	★		1 (0.1-2.8)	0.15 (0.05-0.4)	2000
		16 04 12FP	★		1 (0.1-2.1)	0.15 (0.05-0.4)	2000
	RCGX	08 03 M0-AL		★	1.5 (0.8-3.2)	0.8 (0.25-1.7)	2000
		10 T3 M0-AL		★	2 (1-4)	0.8 (0.25-2)	2000
		12 04 M0-AL		★	2.5 (1.2-4.8)	1 (0.3-2.5)	2000

¹⁾ R = Desna verzija, L = Leva verzija



ZAVRŠNA OBRADA VATROOTPORNIH LEGURA

ISO/
ANSI**S****F**

Vatrootporne i super legure, HB 350

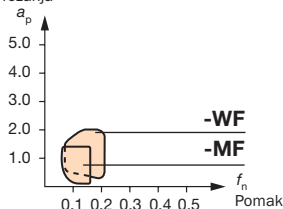
CoroTurn® 107

Jednostrane pločice

CCMT 09 T3 04-WF

 $a_p = 0.3 - 2.1 \text{ mm}$ $f_n = 0.07 - 0.21 \text{ mm/obr}$

CCMT 09 T3 04-MF

 $a_p = 0.1 - 1.4 \text{ mm}$ $f_n = 0.06 - 0.16 \text{ mm/obr}$ Dubina
rezanja

WF – za produktivnu završnu obradu

Operacije: struganje i čeono struganje**Komponente:** vatrootporne super legure uopšteno**Prednosti:** daje duplo bolji kvalitet obrađene površine uz iste pomake. Idealan kada je dobar kvalitet obrađene površine prioritet.

-MF

Operacije: struganje, čeono struganje i profilisanje**Komponente:** vatrootporne super legure uopšteno**Prednosti:** lako-rezna, pozitivna geometrija daje male sile rezanja pogodne za vitke, tankozide i slabo stegnute komponente

DOBRI USLOVI



- Kontinualan rez.
- Predobrađeni komadi.

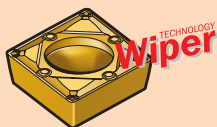
Prvi izbor

PROSEČNI USLOVI



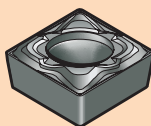
Operacije opšte namene.

VELIKI POMACI



-WF / GC1115

NORMALNI POMACI

-MF / GC1105
(-UM / GC1105)

TEŠKI USLOVI



- Prekinuti rez.
- Male brzine rezanja.
- Teška kora kod otkovaka.

NORMALNI POMACI



-UM / S05F

NORMALNI POMACI

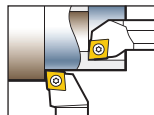
















-MF / GC1115

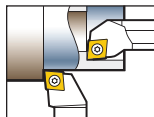
-UM = precizna brušena pločica sa oštrim reznim ivicama.

ISO/
ANSI**S F****ZAVRŠNA OBRADA VATROOTPORNIH LEGURA**

Pozitivne pločice



KATALOŠKA OZNAKA		REŽIMI REZANJA, CMC 20.22/HB 350							
Jednostrane pločice		S05F	GC1115	GC1105	GC1115	Brzina rezanja v_c (m/min)			
						Dubina rezanja a_p mm	Pomak f_n mm/obr	GC1105	GC1115
	CCMT 06 02 04-WF		★			0.8 (0.3-1.4)	0.09 (0.05-0.21)		45
	06 02 08-WF		★			0.8 (0.3-1.4)	0.11 (0.09-0.25)		45
	09 T3 04-WF		★			1 (0.3-2.1)	0.14 (0.07-0.21)		45
	DCMX 07 02 04-WF		★			0.7 (0.3-1.4)	0.08 (0.05-0.18)		45
	07 02 08-WF		★			0.7 (0.3-1.4)	0.11 (0.09-0.25)		45
	11 T3 04-WF		★			1 (0.3-2.1)	0.14 (0.07-0.21)		45
	11 T3 08-WF		★			1 (0.3-2.1)	0.18 (0.12-0.28)		45
	TCMX 09 02 04-WF		★			0.7 (0.3-1.4)	0.08 (0.05-0.21)		45
	09 02 08-WF		★			0.7 (0.3-1.4)	0.15 (0.1-0.2)		45
	11 03 04-WF		★			1 (0.3-1.8)	0.14 (0.07-0.21)		45
	11 03 08-WF		★			1 (0.3-1.8)	0.18 (0.12-0.28)		45
	16 T3 04-WF		★			1.2 (0.3-2.4)	0.14 (0.07-0.2)		45
	16 T3 08-WF		★			1.2 (0.3-2.5)	0.18 (0.12-0.35)		45
				★					
	CCMT 06 02 02-MF				★	0.3 (0.06-1.2)	0.04 (0.03-0.08)		45
	06 02 04-MF				★	0.3 (0.1-1.2)	0.06 (0.05-0.12)		45
	09 T3 02-MF			★	★	0.35 (0.08-1.4)	0.05 (0.04-0.11)		45
	09 T3 04-MF			★	☆	0.35 (0.1-1.4)	0.08 (0.06-0.16)	80	45
	09 T3 08-MF			★	☆	0.35 (0.15-1.4)	0.11 (0.08-0.21)		45
	CCGT 06 02 02-UM				★	0.5 (0.1-1.1)	0.05 (0.02-0.08)		45
	06 02 04-UM				★	1 (0.5-1.4)	0.14 (0.08-0.21)		45
	09 T3 02-UM			★	☆	0.5 (0.1-1.1)	0.05 (0.02-0.08)	80	45
	09 T3 04-UM			★	☆	1.3 (0.5-2.1)	0.11 (0.08-0.18)	80	45
	09 T3 08-UM			★	☆	1.3 (0.5-2.1)	0.14 (0.12-0.25)	80	45
	DCMT 07 02 02-MF				★	0.26 (0.06-1.1)	0.04 (0.03-0.08)		45
	07 02 04-MF				★	0.26 (0.08-1.1)	0.06 (0.05-0.12)		45
	11 T3 02-MF				★	0.35 (0.08-1.4)	0.05 (0.04-0.11)		45
	11 T3 04-MF			★	☆	0.35 (0.11-1.4)	0.08 (0.06-0.16)	80	45
	11 T3 08-MF			★	☆	0.35 (0.15-1.4)	0.11 (0.08-0.21)		45
	DCGT 07 02 02-UM				★	0.5 (0.1-1.1)	0.05 (0.02-0.08)		45
	07 02 04-UM				★	1 (0.5-1.8)	0.11 (0.08-0.18)		45
	11 T3 02-UM			★	☆	0.5 (0.1-1.1)	0.02 (0.01-0.08)	80	45
	11 T3 04-UM			★	☆	1.3 (0.5-2.1)	0.11 (0.08-0.18)	80	45
	11 T3 08-UM		☆	★	☆	1.3 (0.5-2.1)	0.14 (0.12-0.25)	80	45
	SCMT 09 T3 04-MF				★	0.35 (0.11-1.4)	0.08 (0.06-0.16)		45
	09 T3 08-MF				★	0.35 (0.15-1.4)	0.11 (0.08-0.21)		45
	TCMT 09 02 02-MF				★	0.3 (0.06-1.2)	0.04 (0.03-0.09)		45
	09 02 04-MF				★	0.3 (0.1-1.2)	0.07 (0.05-0.13)		45
	11 03 02-MF				★	0.3 (0.06-1.2)	0.04 (0.03-0.09)		45
	11 03 04-MF				★	0.3 (0.1-1.2)	0.07 (0.05-0.13)		45
	11 03 08-MF				★	0.3 (0.13-1.2)	0.09 (0.07-0.18)		45
	16 T3 04-MF				★	0.35 (0.11-1.4)	0.08 (0.06-0.16)		45
	VBMT 11 03 02-MF				★	0.3 (0.06-1.2)	0.04 (0.03-0.09)		45
	11 03 04-MF				★	0.3 (0.1-1.2)	0.07 (0.05-0.13)		45
	11 03 08-MF				★	0.3 (0.13-1.2)	0.09 (0.07-0.18)		45
	16 04 02-MF				★	0.32 (0.07-1.3)	0.05 (0.04-0.09)		45
	16 04 04-MF				★	0.32 (0.1-1.3)	0.07 (0.05-0.14)		45
	VBGT 16 04 02-UM				★	0.5 (0.1-1.1)	0.05 (0.02-0.08)		45
	16 04 04-UM	☆		★	☆	1.3 (0.5-2.8)	0.14 (0.08-0.21)	80	45
	16 04 08-UM			★	☆	1.3 (0.5-2.8)	0.18 (0.12-0.28)	75	45
	VCGT 11 03 01-UM				★	0.3 (0.1-0.7)	0.02 (0.01-0.06)		45
	11 03 02-UM				★	0.5 (0.1-1.1)	0.05 (0.02-0.08)		45
	11 03 04-UM				★	1.3 (0.5-2.1)	0.11 (0.08-0.18)		45
	RCMT 08 03 M0-SM	☆		★	★	1 (0.33-2)	0.2 (0.15-0.3)	70	80
	10 T3 M0-SM	☆		★	★	1.5 (0.4-2.5)	0.25 (0.18-0.4)	80	80
	12 04 M0-SM	☆		★	★	2 (0.5-3)	0.3 (0.2-0.5)	80	80



SREDNJA OBRADA VATROOTPORNIH LEGURA

Vatrootporne i super legure, HB 350

ISO/
ANSI

S

M

CoroTurn® 107

Jednostrane
pločice

CCMT 09 T3 08-MM

$a_p = 0.7 - 2.8 \text{ mm}$

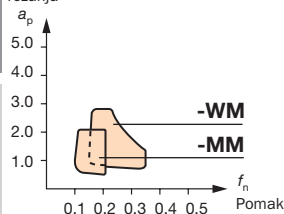
$f_n = 0.15 - 0.35 \text{ mm/obr}$

CCMT 09 T3 08-MM

$a_p = 0.5 - 2.1 \text{ mm}$

$f_n = 0.10 - 0.21 \text{ mm/obr}$

Dubina
rezanja



-WM – za produktivnu srednju obradu struganjem

Operacije: struganje i čeono struganje

Komponente: stabilna vratila, osovine, zupčanici i sl.

Prednosti: daje duplo bolji kvalitet obrađene površine uz iste pomake. Idealan kada je dobar kvalitet obrađene površine prioritet.

-MM

Operacije: struganje, čeono struganje i profilisanje

Komponente: vatrootporne super legure uopšteno

Prednosti: univerzalna, pouzdana obrada bez prisutnih problema

DOBRI USLOVI



- Kontinualan rez.
- Predobrađeni komadi.

Prvi izbor

PROSEČNI USLOVI



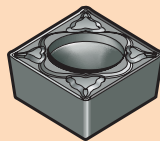
Operacije opšte namene.

VELIKI POMACI



-WM / GC1115

NORMALNI POMACI



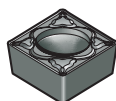
-MM / GC1105
(-UM / GC1105)

TEŠKI USLOVI



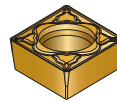
- Prekinuti rez.
- Male brzine rezanja.
- Teška kora kod otkovaka.

NORMALNI POMACI



-MM / GC1105
(-UM / GC1105)

NORMALNI POMACI

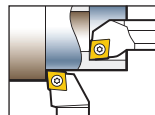


-MM / GC1115

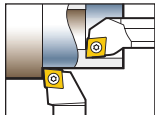
-UM = precizna brušena pločica sa oštrim reznim ivicama.

ISO/
ANSI**S M****SREDNJA OBRADA VATROOTPORNIH LEGURA**

Pozitivne pločice



KATALOŠKA OZNAKA			REŽIMI REZANJA, CMC 20.22/HB 350				Brzina rezanja v_c (m/min)			
Jednostrane pločice		r_ϵ					Dubina rezanja a_p mm	Pomak f_n mm/obr	GC1105	GC1115
 Wiper	CCMT 06 02 08-WM 09 T3 04-WM 09 T3 08-WM			★			1 (0.5-1.8)	0.14 (0.1-0.2)	45	
							1.5 (0.5-2.8)	0.18 (0.12-0.28)		
							1.5 (0.7-2.8)	0.21 (0.15-0.35)		
	DCMX 11 T3 04-WM 11 T3 08-WM			★			1.5 (0.5-2.8)	0.18 (0.12-0.28)	45	
							1.5 (0.5-2.8)	0.21 (0.15-0.35)		
	TCMX 11 03 04-WM			★			1.2 (0.5-2.1)	0.15 (0.12-0.2)	45	
	CCMT 06 02 04-MM 06 02 08-MM 09 T3 04-MM 09 T3 08-MM			☆	★	☆	0.64 (0.2-1.7)	0.08 (0.06-0.12)	80	45
				☆	★	☆	0.64 (0.4-1.7)	0.11 (0.08-0.16)	80	45
				☆	★	☆	0.64 (0.25-2.1)	0.11 (0.08-0.16)	80	45
				☆	★	☆	0.8 (0.5-2.1)	0.14 (0.1-0.21)	80	45
	CCGT 06 02 04-UM 09 T3 04-UM 09 T3 08-UM			☆	★	☆	1 (0.5-1.4)	0.14 (0.08-0.21)	45	
							1.3 (0.5-2.1)	0.11 (0.08-0.18)		
							1.3 (0.5-2.1)	0.14 (0.12-0.25)		
	DCMT 07 02 04-MM 07 02 08-MM 11 T3 04-MM 11 T3 08-MM 11 T3 12-MM			☆	★	☆	0.6 (0.19-1.6)	0.08 (0.06-0.12)	80	45
				☆	★	☆	0.6 (0.38-1.6)	0.11 (0.08-0.16)	80	45
				☆	★	☆	0.8 (0.25-2.1)	0.11 (0.08-0.16)	80	45
				☆	★	☆	0.8 (0.5-2.1)	0.14 (0.1-0.21)	80	45
				☆	★	☆	0.8 (0.6-2.1)	0.17 (0.12-0.25)	80	45
	DCGT 07 02 04-UM 07 02 08-UM 11 T3 04-UM 11 T3 08-UM			☆	★	☆	1 (0.5-1.8)	0.11 (0.08-0.18)	45	
							1 (0.5-1.8)	0.14 (0.12-0.25)		
							1.3 (0.5-2.1)	0.11 (0.08-0.18)		
	SCMT 09 T3 04-MM 09 T3 08-MM			☆	★	☆	0.8 (0.25-2.1)	0.11 (0.08-0.16)	80	45
							0.8 (0.5-2.1)	0.14 (0.1-0.21)		
							0.8 (0.5-2.1)	0.14 (0.1-0.21)		
	TCMT 09 02 04-MM 09 02 08-MM 11 03 04-MM 11 03 08-MM 16 T3 04-MM 16 T3 08-MM 16 T3 12-MM			☆	★	☆	0.6 (0.19-1.6)	0.08 (0.06-0.12)	45	
							0.6 (0.38-1.6)	0.11 (0.08-0.16)		
							0.67 (0.21-1.8)	0.09 (0.06-0.13)		
							0.67 (0.42-1.8)	0.12 (0.09-0.18)		
							0.8 (0.25-2.1)	0.11 (0.08-0.16)		
							0.8 (0.5-2.1)	0.14 (0.1-0.21)		
							0.8 (0.6-2.1)	0.17 (0.12-0.25)		
	TCGT 16 T3 04-UM 16 T3 08-UM			☆	★		1.5 (0.5-2.8)	0.11 (0.08-0.18)	80	
							1.5 (0.5-2.8)	0.14 (0.12-0.25)		
	VBMT 16 04 04-MM 16 04 08-MM 16 04 12-MM			☆	★	☆	0.72 (0.23-1.9)	0.11 (0.07-0.14)	80	45
							0.72 (0.45-1.9)	0.13 (0.09-0.19)		
							0.72 (0.54-1.9)	0.15 (0.11-0.23)		
	VBGT 16 04 04-UM 16 04 08-UM			☆	★	☆	1.3 (0.5-2.8)	0.14 (0.08-0.21)	80	45
							1.3 (0.5-2.8)	0.18 (0.12-0.28)		
	RCMT 08 03 M0-SM 10 T3 M0-SM 12 04 M0-SM			☆	★		1 (0.33-2)	0.2 (0.15-0.3)	70	
							1.5 (0.4-2.5)	0.25 (0.18-0.4)		
							2 (0.5-3)	0.3 (0.2-0.5)		



ZAVRŠNA OBRADA KALJENIH MATERIJALA

Kaljeni materijali, HRC 60

ISO/
ANSI

H

F

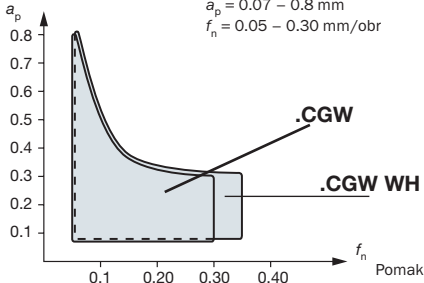
CoroTurn® 107

Jednostrane
pločice

CCGW09T308T01020FWH

 $a_p = 0.07 - 0.8 \text{ mm}$ $f_n = 0.05 - 0.35 \text{ mm/obr}$ Dubina
rezanja

CCGW09T308S01020F

 $a_p = 0.07 - 0.8 \text{ mm}$ $f_n = 0.05 - 0.30 \text{ mm/obr}$ **Operacije:** uzdužno struganje, čeono struganje i profilisanje.**Komponente:** kaljene komponente menjača i upravljačkog dela vozila.**Prednosti:** izvanredan kvalitet obrađene površine na kaljenim materijalima. Ponekad uporediv sa brušenjem.**Moguća optimizacija:** Wiper geometrija WH.

DOBRI USLOVI



- Kontinualan rez.
- Predobrađeni komadi.

VELIKI POMAK



.CGW WH / CB7015

Prvi izbor

PROSEČNI USLOVI



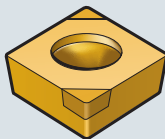
Operacije opšte namene.

VELIKI POMAK



.CGW WH / CB7015

NORMALNI POMACI



.CGW / CB7015

TEŠKI USLOVI



- Prekinuti rez.
- Nestabilni uslovi.

VELIKI POMAK



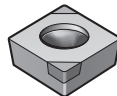
.CGW WH / CB7015

NORMALNI POMACI



.CGW / CB7015

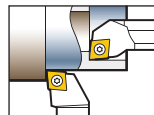
NORMALNI POMACI



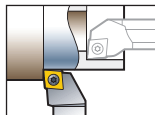
.CGW / CB7015

ISO/
ANSI**H F****ZAVRŠNA OBRADA KALJENIH MATERIJALA**

Pozitivne pločice



KATALOŠKA OZNAKA				REŽIMI REZANJA, CMC 04.1/HRC 60			
Jednostrane pločice		CB7015	CB7025	Dubina rezanja a_p mm	Pomak f_n mm/obr	Brzina rezanja v_c (m/min)	
						CB7015	CB7025
	CCGW 09T304T01020FWH CCGW 09T308T01020FWH	★ ★		0.1(0.07-0.4) 0.2(0.07-0.8)	0.18(0.05-0.25) 0.28(0.05-0.35)	180 155	
	CCGW 09T304S01020FWH CCGW 09T308S01020FWH		★ ★	0.1(0.07-0.4) 0.2(0.07-0.8)	0.18(0.05-0.25) 0.28(0.05-0.35)		145 130
	CCGW 09T304S01020F CCGW 09T308S01020F	★ ★		0.1(0.07-0.4) 0.2(0.07-0.8)	0.1(0.05-0.2) 0.15(0.05-0.3)	215 190	
	CCGW 09T304S01020F CCGW 09T308S01020F		★ ★	0.1(0.07-0.4) 0.2(0.07-0.8)	0.1(0.05-0.2) 0.15(0.05-0.3)		165 150
	DCGW 11T304S01020F 11T308S01020F	★ ★		0.1(0.07-0.4) 0.2(0.07-0.8)	0.1(0.05-0.2) 0.15(0.05-0.3)	215 190	
	DCGW 11T304S01020F 11T308S01020F		★ ★	0.1(0.07-0.4) 0.2(0.07-0.8)	0.1(0.05-0.2) 0.15(0.05-0.3)		165 150
	TCGW 090202S01020F 090204S01020F	★ ★		0.07(0.04-0.2) 0.1(0.07-0.4)	0.07(0.03-0.1) 0.1(0.05-0.2)	235 215	
	TCGW 110304S01020F 110308S01020F	★ ★		0.1(0.07-0.4) 0.2(0.07-0.8)	0.1(0.05-0.2) 0.15(0.05-0.3)	215 190	
	TCGW 090202S01020F 090204S01020F		★ ★	0.07(0.04-0.2) 0.1(0.07-0.4)	0.07(0.03-0.1) 0.1(0.05-0.2)		170 165
	TCGW 110304S01020F 110308S01020F		★ ★	0.1(0.07-0.4) 0.2(0.07-0.8)	0.1(0.05-0.2) 0.15(0.05-0.3)		165 150
	VBGW 160404S01020F 160408S01020F	★ ★		0.1(0.07-0.4) 0.2(0.07-0.8)	0.1(0.05-0.2) 0.15(0.05-0.3)	215 190	
	VBGW 160404S01020F 160408S01020F		★ ★	0.1(0.07-0.4) 0.2(0.07-0.8)	0.1(0.05-0.2) 0.15(0.05-0.3)		165 150



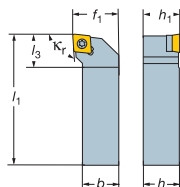
Spoljašnja obrada sa CoroTurn® 107, pozitivnim pločicama

Drške u veličinama 0808 – 2525

CoroTurn® 107 stezanje vijkom

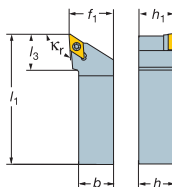
SCLCR/L

κ_r 95°

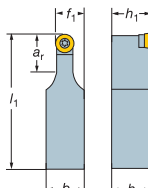


SDJCR/L

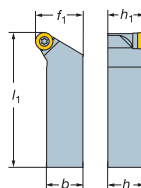
κ_r 93°



SRDCN








SRSCR/L



(neutralan)

Desna verzija prikazana

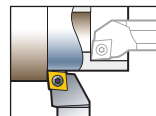
	Pločica	Kataloška oznaka	Dimenzije, mm							 Nm	
			a_r	h	h_1	b	l_1	l_3	f_1		$r_e^{1)}$
 <p>95°</p>	C	SCLCR/L 0808D06	-	8	8	8	60	13	10	0.4	7IP 0.9
		1010E06	-	10	10	10	70	13	12	0.4	
		SCLCR/L 1212F09-M	-	12	12	12	80	19.5	16	0.8	15IP 3.0
		1616H09	-	16	16	16	100	18	20	0.8	
2020K09	-	20	20	20	125	18	25	0.8			
 <p>93°</p>	D	SDJCR/L 1010E07	-	10	10	10	70	17	12	0.4	7IP 0.9
		1212F07	-	12	12	12	80	19	16	0.4	
		1616H07	-	16	16	16	100	19	20	0.4	15IP 3.0
		2020K07	-	20	20	20	125	22	25	0.4	
		SDJCR/L 1616H11	-	16	16	16	100	24	20	0.8	
2020K11	-	20	20	20	125	24	25	0.8			
2525M11	-	25	25	25	150	28	32	0.8			
 <p>90°</p>	R	SRDCN 1616H08	16	16	16	16	100	-	12	-	9IP 1.4
		SRDCN 2020K10-A	25	20	20	20	125	-	15	-	15IP 3.0
		2525M10-A	25	25	25	25	150	-	17.5	-	
SRDCN 2020K12-A	25	20	20	20	125	-	16	-	15IP 3.0		
2525M12-A	28	25	25	25	150	-	18.5	-			
 <p>27°</p>	R	SRSCR/L 2020K10	-	20	20	20	125	-	25	-	15IP 3.0
		2525M10	-	25	25	25	150	-	32	-	
SRSCR/L 2525M12	-	25	25	25	150	-	32	-	15IP 3.0		

¹⁾ r_e = radijus vrha rezne pločice

Primer poručivanja: 2 komada SCLCR 0808D06

(R = Desna verzija, L= Leva verzija)

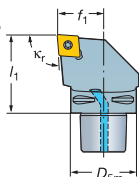
Spoljašnja obrada sa CoroTurn® 107, pozitivnim pločicama



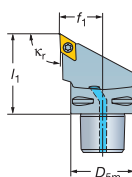
Coromant Capto u veličinama C4 – C6

CoroTurn® 107 stezanje vijkom

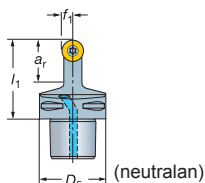
SCLCR/L

 $\kappa_r 95^\circ$ 

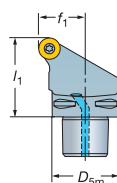
SDJCR/L

 $\kappa_r 93^\circ$ 

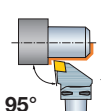
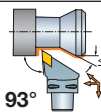
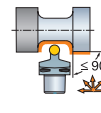
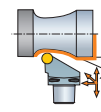
SRDCN



SRSCR/L

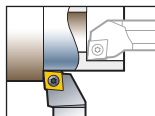


Desna verzija prikazana

Pločica	Veličina	Kataloška oznaka	Dimenzije, mm					Nm	
			a_r	D_{5m}	l_1	f_1	$r_e^{1)}$		
 95°	C	C4	C4-SCLCR/L-27050-09	–	40	50	27	0.8	15IP 3.0
		C5	C5-SCLCR/L-35060-09	–	50	60	35	0.8	
		C6	C6-SCLCR/L-45065-09	–	63	65	45	0.8	
 93°	D	C4	C4-SDJCR/L-27050-07	–	40	50	27	0.4	7IP 0.9
		C5	C5-SDJCR/L-35060-11	–	50	60	35	0.8	15IP 3.0
		C6	C6-SDJCR/L-45065-11	–	63	65	45	0.8	
 ≤ 90°	R	C4	C4-SRDCN -00050-08A	16	40	50	4	–	9IP 1.4
		C5	C5-SRDCN -00060-08A	16	50	60	4	–	
	10	C4	C4-SRDCN -00050-10A	25	40	50	5	–	15IP 3.0
		C5	C5-SRDCN -00060-10A	25	50	60	5	–	
		C6	C6-SRDCN -00065-10A	25	63	65	5	–	
			C6-SRDCN -00065-12A	28	63	65	6	–	15IP 3.0
 ≤ 27°	R	C4	C4-SRSCR/L-27050-08	–	40	50	27	–	9IP 1.4
		C5	C5-SRSCR/L-35060-08	–	50	60	35	–	
	10	C4	C4-SRSCR/L-27050-10	–	40	50	27	–	15IP 3.0
		C5	C5-SRSCR/L-35060-10	–	50	60	35	–	
		C6	C6-SRSCR/L-45065-10	–	63	65	45	–	
			C6-SRSCR/L-45065-12	–	63	65	45	–	15IP 3.0

¹⁾ r_e = radijus vrha rezne pločice

Primer poručivanja: 2 komada C4-SCLCR-27050-09
(R = Desna verzija, L = Leva verzija)



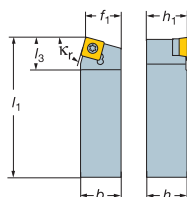
Spoljašnja obrada sa CoroTurn® 107, pozitivnim pločicama

Drške u veličinama 0808 – 2525

CoroTurn® 107 stezanje vijkom

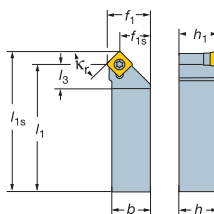
SSBCR/L

$\kappa_r 75^\circ$



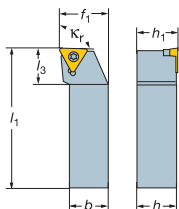
SSDCR/L

$\kappa_r 45^\circ$



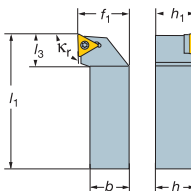
STFCR/L

$\kappa_r 91^\circ$


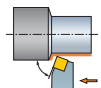
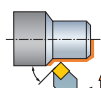
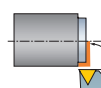
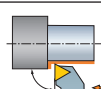


STGCR/L

$\kappa_r 91^\circ$



Desna verzija prikazana

Pločica	Kataloška oznaka	Dimenzije, mm										 Nm	
		h	h_1	b	l_1	l_{1s}	l_3	f_1	f_{1s}	$r_e^{1)}$			
 75°	09	SSBCR/L 1616H09	16	16	16	100	-	15.5	13	-	0.8	15IP 3.0	
	S												
 45°	09	SSDCR/L 1616H09 2020K09	16	16	16	93.9	100	9.4	17	10.9	0.8	15IP 3.0	
	S												
 91°	09	STFCR/L 1010E09	10	10	10	70	-	14	12	-	0.4	7IP 0.9	
	T		11	STFCR/L 1212F11-B1 ²⁾	12	12	12	80	-	16	16		-
			16	STFCR/L 1616H11-B1 ²⁾	16	16	16	100	-	16	20	-	0.4
	16		STFCR/L 1616H16	16	16	16	100	-	22	20	-	0.8	15IP 3.0
	2020K16	20	20	20	125	-	22	25	-	0.8			
	2525M16	25	25	25	150	-	24	32	-	0.8			
 91°	09	STGCR/L 0808D09 1010E09	8	8	8	60	-	13.8	10	-	0.4	7IP 0.9	
	T		10	10	10	70	-	11.8	12	-	0.4		
			11	STGCR/L 1212F11-B1 ²⁾	12	12	12	80	-	16.3	16	-	0.4
	16		STGCR/L 1616H11-B1 ²⁾	16	16	16	100	-	16.3	20	-	0.4	
	STGCR/L 1616H16	16	16	16	100	-	25	20	-	0.8	15IP 3.0		
	2020K16	20	20	20	125	-	26	25	-	0.8			
	2525M16	25	25	25	150	-	27	32	-	0.8			

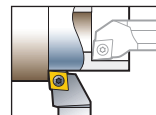
¹⁾ r_e = radijus vrha rezne pločice

²⁾ Za pločice debljine 03 = 3.18 mm

Primer poručivanja: 2 komada SSBCR 1616H09

(R = Desna verzija, L= Leva verzija)

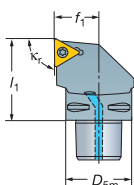
Spoljšanja obrada sa CoroTurn® 107, pozitivnim pločicama




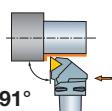

Coromant Capto u veličinama C4 – C6

CoroTurn® 107 stezanje vijkom

STGCR/L

 $\kappa_r 91^\circ$ 

Desna verzija prikazana

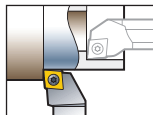
	Pločica	Veličina	Kataloška oznaka	Dimenzije, mm				 Nm
				D_{5m}	l_1	f_1	$r_e^{1)}$	
 91°	 11 16 T	C4	C4-STGCR/L-27050-11-B1 ²⁾	40	50	27	0.4	7IP 0.9
		C4	C4-STGCR/L-27050-16	40	50	27	0.8	15IP 3.0
		C5	C5-STGCR/L-35060-16	50	60	35	0.8	
		C6	C6-STGCR/L-45065-16	63	65	45	0.8	

¹⁾ r_e = radijus vrha rezne pločice

²⁾ Za pločice debljine O3 = 3.18 mm

Primer poručivanja: 2 komada C4-STGCR-27050-11-B1

(R = Desna verzija, L= Leva verzija)



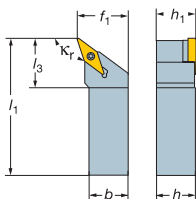
Spoljašnja obrada sa CoroTurn® 107, pozitivnim pločicama

Drške u veličinama 1212 – 2525

CoroTurn® 107 stezanje vijkom

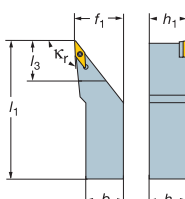
SVHBR/L

κ_r 107.5°



SVJBR/L

κ_r 93°



Desna verzija prikazana

 107.5°	 93°	Pločica	Kataloška oznaka	Dimenzije, mm						 Nm	
				h	h_1	b	l_1	l_3	f_1		$r_e^{1)}$
 107.5°	 93°	 V	SVHBR/L 2020K16	20	20	20	125	31.5	25	0.8	15IP 3.0
			SVHBR/L 2525M16	25	25	25	150	31.5	32	0.8	
 107.5°	 93°	 V	SVJBR/L 1212F11-B1 ²⁾	12	12	12	80	27	16	0.4	7IP 0.9
			SVJBR/L 1616H11-B1 ²⁾	16	16	16	100	27	20	0.4	
			SVJBR/L 2020K11-B1 ²⁾	20	20	20	125	27	25	0.4	
			SVJBR/L 2525M11-B1 ²⁾	25	25	25	150	27	32	0.4	
			SVJBR/L 2020K16	20	20	20	125	31.5	25	0.8	
SVJBR/L 2525M16	25	25	25	150	31.5	32	0.8				

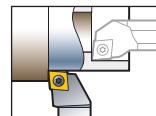
¹⁾ r_e = radijus vrha rezne pločice

²⁾ Za pločice debljine 03 = 3.18 mm

Primer poručivanja: 2 komada SVHBR 2020K16

(R = Desna verzija, L = Leva verzija)

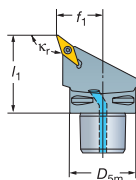
Spoljašnja obrada sa CoroTurn® 107, pozitivnim pločicama



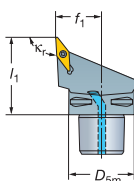
Coromant Capto u veličinama C4 – C6

CoroTurn® 107 stezanje vijkom

SVHBR/L

 κ_r 107.5°

SVJBR/L

 κ_r 93°

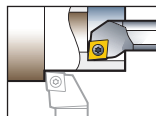
Desna verzija prikazana

	Pločica	Veličina	Kataloška oznaka	Dimenzije, mm				 Nm
				D_{5m}	l_1	f_1	$r_e^{1)}$	
 107.5°	 V	C4	C4-SVHBR/L -27050-11-B1 ²⁾	40	50	27	0.4	7IP 0.9
		C4	C4-SVHBR/L -27050-16	40	50	27	0.8	15IP 3.0
		C5	C5-SVHBR/L -35060-16	50	60	35	0.8	
		C6	C6-SVHBR/L -45065-16	63	65	45	0.8	
 93°	 V	C4	C4-SVJBR/L -27050-11-B1 ²⁾	40	50	27	0.4	7IP 0.9
		C4	C4-SVJBR/L -27050-16	40	50	27	0.8	15IP 3.0
		C5	C5-SVJBR/L -35060-16	50	60	35	0.8	
		C6	C6-SVJBR/L -45065-16	63	65	45	0.8	

¹⁾ r_e = radijus vrha rezne pločice²⁾ Za pločice debljine O3 = 3.18 mm

Primer poručivanja: 2 komada C4-SVHBR-27050-11-B1

(R = Desna verzija, L= Leva verzija)



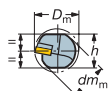
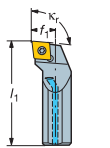
Unutrašnja obrada sa CoroTurn® 107, pozitivnim pločicama

Prečnik drške 8 – 25 mm

CoroTurn® 107 stezanje vijkom

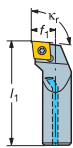
A...-SCLCR/L

$\kappa_r 95^\circ$



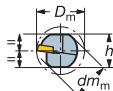
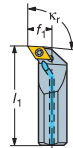
A...-SCLCR/L...R

$\kappa_r 95^\circ$



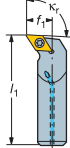
A...-SDUCR/L

$\kappa_r 93^\circ$



A...-SDUCR/L...R

$\kappa_r 93^\circ$



A...-SSKCR/L

$\kappa_r 75^\circ$



A...-SSKCR/L...R

$\kappa_r 75^\circ$



Maks. preput alata $4 \times d_{m\max}$

Dovođenje rashladnog sredstva kroz alat

Desna verzija prikazana

Pločica	Kataloška oznaka	Dimenzije, mm					$r_e^{1)}$	Nm		
		$d_{m\max}$	$D_{m\min}$	f_1	h	l_1				
<p>95°</p>	C	Cilindrična čelična drška sa ravnim delom za stezanje								
		A08H -SCLCR/L 06	8	10	5	7	100	0.4	7IP 0.9	
		A10K -SCLCR/L 06	10	12	6	9	125	0.4	0.4	
		A12M -SCLCR/L 06	12	16	9	11	150	0.4	0.4	
		A16R -SCLCR/L 06	16	20	11	15	200	0.4	0.4	
	A16R -SCLCR/L 09	16	20	11	15	200	0.4	15IP 3.0		
	A20S -SCLCR/L 09	20	25	13	18	250	0.8	0.8		
	A25T -SCLCR/L 09	25	32	17	23	300	0.8	0.8		
	Cilindrična čelična drška ²⁾									
	A08H -SCLCR/L 06-R	8	10	5	-	100	0.4	7IP 0.9		
	A10K -SCLCR/L 06-R	10	12	6	-	125	0.4	0.4		
	A12M -SCLCR/L 06-R	12	16	9	-	150	0.4	0.4		
	A16R -SCLCR/L 06-R	16	20	11	-	200	0.4	0.4		
	A16R -SCLCR/L 09-R	16	20	11	-	200	0.8	15IP 3.0		
A20S -SCLCR/L 09-R	20	25	13	-	250	0.8	0.8			
<p>93°</p>	D	Cilindrična čelična drška sa ravnim delom za stezanje								
		A10K -SDUCR/L 07	10	13	7	9	125	0.4	7IP 0.9	
		A12M -SDUCR/L 07	12	16	9	11	150	0.4	0.4	
		A16R -SDUCR/L 07	16	20	11	15	200	0.4	0.4	
		A20S -SDUCR/L 11	20	25	13	18	250	0.8	15IP 3.0	
	A25T -SDUCR/L 11	25	32	17	23	300	0.8	0.8		
	Cilindrična čelična drška ²⁾									
	A10K -SDUCR/L 07-ER	10	15	9	-	125	0.4	7IP 0.9		
	A12M -SDUCR/L 07-ER	12	18	11	-	150	0.4	0.4		
	A16R -SDUCR/L 07-R	16	20	11	-	200	0.4	0.4		
A20S -SDUCR/L 11-R	20	25	13	-	250	0.8	15IP 3.0			
<p>75°</p>	S	Cilindrična čelična drška sa ravnim delom za stezanje								
		A16R -SSKCR/L 09	16	20	11	15	200	0.8	15IP 3.0	
		A20S -SSKCR/L 09	20	25	13	18	250	0.8	0.8	
		Cilindrična čelična drška ²⁾								
		A16R -SSKCR/L 09-R	16	20	11	-	200	0.8	15IP 3.0	
A20S -SSKCR/L 09-R	20	25	13	-	250	0.8	0.8			

¹⁾ r_e = radius vrha rezne pločice

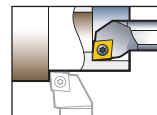
²⁾ Koristiti sa EasyFix čaurama. Videti Glavni Katalog.

Primer poručivanja: 2 komada A08H-SCLCR 06

(R = Desna verzija, L = Leva verzija)

Unutrašnja obrada sa CoroTurn® 107, pozitivnim pločicama

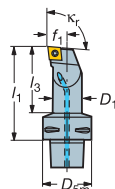
Coromant Capto u veličinama C4 – C5



CoroTurn® 107 stezanje vijkom

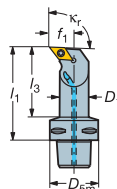
SCLCR/L

$\kappa_r 95^\circ$



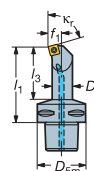
SDUCR/L

$\kappa_r 93^\circ$

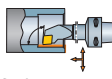
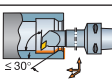
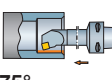


SSKCR/L

$\kappa_r 75^\circ$

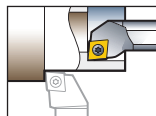


Desna verzija prikazana

Pločica	Veličina	Kataloška oznaka	Dimenzije, mm							Nm
			D_m min	D_1	D_{5m}	f_1	l_1	l_3	$r_e^{1)}$	
 95° C	C4	C4-SCLCR/L -11070-09	20	16	40	11	70	47	0.8	15IP 3.0
		-13080-09	25	20	40	13	80	58	0.8	
		-17090-09	32	25	40	17	90	69	0.8	
 93° D 11	C4	C4-SDUCR/L -11070-07	20	16	40	11	70	47	0.4	7IP 0.9
	C5	C5-SDUCR/L -11070-07	20	16	50	11	70	46	0.4	7IP 0.9
	C4	C4-SDUCR/L -13080-11	25	20	40	13	80	58	0.8	15IP 3.0
		-17090-11	32	25	40	17	90	69	0.8	
		-22110-11	40	32	40	22	110	89	0.8	
	C5	C5-SDUCR/L -13080-11	25	20	50	13	80	56	0.8	15IP 3.0
-17090-11		32	25	50	17	90	67	0.8		
-22110-11		40	32	50	22	110	88	0.8		
 75° S	C4	C4-SSKCR -13080-09	25	20	40	13	80	58	0.8	15IP 3.0
	C5	C5-SSKCR/L -13080-09	25	20	50	13	80	56	0.8	15IP 3.0

¹⁾ r_e = radijus vrha rezne pločice

Primer poručivanja: 2 komada C4-SCLCR-11070-09
(R = Desna verzija, L = Leva verzija)



Unutrašnja obrada sa CoroTurn® 107, pozitivnim pločicama

Prečnik drške 10 – 32 mm

CoroTurn® 107 stezanje vijkom

STFCR/L

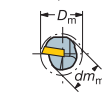
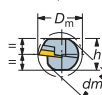
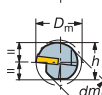
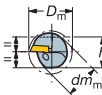
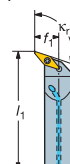
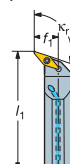
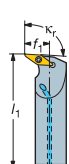
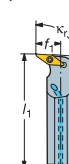
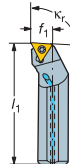
STFCR/L...R

SVUBR/L

SVUBR/L...R


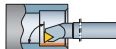

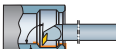

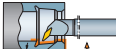

SVQBR/L

SVQBR/L...R

 $\kappa_r 91^\circ$ $\kappa_r 91^\circ$ $\kappa_r 93^\circ$ $\kappa_r 93^\circ$ $\kappa_r 107^\circ 5'$ $\kappa_r 107^\circ 5'$ Maks. preput alata 4 x dm_m

Dovođenje rashladnog sredstva kroz alat

Desna verzija prikazana

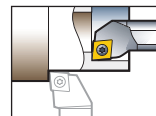
Pločica	Kataloška oznaka	Dimenzije, mm					$r_e^{1)}$		Nm		
		dm_m	D_m	min f_1	h	l_1					
 91°	 T	Cilindrična čelična drška sa ravnim delom za stezanje									
		09	A10K-STFCR/L 09	10	13	7	9	125	0.4	7IP 0.9	
			A12M-STFCR/L 09	12	16	9	11	150	0.4		
		11	A12M-STFCR/L 11-B1 ³⁾	12	16	9	11	150	0.4	7IP 0.9	
			A16R-STFCR/L 11-B1 ³⁾	16	20	11	15	200	0.4		
			A20S-STFCR/L 11-B1 ³⁾	20	25	13	18	250	0.4		
		16	A25T-STFCR/L 16	25	32	17	23	300	0.8	15IP 3.0	
			A32T-STFCR/L 16	32	40	22	30	300	0.8		
			Cilindrična čelična drška ²⁾								
			09	A10K-STFCR/L 09-R	10	13	7	-	125	0.4	7IP 0.9
		A12M-STFCR/L 09-R	12	16	9	-	150	0.4			
	11	A12M-STFCR/L 11-RB1 ³⁾	12	16	9	-	150	0.4	7IP 0.9		
		A16R-STFCR/L 11-RB1 ³⁾	16	20	11	-	200	0.4			
		A20S-STFCR/L 11-RB1 ³⁾	20	25	13	-	250	0.4			
 93°	 V	Cilindrična čelična drška sa ravnim delom za stezanje									
		11	A16R-SVUBR/L 11-EB1 ²⁾	16	22	13	15	200	0.4	7IP 0.9	
			A20S-SVUBR/L 11-EB1 ²⁾	20	27	15	18	250	0.4		
			A25T-SVUBR/L 11-DB1 ²⁾	25	33	18	23	300	0.4		
		16	A25T-SVUBR/L 16-D	25	33	18	23	300	0.8	15IP 3.0	
			A32T-SVUBR/L 16	32	40	22	30	300	0.8		
			Cilindrična čelična drška ²⁾								
			11	A16R-SVUBR/L 11-ERB1 ³⁾	16	22	13	-	200	0.4	7IP 0.9
			16	A20S-SVUBR/L 11-ERB1 ³⁾	20	27	15	-	250	0.4	
		 107°5'	 V	Cilindrična čelična drška sa ravnim delom za stezanje							
11	A16R-SVQBR/L 11-EB1 ³⁾			16	22	13	15	200	0.4	7IP 0.9	
	A20S-SVQBR/L 11-EB1 ³⁾			20	27	15	18	250	0.4		
	A25T-SVQBR/L 11-DB1 ³⁾			25	33	18	23	300	0.4		
16	A25T-SVQBR/L 16-D			25	33	18	23	300	0.8	15IP 3.0	
	A32T-SVQBR/L 16			32	40	22	30	300	0.8		
	Cilindrična čelična drška ²⁾										
	11			A16R-SVQBR/L 11-ERB1 ³⁾	16	22	13	-	200	0.4	7IP 0.9
				A25S-SVQBR/L 11-ERB1 ³⁾	20	27	15	-	250	0.4	

¹⁾ r_e = radijus vrha rezne pločice²⁾ Koristiti sa EasyFix čaurama. Videti Glavni Katalog.³⁾ Za pločice debljine 03 = 3.18 mm

Primer poručivanja: 2 komada A10K-STFCR 09

(R = Desna verzija, L= Leva verzija)

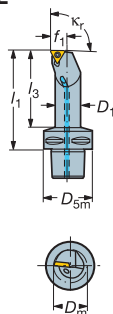
Unutrašnja obrada sa CoroTurn® 107, pozitivnim pločicama



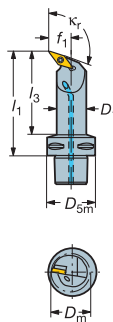
Coromant Capto u veličinama C4 – C6

CoroTurn® 107 stezanje vijkom

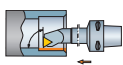
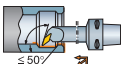
STFCR/L

 $\kappa_r 91^\circ$ 

SVQBR/L

 $\kappa_r 107^\circ 5'$ 

Desna verzija prikazana

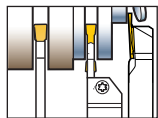
91°	Pločica	Veličina	Kataloška oznaka	Dimenzije, mm							Nm	
				D_m min	D_1	D_{5m}	f_1	l_1	l_3	$r_e^{1)}$		
 91°	11	C4	C4-STFCR/L -11070-11-B1 ²⁾	20	16	40	11	70	47	0.4	7IP	0.9
			-13080-11-B1 ²⁾	25	20	40	13	80	57	0.4	7IP	0.9
	T	C5	C5-STFCR/L -11070-11-B1 ²⁾	20	16	50	11	70	46	0.4	7IP	0.9
			-13080-11-B1 ²⁾	25	20	50	13	80	56	0.4	7IP	0.9
	16	C4	C4-STFCR/L -17090-16	32	25	40	17	90	69	0.8	15IP	3.0
			-22110-16	40	32	40	22	110	89	0.8	15IP	3.0
C5	C5-STFCR/L -17090-16	32	25	50	17	90	67	0.8	15IP	3.0		
	-22110-16	40	32	50	22	110	88	0.8	15IP	3.0		
 107°5'	11	C4	C4-SVQBR/L-13070-11-B1 ²⁾	25	20	40	13	70	48	0.4	7IP	0.9
			-15080-11-B1 ²⁾	27	20	40	15	80	58	0.4	7IP	0.9
	V	C5	C5-SVQBR/L-15080-11-B1 ²⁾	27	20	50	15	80	57	0.4	7IP	0.9
	16	C4	C4-SVQBR/L-18090-16	33	25	40	18	90	69	0.8	15IP	3.0
			-22110-16	40	32	40	22	110	89	0.8	15IP	3.0
C5	C5-SVQBR/L-18090-16	33	25	50	18	90	67	0.8	15IP	3.0		
	-22110-16	40	32	50	22	110	88	0.8	15IP	3.0		
C6	C6-SVQBR/L-22120-16	40	32	63	22	120	94	0.8	15IP	3.0		

1) r_e = radijus vrha rezne pločice

2) Za pločice debljine O3 = 3.18 mm

Primer poručivanja: 2 komada C4-STFCR-11070-11-B1

(R = Desna verzija, L= Leva verzija)



Kako koristiti priručnik



Definišite operaciju

Pogledajte strane sa pločicama za geometrije, kvalitete i režime rezanja

Pogledajte strane sa nosačima za izbor nosača



Odsecanje malih prečnika

CoroCut® 3



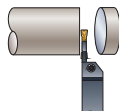
Strana 112



Strane 122-123

Odsecanje srednjih prečnika

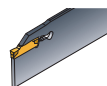
CoroCut® 1-2 T-Max Q-Cut® 151.2



Strana 110



Strana 112



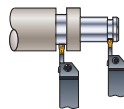
Strana 124



Strane 126-128

Ukopavanje

CoroCut® 1-2



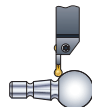
Strana 114



Strane 126-128

Profilisanje

CoroCut® 1-2



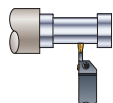
Strane 116-119



Strane 126-128

Struganje

CoroCut® 1-2



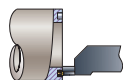
Strana 120



Strane 126-128

Čeono ukopavanje

CoroCut® 1-2



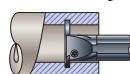
Strana 120



Strana 129

Unutrašnje ukopavanje

CoroCut® 1-2 T-Max Q-Cut® 151.3



Strana 110

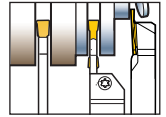


Strana 131

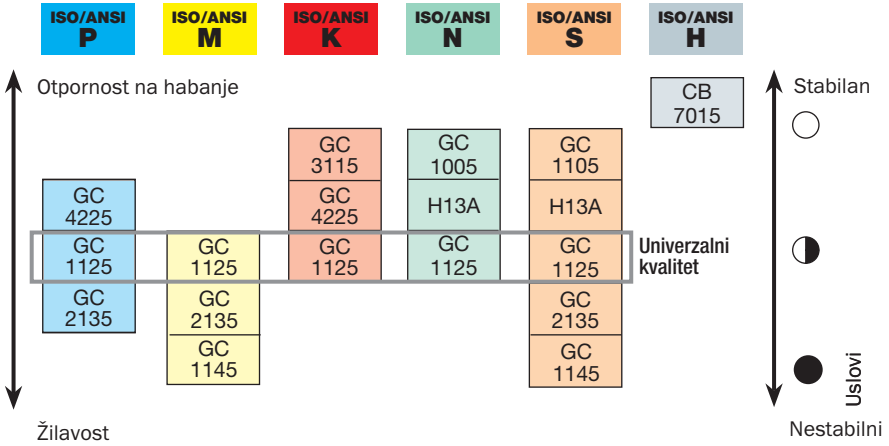


Strane 130-131

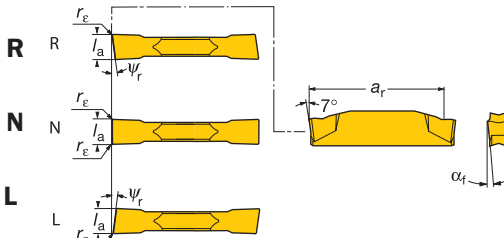
Opšte smernice



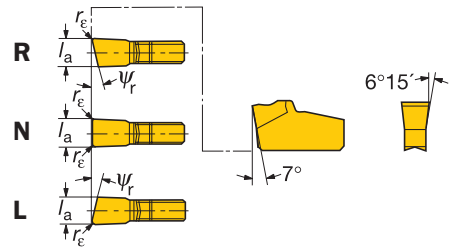
Pregled kvaliteta



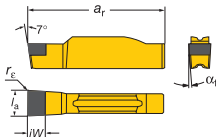
Dimenzije CoroCut® 1-2 pločica



Dimenzije T-Max Q-Cut® pločica



Za pločice sa umetnutim vrhom CBN / CD

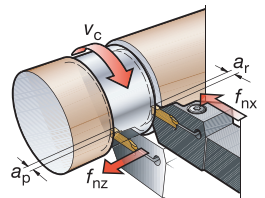


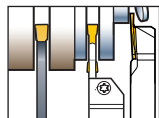
Tolerancija I_a dimenzije

Geometrija	Tolerancija, mm
CoroCut®	
-CF, -CM, -CR, -GM, -RM, -TF, -TM	0/+0.1
-GF, -GE, -RO, -RE, -RS, -AM	±0.02
T-Max Q-Cut®	
-5F, -5E, -4E,	0/+0.25

Smer pomaka

f_{nx} – prav, radijalan pomak u pravcu centra
 f_{nz} – prav, aksijalan pomak u pravcu ose





Odsecanje malih prečnika $\varnothing \leq 12$ mm

CoroCut® 3

ISO/ANSI



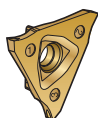
DOBRI USLOVI



Izbor malih pomaka

Za odsecanje bez pipaka i pucni

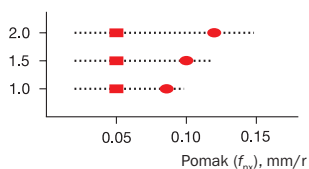
-CS



- Oštra rezna ivica.
- Širok izbor napadnih uglova

Radijalni pomak

Širina pločice (l_a), mm



Prvi izbor!

PROSEČNI USLOVI



Izbor srednjih pomaka

Za odsecanje cevi i šipki

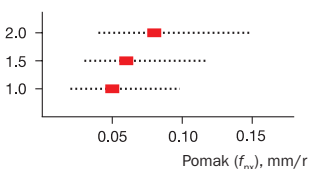
-CM



- Lomljenje strugotine
- Preporučeno za normalne uslove rezanja

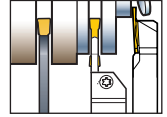
Radijalni pomak

Širina pločice (l_a), mm



P	-CS / GC1125	-CM / GC1125
M	-CS / GC1125	-CM / GC1125
N	-CS / GC1125	
S	-CS / GC1125	

Odsecanje

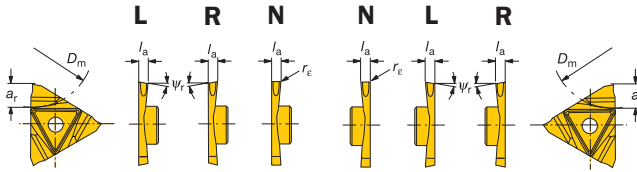


CoroCut® 3 123T

123U

Desna rezna pločica

Leva rezna pločica



Tolerancije, mm

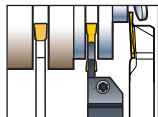
N123 -CM	$l_a \pm 0.03$ $r_e + 0, -0.1$
N123 -CS	$l_a \pm 0.03$ $r_e + 0.1, -0$
R/L123 -CS	$l_a + 0.03, -0.07$ $r_e + 0.1, -0$

	Veličina sedišta ¹⁾	Primer poručivanja	Dimenzije, mm	Preporuke za izbor kvaliteta i režima rezanja										
				f_{nx} mm/r	Kvaliteti									
			l_a	ψ_r	r_e	D_m max	a_r max	P	M	N	S			
Mali pomaci Bez pipka i pucni	T	N123T3 -0100-0000-CS	★	1.00	0°	0	50	4.3	0.05 (0.03 – 0.10)	Prvi izbor	GC1125	GC1125	GC1125	GC1125
		R/L123T3 -0100-0500-CS	★	1.00	5°	0	50	4.2	0.05 (0.02 – 0.09)					
		-0100-1000-CS	★	1.00	10°	0	50	4.2	0.04 (0.02 – 0.08)					
		-0100-1500-CS	★	1.00	15°	0	50	4.2	0.04 (0.02 – 0.07)					
		N123T3 -0150-0000-CS	★	1.50	0°	0	100	6.4	0.05 (0.03 – 0.12)					
		R/L123T3 -0150-0500-CS	★	1.50	5°	0	100	6.3	0.05 (0.02 – 0.11)					
		-0150-1000-CS	★	1.50	10°	0	100	6.3	0.04 (0.02 – 0.10)					
		-0150-1500-CS	★	1.50	15°	0	100	6.3	0.04 (0.02 – 0.08)					
		N123T3 -0200-0000-CS	★	2.00	0°	0	100	6.4	0.05 (0.03 – 0.15)					
		R/L123T3 -0200-0500-CS	★	2.00	5°	0	100	6.3	0.05 (0.02 – 0.14)					
	R/L123T3 -0200-1000-CS	★	2.00	10°	0	100	6.3	0.04 (0.02 – 0.12)						
	R/L123T3 -0200-1500-CS	★	2.00	15°	0	100	6.3	0.04 (0.02 – 0.11)						
	U	N123U3 -0100-0000-CS	★	1.00	0°	0	50	4.3	0.05 (0.03 – 0.10)	v_c m/min	140	125	1500	25
		R/L123U3 -0100-0500-CS	★	1.00	5°	0	50	4.2	0.05 (0.02 – 0.09)					
		R/L123U3 -0100-1000-CS	★	1.00	10°	0	50	4.2	0.04 (0.02 – 0.08)					
		R/L123U3 -0100-1500-CS	★	1.00	15°	0	50	4.2	0.04 (0.02 – 0.07)					
		N123U3 -0150-0000-CS	★	1.50	0°	0	100	6.4	0.05 (0.03 – 0.12)					
		R/L123U3 -0150-0500-CS	★	1.50	5°	0	100	6.3	0.05 (0.02 – 0.11)					
		-0150-1000-CS	★	1.50	10°	0	100	6.3	0.04 (0.02 – 0.10)					
		-0150-1500-CS	★	1.50	15°	0	100	6.3	0.04 (0.02 – 0.08)					
N123U3 -0200-0000-CS		★	2.00	0°	0	100	6.4	0.05 (0.03 – 0.15)						
-0200-0500-CS		★	2.00	5°	0	100	6.3	0.05 (0.02 – 0.14)						
-0200-1000-CS	★	2.00	10°	0	100	6.3	0.04 (0.02 – 0.12)							
-0200-1500-CS	★	2.00	15°	0	100	6.3	0.04 (0.02 – 0.11)							
Srednji pomaci Normalni uslovi rezanja	T	N123T3 -0100-0001-CM	★	1.00	0°	0.10	50	4.3	0.05 (0.02 – 0.10)	Prvi izbor	GC1125	GC1125		
		-0150-0001-CM	★	1.50	0°	0.10	100	6.4	0.05 (0.02 – 0.13)					
		-0200-0001-CM	★	2.00	0°	0.10	100	6.4	0.05 (0.02 – 0.15)					
	U	N123U3 -0100-0001-CM	★	1.00	0°	0.10	50	4.3	0.05 (0.02 – 0.10)		125	125		
		-0150-0001-CM	★	1.50	0°	0.10	100	6.4	0.05 (0.02 – 0.13)					
		-0200-0001-CM	★	2.00	0°	0.10	100	6.4	0.05 (0.02 – 0.15)					
				v_c m/min										

¹⁾ Da odgovara veličini sedišta na nosaču.

T= Desna rezna jedinka, U= Leva rezna jedinka

Primer poručivanja: N123T3-0100-0000-CS 1125
R = Desna verzija, N= neutralan, L = Leva verzija



Odsecanje srednjih prečnika $\varnothing \leq 40$ mm

CoroCut® 1-2

ISO/ANSI



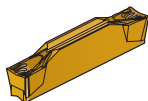
DOBRI USLOVI



Izbor malih pomaka

Za Odsecanje cevi

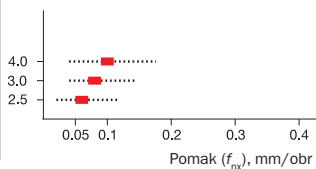
-CF



- Dobra kontrola strugotine pri malim pomacima.
- Pozitivna geometrija eliminiše rizik pojave naslaga na reznoj ivici.
- Lako rezanje.
- Daje dobru obrađenu površinu, usled wiper dizajna na strani.

Radijalni pomak

Širina pločice (l_a), mm



Prvi izbor!

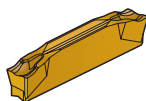
PROSEČNI USLOVI



Izbor srednjih pomaka

Za odsecanje cevi i šipki

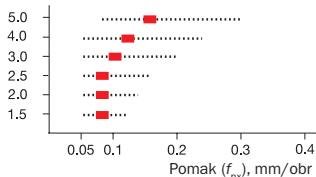
-CM



- Preporuka za komponente tankih zidova i malih prečnika.
- Pozitivna geometrija eliminiše rizik pojave naslaga na reznoj ivici.
- Male sile rezanja smanjuju vibracije.

Radijalni pomak

Širina pločice (l_a), mm



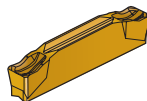
TEŠKI USLOVI



Izbor velikih pomaka

Za odsecanje šipki

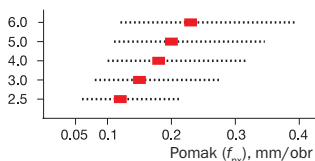
-CR



- Jake rezne ivice smanjuju rizik od krzanja pločice.
- Za odsecanje šipki i prekidan rez.

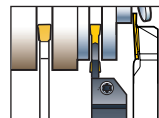
Radijalni pomak

Širina pločice (l_a), mm



P	-CF / GC1125	-CM / GC1125	-CR / GC2135
M	-CF / GC1125	-CM / GC2135	-CR / GC1145
K	-CF / GC1125	-CM / GC4225	-CR / GC4225
S	-CF / GC1125	-CM / GC1145	-CR / GC1145

Odsecanje



CoroCut® 1-2

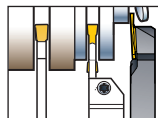
	Veličina sedišta ¹⁾	Kataloška oznaka	Dimenzije, mm ²				Preporuke za izbor kvaliteta i režima rezanja		Kvaliteti						
			GC425	GC1125	GC1145	GC2195	l_a	Ψ_r	r_ϵ	a	f_{nx} mm/obr	P	M	K	S
												Prvi izbor			
Mali pomaci	Odsecanje cevi	F	N123F2-0250-0001-CF R/L123F2-0250-0501-CF	★	★	★	2.50 0° 0.10 18.4	0.04 (0.02 - 0.12)							
		G	N123G2-0300-0001-CF R/L123G2-0300-0501-CF	★	★	★	2.50 5° 0.15 18.4	0.04 (0.02 - 0.11)							
		H	N123H2-0400-0001-CF R/L123H2-0400-0501-CF	★	★	★	3.00 0° 0.10 18.4	0.08 (0.04 - 0.15)							
				★	★	★	3.00 5° 0.15 18.3	0.07 (0.04 - 0.13)							
				★	★	★	4.00 0° 0.15 23.3	0.10 (0.04 - 0.18)							
		★	★	★	4.00 5° 0.15 25.3	0.09 (0.04 - 0.16)									
Srednji pomaci	Odsecanje cevi i šipki	D	N123D2-0150-0002-CM	★	★	★	1.50 0° 0.20 12.9	0.06 (0.03 - 0.17)							
		E	N123E2-0200-0002-CM R/L123E2-0200-0502-CM	★	★	★	2.00 0° 0.20 19.0	0.06 (0.03 - 0.17)							
				★	★	★	2.00 5° 0.20 19.0	0.05 (0.03 - 0.15)							
		F	N123F2-0250-0002-CM R/L123F2-0250-0502-CM	★	★	★	2.50 0° 0.20 18.9	0.08 (0.03 - 0.15)							
				★	★	★	2.50 5° 0.20 18.9	0.07 (0.03 - 0.13)							
		G	N123G2-0300-0002-CM R/L123G2-0300-0502-CM	★	★	★	3.00 0° 0.20 18.9	0.13 (0.04 - 0.25)							
				★	★	★	3.00 5° 0.20 18.8	0.11 (0.03 - 0.23)							
		H	N123H2-0400-0002-CM R/L123H2-0400-0502-CM	★	★	★	4.00 0° 0.20 24.1	0.12 (0.05 - 0.24)							
★	★			★	4.00 5° 0.20 24.1	0.11 (0.05 - 0.22)									
J	N123J2-0500-0002-CM R/L123J2-0500-0502-CM	★	★	★	5.00 0° 0.20 24.1	0.15 (0.07 - 0.30)									
		★	★	★	5.00 5° 0.20 24.1	0.14 (0.06 - 0.27)									
Veliki pomaci	Odsecanje šipki	F	N123F2-0250-0003-CR R/L123F2-0250-0503-CR	★	★	★	2.50 0° 0.30 18.9	0.12 (0.04 - 0.19)							
				★	★	★	2.50 5° 0.30 18.9	0.11 (0.03 - 0.17)							
		G	N123G2-0300-0003-CR R/L123G2-0300-0503-CR	★	★	★	3.00 0° 0.30 18.9	0.15 (0.05 - 0.28)							
				★	★	★	3.00 5° 0.30 18.8	0.14 (0.05 - 0.25)							
		H	N123H2-0400-0003-CR R/L123H2-0400-0503-CR	★	★	★	4.00 0° 0.30 23.7	0.18 (0.10 - 0.32)							
				★	★	★	4.00 5° 0.30 23.7	0.16 (0.09 - 0.28)							
		J	N123J2-0500-0004-CR R/L123J2-0500-0504-CR	★	★	★	5.00 0° 0.40 23.7	0.20 (0.11 - 0.35)							
				★	★	★	5.00 5° 0.40 23.6	0.18 (0.10 - 0.32)							
K	N123K2-0600-0004-CR	★	★	★	6.00 0° 0.40 23.5	0.23 (0.12 - 0.40)									

¹⁾ Da odgovara veličini sedišta na nosaču.

Primer poručivanja: 10 komada N123F2-0250-0001-CF 1125

R= Desna, N = Neutralna, L = Leva verzija

²⁾ Za crtež sa dimenzijama pogledati stranu 107



Odsecanje velikih prečnika $\varnothing 40 - 110$ mm

T-Max Q-Cut®

ISO/ANSI



DOBRI USLOVI



Izbor malih pomaka

Za odsecanje bez pucne

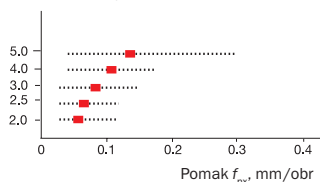
-5F



- Oštra rezna ivica.
- Širok izbor napadnih uglova

Radijalni pomak

Širina pločice (l_d), mm



Prvi izbor!

PROSEČNI USLOVI



Izbor srednjih pomaka

Za odsecanje cevi i šipki

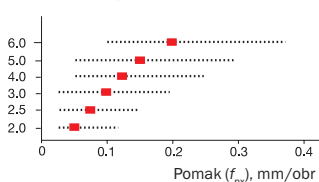
-5E



- Male sile rezanja .
- Preporučeno za cevi i komponente malih prečnika.

Radijalni pomak

Širina pločice (l_d), mm



TEŠKI USLOVI



Izbor velikih pomaka

Za odsecanje šipki

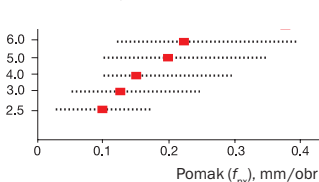
-4E



- Jaka rezna ivica.
- Odlična za prekidan rez i operacije koje zahtevaju žilavost

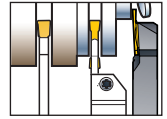
Radijalni pomak

Širina pločice (l_d), mm



P	-5F / GC1125	-5E / GC1125	-4E / GC2135
M	-5F / GC1125	-5E / GC2135	-4E / GC1145
K	-5F / GC1125	-5E / GC4225	-4E / GC4225
N		-5E / H13A	-4E / H13A
S	-5F / GC1125	-5E / GC1145	-4E / GC1145

Odsecanje



T-Max Q-Cut®

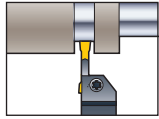
	Veličina sedišta ¹⁾	Kataloška oznaka					Dimenzije, mm ²			Preporuke za izbor kvaliteta i režima rezanja							
			H13A	GC4225	GC1125	GC2135	GC1145	l_a	ψ_r	r_e	f_{mx} mm/obr	Kvaliteti					
												P	M	K	N	S	
Mali pomaci Bez pucne	20	N151.2-200-5F			★			2.00	0°	0.20	0.04 (0.03 – 0.12)	Prvi izbor					
		R/L151.2-200 05-5F			★			2.00	5°	0.10	0.04 (0.03 – 0.11)	GC1125	GC1125	GC1125	GC1125		
		-200 08-5F			★			2.00	8°	0.10	0.03 (0.03 – 0.10)						
		-200 12-5F			★			2.00	12°	0.10	0.03 (0.02 – 0.09)						
		-200 15-5F			★			2.00	15°	0.10	0.03 (0.02 – 0.09)						
		-200 20-5F			★			2.00	20°	0.10	0.02 (0.02 – 0.07)						
	25	N151.2 -250-5F			★			2.50	0°	0.20	0.06 (0.03 – 0.15)	v_c m/min					
		R/L151.2-250 05-5F			★			2.50	5°	0.10	0.05 (0.03 – 0.14)	140	125	95	25		
		-250 08-5F			★			2.50	8°	0.10	0.05 (0.02 – 0.13)						
		-250 12-5F			★			2.50	12°	0.10	0.05 (0.02 – 0.11)						
		-250 15-5F			★			2.50	15°	0.10	0.04 (0.02 – 0.11)						
	30	N151.2 -300-5F			★			3.00	0°	0.20	0.08 (0.03 – 0.20)						
		R/L151.2-300 05-5F			★			3.00	5°	0.10	0.07 (0.03 – 0.18)						
		-300 08-5F			★			3.00	8°	0.10	0.07 (0.03 – 0.17)						
		-300 12-5F			★			3.00	12°	0.10	0.06 (0.02 – 0.15)						
40	N151.2 -400-5F			★			4.00	0°	0.20	0.10 (0.05 – 0.25)							
	R/L151.2-400 05-5F			★			4.00	5°	0.10	0.09 (0.04 – 0.22)							
	-400 08-5F			★			4.00	8°	0.10	0.08 (0.04 – 0.21)							
50	N151.2 -500-5F			★			5.00	0°	0.20	0.12 (0.05 – 0.30)							
	R/L151.2-500 05-5F			★			5.00	5°	0.10	0.11 (0.05 – 0.27)							
Srednji pomaci Odsecanje cevi i šipki	20	N151.2-200-5E	★	★	★	★	★	2.00	0°	0.20	0.06 (0.03 – 0.17)	Prvi izbor					
		N151.2-250-5E	★	★	★	★	★	2.50	0°	0.20	0.08 (0.03 – 0.15)	GC1125	GC2135	GC4225	H13A	GC1145	
	30	N151.2-300-5E	★	★	★	★	★	3.00	0°	0.20	0.13 (0.04 – 0.25)						
		R/L151.2-300 05-5E	★	★	★	★	★	3.00	5°	0.20	0.11 (0.03 – 0.23)						
	40	N151.2-400-5E	★	★	★	★	★	4.00	0°	0.20	0.12 (0.05 – 0.24)						
		R/L151.2-400 05-5E	★	★	★	★	★	4.00	5°	0.20	0.11 (0.04 – 0.22)						
	50	N151.2-500-5E	★	★	★	★	★	5.00	0°	0.20	0.15 (0.04 – 0.24)						
		R151.2-500 05-5E	★	★	★	★	★	5.00	5°	0.20	0.14 (0.04 – 0.22)						
		L151.2-500 05-5E	★	★	★	★	★	5.00	5°	0.20	0.14 (0.04 – 0.22)						
	60	N151.2-600-5E	★	★	★	★	★	6.00	0°	0.20	0.20 (0.09 – 0.36)						
		R/L151.2-600 05-5E	★	★	★	★	★	6.00	5°	0.20	0.18 (0.08 – 0.33)	v_c m/min					
										140	90	125	1500	20			
Veliki pomaci Odsecanje šipki	25	N151.2-250-4E	★	★	★	★	★	2.50	0°	0.30	0.10 (0.03 – 0.17)	Prvi izbor					
		N151.2-300-4E	★	★	★	★	★	3.00	0°	0.30	0.12 (0.05 – 0.24)	GC2135	GC1155	GC4225	H13A	GC1145	
	R/L151.2-300 05-4E	★	★	★	★	★	3.00	5°	0.30	0.11 (0.04 – 0.22)							
	40	N151.2-400-4E	★	★	★	★	★	4.00	0°	0.30	0.15 (0.10 – 0.30)						
		R/L151.2-400 05-4E	★	★	★	★	★	4.00	5°	0.30	0.14 (0.09 – 0.27)						
	50	N151.2-500-4E	★	★	★	★	★	5.00	0°	0.40	0.18 (0.10 – 0.35)						
		R/L151.2-500 05-4E	★	★	★	★	★	5.00	5°	0.30	0.16 (0.09 – 0.31)	v_c m/min					
	60	N151.2-600-4E	★	★	★	★	★	6.00	0°	0.40	0.22 (0.13 – 0.39)	140	90	125	415	20	
		R/L151.2-600 05-4E	★	★	★	★	★	6.00	5°	0.30	0.20 (0.11 – 0.35)						

¹⁾ Da odgovara veličini sedišta na nosaču.

²⁾ Za crtež sa dimenzijama pogledati stranu 107

Primer poručivanja: 10 komada N151.2-200-5F 1125
R= Desna, N = Neutralna, L = Leva verzija





Ukopavanje

CoroCut® 1-2

ISO/ANSI

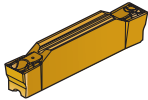


DOBRI USLOVI



Izbor malih pomaka

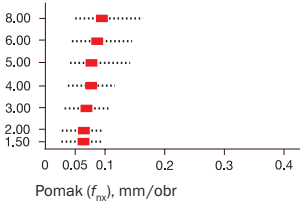
-GF



- Oštra rezna ivica.
- Male sile rezanja i dobar kvalitet obrađene površine.
- Uske tolerancije

Radijalni pomak

Širina pločice (l_a), mm



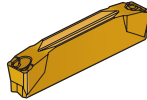
Prvi izbor!

PROSEČNI USLOVI



Izbor srednjih pomaka

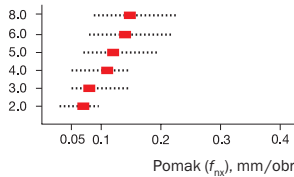
-GM



- Izvanredna kontrola strugotine.
- Umanjuje debljinu strugotine dajući odličan kvalitet površine.

Radijalni pomak

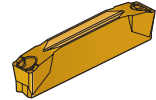
Širina pločice (l_a), mm



TEŠKI USLOVI

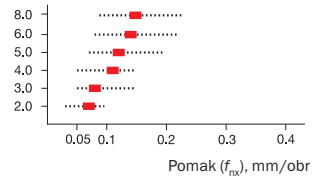


-GM



Radijalni pomak

Širina pločice (l_a), mm



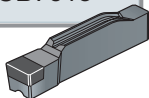
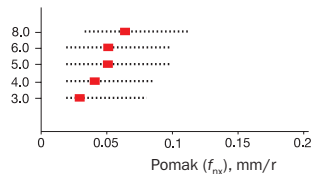
P	-GF / GC1125	-GM / GC4225	-GM / GC2135
M	-GF / GC1125	-GM / GC1125	-GM / GC1145
K	-GF / GC1125	-GM / GC3115	-GM / GC4225
N	-GF / H13A	-GM / H13A	
S	-GF / GC1105		
H	S01025 / CB7015		

Za kaljene materijale

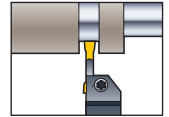
- CBN pločica
- Uske tolerancije i odličan kvalitet obrađene površine

Radijalni pomak

Širina pločice (l_a), mm



Ukopavanje



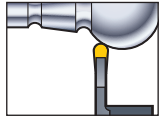
CoroCut® 1-2

	Veličina sedišta ¹⁾	Kataloška oznaka	Dimenzije, mm					Preporuke za izbor kvaliteta i režima rezanja													
			GC1105	H13A	GC3115	GC4225	GC1125	CB7015	l _a	r _e	a _r	f _{max} mm/obr	Kvaliteti								
													P	M	K	N	S	H			
Mali pomaci	D E G H K L	CoroCut 2-edge																			
		N123D2 -0150-0001-GF					★	1.5	0.10	13.3	0.07 (0.03 – 0.14)										
		N123E2 -0200-0002-GF	★	★				2.00	0.20	19.2	0.08 (0.04 – 0.16)										
		-0200-0004-GF		★				2.00	0.40	19.2	0.08 (0.04 – 0.16)										
		N123G2 -0300-0002-GF	★	★				3.00	0.20	19.2	0.09 (0.05 – 0.20)										
		-0300-0004-GF		★				3.00	0.40	19.2	0.09 (0.05 – 0.20)										
		N123H2 -0400-0002-GF	★	★				4.00	0.20	24.4	0.10 (0.05 – 0.22)										
		-0400-0004-GF		★				4.00	0.40	24.4	0.10 (0.05 – 0.22)										
		-0475-0004-GF						4.75	0.40	24.1	0.10 (0.05 – 0.22)										
		-0475-0008-GF						4.75	0.80	24.1	0.10 (0.05 – 0.22)										
		-0500-0002-GF	★	★				5.00	0.20	24.4	0.10 (0.05 – 0.24)										
		-0500-0004-GF		★				5.00	0.40	24.4	0.10 (0.05 – 0.24)										
	N123K2 -0600-0002-GF			★			6.00	0.20	24.4	0.12 (0.06 – 0.29)											
	N123L2 -0800-0002-GF				★		8.00	0.20	29.6	0.18 (0.09 – 0.40)											
	E F G H J	Za ukopavanje kanala za segere ²⁾																			
		N123E2 -0185-0001-GF					★	1.85	0.10	19.3	0.08 (0.04 – 0.16)										
		-0215-0001-GF					★	2.15	0.10	19.3	0.08 (0.04 – 0.16)										
		N123F2 -0265-0002-GF					★	2.65	0.20	19.2	0.09 (0.05 – 0.20)										
N123G2 -0315-0002-GF							3.15	0.20	19.2	0.09 (0.05 – 0.20)											
N123H2 -0415-0002-GF							4.15	0.20	24.4	0.10 (0.05 – 0.22)											
N123J2 -0515-0002-GF							5.15	0.20	24.4	0.10 (0.05 – 0.24)											
v _c m/min																					
140		125	95	1500	35																
Prvi izbor																					
GC1125	GC1125	GC1125	H13A																		
Srednji pomaci	G H J L	CoroCut 1-edge za kaljene materijale																			
		N123G1 -030004S01025					★	3.00	0.40	∞	0.03 (0.02 – 0.08)										
		N123H1 -040004S01025					★	4.00	0.40	∞	0.05 (0.02 – 0.10)										
		-050004S01025					★	5.00	0.40	∞	0.05 (0.02 – 0.10)										
		N123J1 -060004S01025					★	6.00	0.40	∞	0.05 (0.02 – 0.10)										
	N123L1 -080008S01025					★	8.00	0.80	∞	0.07 (0.03 – 0.12)											
	v _c m/min																				
	140	125	95	415																	
	Prvi izbor																				
	GC1125	GC1125	GC1125	H13A																	

¹⁾ Da odgovara veličini sedišta na nosaču.

²⁾ tolerancije, mm la = +0.09 / +0.13.

Primer poručivanja: 10 komada N123D2-0150-0001-GF 1125
N = Neutralna



Profilisanje

CoroCut® 1-2

ISO/ANSI

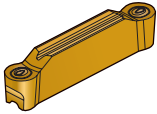


DOBRI USLOVI



Izbor malih pomaka

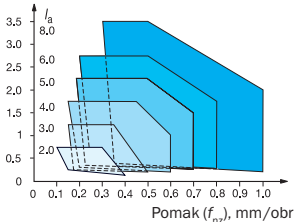
-RO



- Izvredna kontrola strugotine na malim posmacima i dubinama rezanja.
- Dobar kvalitet obrađene površine.

Aksijalni pomak

Dubina rezanja (a_p), mm



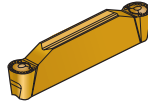
Prvi izbor!

PROSEČNI USLOVI



Izbor srednjih pomaka

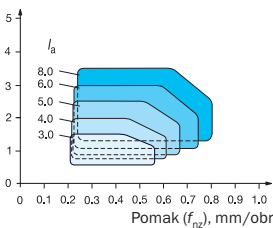
-RM



- Odlično za profilisanje kod svih materijala
- Izvredna kontrola strugotine.
- Dobar kvalitet obrađene površine.

Aksijalni pomak

Dubina rezanja (a_p), mm

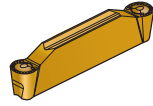


TEŠKI USLOVI



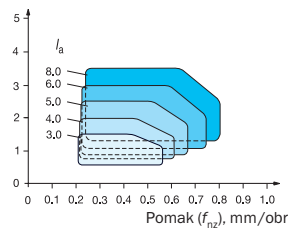
Profilisanje kaljenih materijala

-RM



Aksijalni pomak

Dubina rezanja (a_p), mm



P

-RO / GC1125

-RM / GC4225

-RM / GC2135

M

-RO / GC1125

-RM / GC1125

-RM / GC2135

K

-RO / GC1125

-RM / GC4225

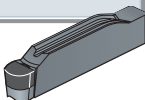
-RM / GC4225

S

-RO / GC1105

H

S01025 / CB7015

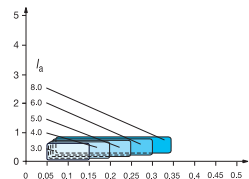


Za kaljene materijale

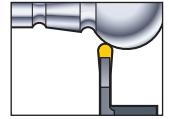
- Pločica sa CBN umetkom
- Izvredna produktivnost i kvalitet obrađene površine
- Pločica sa jednom reznom ivicom

Aksijalni pomak

Dubina rezanja (a_p), mm



Profilisanje



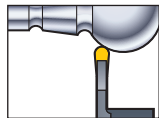
CoroCut® 1-2

	Veličina sedišta ¹⁾	Kataloška oznaka	GC1105	GC4225	GC1125	CB7015	Dimenzije, mm			Preporuke za izbor kvaliteta i režima rezanja ²⁾						
							l_a	r_e	a_r	f_{nx} mm/obr	Kvaliteti					
												P	M	K	N	S
Mali pomaci	E F H J L	CoroCut 2-edge										Prvi izbor				
		N123E2 -0200-RO	★		★			2.00	1.00	19.3	0.25 (0.14 – 0.36)	GC1125	GC1125	GC1125	GC1105	
		N123F2 -0300-RO	★		★			3.00	1.50	18.7	0.30 (0.18 – 0.43)	GC1125	GC1125	GC1125	GC1105	
		N123H2 -0400-RO	★		★			4.00	2.00	23.4	0.45 (0.30 – 0.60)	GC1125	GC1125	GC1125	GC1105	
		-0450-RO			★			4.50	2.25	23.1	0.50 (0.23 – 0.70)	GC1125	GC1125	GC1125	GC1105	
		-0500-RO	★		★			5.00	2.50	22.8	0.50 (0.23 – 0.70)	GC1125	GC1125	GC1125	GC1105	
		N123J2 -0600-RO	★		★			6.00	3.00	22.3	0.60 (0.28 – 0.80)	GC1125	GC1125	GC1125	GC1105	
N123L2 -0800-RO	★		★			8.00	4.00	27.4	0.70 (0.43 – 1.00)	GC1125	GC1125	GC1125	GC1105			
											v_c m/min					
											140	125	95		35	
Srednji pomaci	F G H J L	CoroCut 2-edge										Prvi izbor				
		N123F2 -0300-RM		★	★			3.00	1.50	18.6	0.40 (0.23 – 0.57)	GC4225	GC1125	GC4225		
		N123G2 -0400-RM		★	★			4.00	2.00	18.1	0.40 (0.21 – 0.61)	GC4225	GC1125	GC4225		
		N123H2 -0400-RM		★	★			4.00	2.00	23.2	0.40 (0.21 – 0.61)	GC4225	GC1125	GC4225		
		-0500-RM		★	★			5.00	2.50	22.7	0.44 (0.22 – 0.68)	GC4225	GC1125	GC4225		
		N123J2 -0600-RM		★	★			6.00	3.00	22.2	0.49 (0.24 – 0.68)	GC4225	GC1125	GC4225		
N123L2 -0800-RM		★	★			8.00	4.00	27.0	0.52 (0.24 – 0.80)	GC4225	GC1125	GC4225				
											v_c m/min					
											160	125	125			
Srednji pomaci	F H J	CoroCut 1-edge								iW		Prvi izbor				
		N123F1 -0300S01025				★		3.00	1.50	2.5	0.10 (0.05 – 0.15)					CB7015
		N123H1 -0400S01025				★		4.00	2.00	3.0	0.17 (0.05 – 0.34)					CB7015
		-0500S01025				★		5.00	2.50	3.5	0.17 (0.05 – 0.25)					CB7015
		N123J1 -0600S01025				★		6.00	3.00	4.0	0.20 (0.06 – 0.30)					CB7015
											v_c m/min					
															135	

¹⁾ Da odgovara veličini sedišta na nosaču.

²⁾ Preporučena polazna vrednost za $f_{nx} = 0.4 \times f_{nz}$.

 Primer poručivanja: 10 komada N123E2-0200-RO 1125
 N = Neutralna



Profilisiranje

CoroCut® 1-2



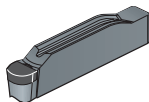
DOBRI USLOVI



Izbor malih pomaka

Profilisiranje neferitnih materijala

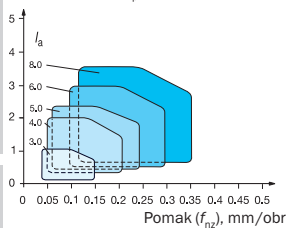
-RS



- Pločica sa umetnutim dijamantom
- Izvredna produktivnost i kvalitet obrađene površine
- Za korišćenje u stabilnim uslovima.
- Pločica sa jednom reznom ivicom

Aksijalni pomak

Dubina rezanja (a_p), mm



Prvi izbor!

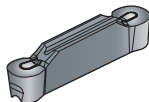
PROSEČNI USLOVI



Izbor srednjih pomaka

Profilisiranje neferitnih materijala

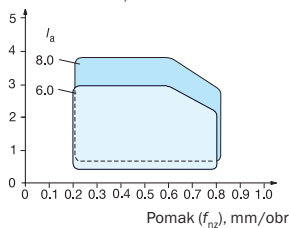
-AM



- Dobra kontrola strugotine i kvalitet obrađene površine.
- Oštra rezna ivica.

Aksijalni pomak

Dubina rezanja (a_p), mm

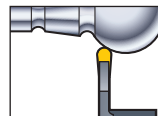


N

-RS / CD10

-AM / GC1005

Profilisanje



CoroCut® 1-2

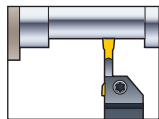
	Veličina sedišta ¹⁾	Kataloška oznaka	CD10	GC1005	Dimenzije, mm				Preporuke za izbor kvaliteta i režima rezanja ²⁾		Kvaliteti												
					l_a	r_ϵ	a_r	iW	f_{nx} mm/obr	N	Prvi izbor												
Mali pomaci	F	CoroCut 1-edge	★		3.00	1.50	∞	2.5	0.10 (0.04 – 0.15)														
		N123F1 -0300-RS												CD10									
		H																★	4.00	2.00	∞	3.0	0.12 (0.05 – 0.21)
		N123H1 -0400-RS -0500-RS																					
		J												★	6.00	3.00	∞	4.0	0.20 (0.10 – 0.30)				
L	★	8.00	4.00	∞	5.0	0.24 (0.11 – 0.35)																	
Srednji pomaci	J	CoroCut 2-edge	★		6.00	3.00	22.2	-	0.50 (0.25 – 0.90)														
		N123J2 -0600-AM												GC1005									
		L																★	8.00	4.00	27.3	-	0.50 (0.25 – 0.90)
		N123L2 -0800-AM												1900									

¹⁾ Da odgovara veličini sedišta na nosaču.

²⁾ Preporučena polazna vrednost za $f_{nx} = 0.4 \times f_{nz}$.

Primer poručivanja: 10 komada N123F1-0300-RS CD10

N = Neutralna



Struganje

CoroCut® 1-2

ISO/ANSI



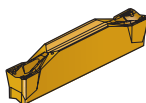
DOBRI USLOVI



Izbor malih pomaka

Za struganje ukopavanjem

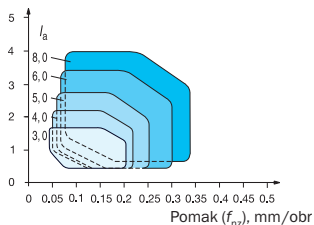
-TF



- Pozitivna geometrija eliminiše rizik pojave naslaga na reznjoj ivici.
- Dobra kontrola strugotine i kvalitet obrađene površine.
- Wiper dizajn sa strane

Aksijalni pomak

Dubina rezanja (a_p), mm



Prvi izbor!

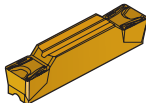
PROSEČNI USLOVI



Izbor srednjih pomaka

Za struganje

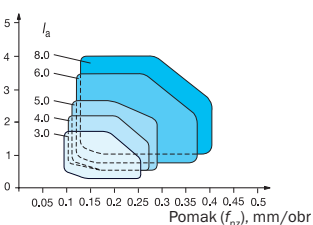
-TM



- Produktivna obrada
- Pozitivna geometrija eliminiše rizik pojave naslaga na reznjoj ivici.

Aksijalni pomak

Dubina rezanja (a_p), mm



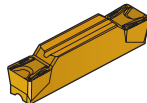
TEŠKI USLOVI



Izbor srednjih pomaka

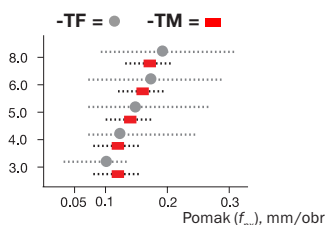
Za struganje

-TM



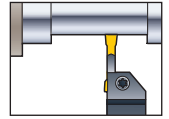
Radijalni pomak

Širina pločice (l_a), mm



P	-TF / GC1125	-TM / GC4225	-TM / GC2135
M	-TF / GC1125	-TM / GC2135	-TM / GC1145
K	-TF / GC4225	-TM / GC4225	-TM / GC4225
N	-TF / H13A	-TM / H13A	
S	-TF / GC1105	-TM / H13A	

Struganje



CoroCut® 1-2

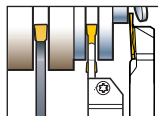
	Veličina sedišta ¹⁾	Kataloška oznaka	GC1145					Dimenzije, mm				Preporuke kvaliteta CoroKey režimi obrade ²⁾							
			GC1105	H13A	GC4225	GC1125	GC2135	l_a	r_ϵ	a_r	Max. a_p	f_{nz} mm/obr	Kvaliteti						
													P	M	K	N	S		
Mali pomaci	G H J K L	CoroCut 2-edge																	
		N123G2 -0300-0003-TF	★	★	★	★		3.00	0.30	18.5	2.6	0.13 (0.04 – 0.23)	Prvi izbor						
		N123H2 -0400-0004-TF	★	★	★	★		4.00	0.40	23.3	3.5	0.15 (0.05 – 0.22)	GC1125	GC1125	GC4225	H13A	GC1105		
		N123J2 -0500-0004-TF	★	★	★	★		5.00	0.40	23.3	3.5	0.183 (0.08 – 0.30)	v_c m/min						
		N123K2 -0600-0004-TF	★	★	★	★		6.00	0.40	23.3	3.8	0.19 (0.08 – 0.30)	140	125	125	1500	35		
		N123L2 -0800-0008-TF	★	★	★	★		8.00	0.80	28.0	4.0	0.22 (0.09 – 0.35)							
Srednji pomaci	G H J K L	CoroCut 2-edge																	
		N123G2 -0300-0004-TM	★	★		★	★	3.00	0.40	18.4	3.5	0.20 (0.10 – 0.25)	Prvi izbor						
		N123H2 -0400-0004-TM	★	★		★	★	4.00	0.40	23.4	4.6	0.20 (0.10 – 0.27)	GC4225	GC2135	GC4225	H13A	H13A		
		-0400-0008-TM	★	★		★	★	4.00	0.80	23.4	4.6	0.20 (0.10 – 0.27)							
		N123J2 -0500-0004-TM	★	★		★	★	5.00	0.40	23.4	4.6	0.22 (0.14 – 0.30)	v_c m/min						
		-0500-0008-TM	★	★		★	★	5.00	0.80	23.0	4.6	0.22 (0.14 – 0.30)	160	90	125	1500	15		
		N123K2 -0600-0004-TM	★	★		★	★	6.00	0.40	23.4	4.5	0.23 (0.15 – 0.37)							
		-0600-0008-TM	★	★		★	★	6.00	0.80	23.0	4.5	0.23 (0.15 – 0.37)							
		N123L2 -0800-0008-TM	★	★		★	★	8.00	0.80	28.0	7.0	0.25 (0.16 – 0.40)							
		-0800-0012-TM	★	★		★	★	8.00	1.20	27.6	7.0	0.25 (0.16 – 0.40)							

¹⁾ Da odgovara veličini sedišta na nosaču.

²⁾ Preporučena polazna vrednost za $f_{nx} = 0.4 \times f_{nz}$.

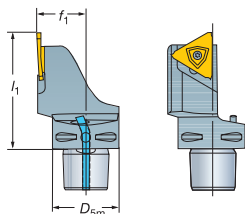
Primer poručivanja: 10 komada N123G2-0300-0003-TF 1125


N = Neutralna



Rezne jedinke za odsecanje malih prečnika

CoroCut® 3

Coromant Capto®
Napomena! Pri upotrebi CoroCut 3 pločica, a_r pločive definiše maksimalnu dubinu rezanja


Veličina sedišta ²⁾	Kataloška oznaka	a_r max	D_{5m}	f_1	l_1	Osnovna pločica	 Nm	
T	C3-RF123T06 -22045BM	6.4	32	22	45	N123T3-0150-CM	15IP	3.0
	C4-RF123T06 -27060BM	6.4	40	27	60			
U	C3-LF123U06 -22045BM	6.4	32	22	45	N123U2-0150-CM	15IP	3.0
	C4-LF123U06 -27060BM	6.4	40	27	60			

¹⁾ Za maks. stabilnost izabrati nosač sa najmanjim mogućim a_r .

²⁾ Da odgovara veličini sedišta na nosaču.

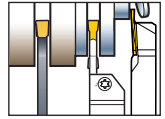
Primer poručivanja: 2 komada C3-RF123T06-22045BM

T= Desna rezna jedinica, U = Leva rezna jedinica

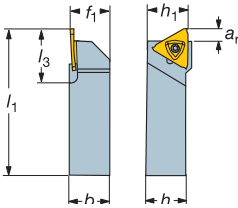
R = Desna verzija, L = Leva verzija




Alati sa prizmatičnom drškom za odsecanje malih prečnika

CoroCut® 3



Napomena! Pri upotrebi CoroCut 3 pločica, a_r pločive definiše maksimalnu dubinu rezanja.



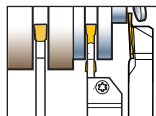
Veličina sedišta ²⁾	Kataloška oznaka Alati sa prizmatičnom drškom	a_r max	b	f_1	h	h_1	l_1	l_3	Osnovna pločica		Nm
T	RF123T06 -1010BM	6.4	10	10	10	10	125	23	N123T3-0150-CM		3.0
	-1212BM	6.4	12	12	12	12	125	23			
	-1616BM	6.4	16	16	16	16	125	23			
	-2020BM	6.4	20	20	20	20	125	23			
	-2525BM	6.4	25	25	25	25	150	23			
	-3232BM	6.4	32	32	32	32	170	23			
U	LF123U06 -1010BM	6.4	10	10	10	10	125	23	N123U3-0150-CM		3.0
	-1212BM	6.4	12	12	12	12	125	23			
	-1616BM	6.4	16	16	16	16	125	23			
	-2020BM	6.4	20	20	20	20	125	23			
	-2525BM	6.4	25	25	25	25	150	23			
	-3232BM	6.4	32	32	32	32	170	23			

¹⁾ Za maks. stabilnost izabrati nosač sa najmanjim mogućim a_r .

²⁾ Da odgovara veličini sedišta pločice.

Primer poručivanja: 2 komada RF123T06-1010BM

R = Desna verzija, L = Leva verzija

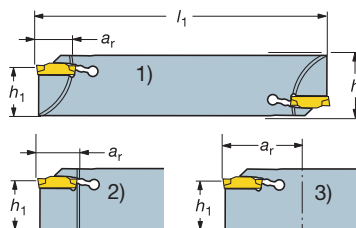


Odsecanje Dvostrani listovi

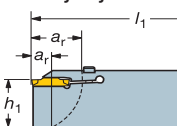
CoroCut® 1-2 nd T-MAX Q-Cut®

CoroCut® 1-2

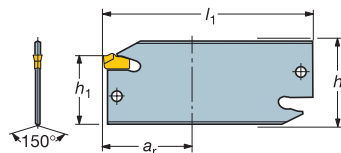
Pažnja! Prilikom korišćenja CoroCut 2-strane pločice, ar pločice definiše maksimalnu dubinu reza.



Stezanje vijkom



T-Max Q-Cut



List za odsecanje Veličina sedišta	Kataloška oznaka					Ključ	Osnovna pločica
		$a_{r\max}$	h	h_1	l_1		
D	CoroCut® 1-2						
	N123D15-21A2 N123D15-25A2	5-15 ¹⁾ 15 ²⁾	25.9 31.9	21.4 25.0	110 150	5680 058-01 5680 058-01	N123D2-0150-CM
E	N123E15-21A2 N123E20-25A2	5-15 ¹⁾ 20 ²⁾	25.9 31.9	21.4 25.0	110 150	5680 058-01	N123E2-0200-CM
	F	N123F30-21A2 N123F55-25A2	30 ³⁾ 55 ³⁾	25.9 31.9	21.4 25.0	110 150	5680 058-01
G		N123G30-21A2 N123G55-25A2	30 ³⁾ 55 ³⁾	25.9 31.9	21.4 25.0	110 150	5680 058-01
	H	N123H55-25A2	55 ³⁾	31.9	25.0	150	5680 058-01
J	N123J55-25A2	55 ³⁾	31.9	25.0	150	5680 058-01	N123J2-0500-CM
K	N123K55-25A2	55 ³⁾	31.9	25.0	150	5680 058-01	N123K2-0600-CM
	CoroCut® 1-2 stezanje vijkom						
E	R/LF123E25-25B1	25	31.9	25.0	150	5680 043-14 (20IP)	N123E2-0200-CM
F	R/LF123F25-25B1	25	31.9	25.0	150	5680 043-14 (20IP)	N123F2-0250-CM
G	R/LF123G25-25B1	25	31.9	25.0	150	5680 043-14 (20IP)	N123G2-0300-CM
H	R/LF123H32-25B1	32	31.9	25.0	150	5680 043-14 (20IP)	N123H2-0400-CM
	T-MAX Q-Cut®						
20	151.2 -21-20	35	25.9	21.4	110	5680 057-021	N151.2-200-5E
25	151.2 -21-25	35	25.9	21.4	110	5680 057-021	N151.2-250-5E
	-25-25	60	31.9	25.0	150		
30	151.2 -21-30	35	25.9	21.4	110	5680 057-021	N151.2-300-5E
	-25-30	60	31.9	25.0	150		
40	151.2 -21-40	35	25.9	21.4	110	5680 057-011	N151.2-400-5E
	-25-40	60	31.9	25.0	150		
50	151.2 -25-50	60	31.9	25.0	150	5680 057-011	N151.2-500-5E
60	151.2 -25-60	60	31.9	25.0	150	5680 057-011	N151.2-600-5E

¹⁾ List sa zakrivljenim ojačanjem

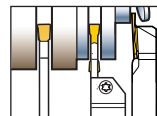
²⁾ List sa ravnim ojačanjem.

³⁾ List bez ojačanja.

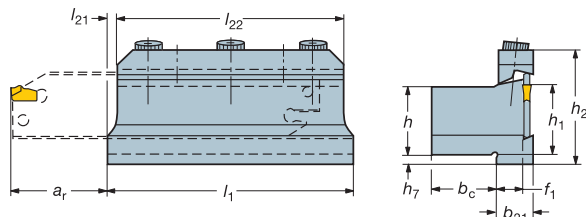
Primer poručivanja: 2 komada N123D15-21A2

R = Desna verzija, L = Leva verzija

Blok za listove za odsecanje

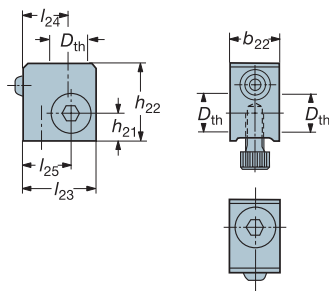


Blok



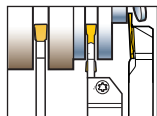
Blok		Za T-Max Q-Cut listove	Kataloška oznaka												
Za CoroCut listove		a_r max		b_{21}	b_c	f_1	h	h_1	h_2	h_7	l_1	l_{21}	l_{22}		
N123D15-21A2		151.2-21-20	35	151.2-2020-21M	18	20	13.4	20	20	45.5	10	80	5	70	
N123E15-21A2		151.2-21-25			151.2-2520-21	18	20	13.4	25	25	45.5	10	80	5	70
N123F30-21A2		151.2-21-30													
N123G30-21A2		151.2-21-40													
N123D15-25A2	R/LF123E25-25B1	151.2-25-25	60	151.2-2020-25	18	20	13.4	20	25	52.5	10	120	5	110	
N123E20-25A2	R/LF123F25-25B1	151.2-25-30			151.2-2520-25	18	20	13.4	25	25	52.5	10	120	5	110
N123F55-25A2	R/LF123G25-25B1	151.2-25-40			151.2-3232-25	18	32	13.4	32	32	54.5	5	120	5	110
N123G55-25A2	R/LF123H25-25B1	151.2-25-50													
N123H55-25A2		151.2-25-60													
N123J55-25A2															
N123K55-25A2															

Adapter za hlađenje (opciono)



	b_{22}	h_{21}	h_{22}	l_{23}	l_{24}	l_{25}	D_{th}
5691 050-011	17	10	28	26	16.2	17.2	G ^{1/4} "

Primer poručivanja: 2 komada 151.2-2020-21M

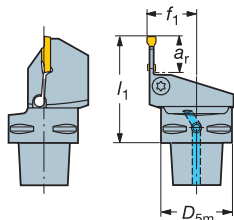



Spoljašnja rezna jedinka za odsecanje, ukopavanje, profilisanje i struganje

CoroCut® 1-2

Coromant Capto®

Pažnja! Prilikom korišćenja CoroCut 2-strane pločice, ar pločice definiše maksimalnu dubinu reza.



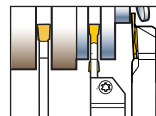
Veličina sedišta ¹⁾	Kataloška oznaka	a_r max	D_{sm}	f_1	l_1	Osnovna pločica 	Nm
D	C4-R/LF123D15-27055B	15	40	27	55	N123D2-0150-CM	20IP 3.5
	C5-R/LF123D15-35055B	15	50	35	55		
E	C4-R/LF123E15-27055B	15	40	27	55	N123E2-0200-CM	20IP 4.0
	C5-R/LF123E15-35060B	15	50	35	60		
F	C4-R/LF123F20-27060B	20	40	27	60	N123F2-0250-CM	20IP 4.0
	C5-R/LF123F20-35060B	20	50	35	60		
G	C4-R/LF123G20-27060B	20	40	27	60	N123G2-0300-GM	25IP 5.0
	C5-R/LF123G20-35060B	20	50	35	60		
	C6-R/LF123G20-45065B	20	63	45	65		
H	C4-R/LF123H25-27067B	25	40	27	67	N123H2-0400-GM	30IP 7.0
	C5-R/LF123H25-35067B	25	50	35	67		
	C6-R/LF123H25-45070B	25	63	45	70		
J	C4-R/LF123J25-27067B	25	40	27	67	N123J2-0500-GM	30IP 6.0
	C5-R/LF123J25-35067B	25	50	35	67		
	C6-R/LF123J25-45070B	25	63	45	70		
K	C4-R/LF123K25-27070B	25	40	27	70	N123K2-0600-CR	30IP 6.0
	C5-R/LF123K25-35070B	25	50	35	70		
	C6-R/LF123K25-45075B	25	63	45	75		
L	C5-R/LF123L25-35070B	25	50	35	70	N123L2-0800-GM	30IP 7.0
	C6-R/LF123L25-45075B	25	63	45	75		

¹⁾ Da odgovara veličini sedišta pločice.

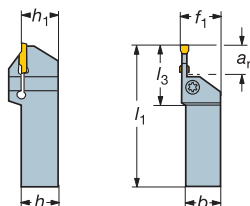
Primer poručivanja: 2 komada C4-RF123D15-27055B
R = Desna verzija, L = Leva verzija


Spoljašnji nosači sa prizmatičnom drškom za odsecanje, ukopavanje, profilisanje i struganje

CoroCut® 1-2



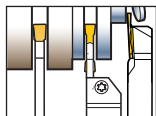
Pažnja! Prilikom korišćenja CoroCut 2-strane pločice, ar pločice definiše maksimalnu dubinu reza.



Veličina sedišta ¹⁾	Kataloške oznake za prizmatične nosače	a_r max	b	f_1	h	h_1	l_1	l_3	Osnovna pločica	 Nm
D	R/LF123D08 -1212B	8	12	13	12	12	125	25.5	N123D2-0150-CM	20IP 12.5
	-1616B	8	16	17	16	16	100	25.5		
	-2020B	8	20	21	20	20	125	25.5		
	-2525B	8	25	26	25	25	150	25.5		
	R/LF123D15 -1616B	15	16	17	16	16	100	33.5	N123D2-0150-CM	20IP 3.5
	-2020B	15	20	21	20	20	125	33.5		
E	R/LF123E08 -1212B	8	12	13	12	12	125	25.5	N123E2-0200-CM	20IP 2.5
	-1616B	8	16	17	16	16	125	25.5		
	-2020B	8	20	21	20	20	125	25.5		
	-2525B	8	25	26	25	25	150	25.5		
	R/LF123E12 -1212B	12	12	13	12	12	125	30.5	N123E2-0200-CM	20IP 3.5
	R/LF123E15 -1616B	15	16	17	16	16	125	33.5	N123E2-0200-CM	20IP 4.0
	-2020B	15	20	21	20	20	125	33.5		
	-2525B	15	25	26	25	25	150	33.5		
F	R/LF123F10 -1212B	10	12	13	12	12	125	29	N123F2-0250-CM	20IP 3.0
	-1616B	10	16	17	16	16	125	29		
	-2020B	10	20	21	20	20	125	29		
	-2525B	10	25	26	25	25	150	29		
	-3225B	10	25	26	25	25	150	29		
	R/LF123F20 -1616B	20	16	17	16	16	125	40	N123F2-0250-CM	20IP 4.0
	-2020B	20	20	21	20	20	125	40		
	-2525B	20	25	26	25	25	150	40		
-3225B	20	25	26	32	32	170	40			
G	R/LF123G10 -1616B	10	16	17	16	16	125	30	N123G2-0300-GM	25IP 3.5
	-2020B	10	20	21	20	20	125	30		
	-2525B	10	25	26	25	25	150	30		
	-3225B	10	25	26	32	32	170	30		
	R/LF123G12 -1212B	12	12	13	12	12	125	32	N123G2-0300-GM	20IP 3.5
	R/LF123G20 -1616B	20	16	17	16	16	125	41	N123G2-0300-GM	25IP 5.0
	-2020B	20	20	21	20	20	125	41		
	-2525B	20	25	26	25	25	150	41		
	-3225B	20	25	26	32	32	170	41		

¹⁾ Da odgovara veličini sedišta pločice.

Primer poručivanja: 2 komada RF123D08-1212B
R = Desna verzija, L = Leva verzija




Spoljašnji nosači sa prizmatičnom drškom za odsecanje, ukopavanje, profilisanje i struganje

CoroCut® 1-2

Pažnja! Prilikom korišćenja CoroCut 2-strane pločice, ar pločice definiše maksimalnu dubinu reza.



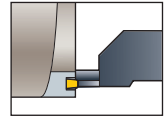
Veličina sedišta ¹⁾	Kataloške oznake za prizmatične nosače	D_m max	a_r max	b	f_1	h	h_1	l_1	l_3	Osnovna pločica		Nm
H	R/LF123H13 -1616B	13	16	17	16	16	125	34		N123H2-0400-CM	30IP	4.5
	-2020BM	13	20	21	20	20	125	34				
	-2525BM	13	25	26	25	25	150	34				
	-3225BM	13	25	26	32	32	170	34				
	R/LF123H25 -1616B	25	16	17	16	16	125	47		N123H2-0400-CM	30IP	7.0
	-2020BM	25	20	21	20	20	125	47				
	-2525BM	25	25	26	25	25	150	47				
	-3225BM	25	25	26	32	32	170	47				
J	R/LF123J13 -2020BM	13	20	21	20	20	125	34		N123J2-0500-CM	30IP	5.0
	-2525BM	13	25	26	25	25	150	34				
	-3225BM	13	25	26	32	32	170	34				
	R/LF123J32 -2525BM	32	25	26	25	25	150	57		N123J2-0500-CM	30IP	7.5
	-3225BM	32	25	26	32	32	170	57				
	K	R/LF123K16 -2525BM	16	25	26	25	25	150	39		N123K2-0600-CR	30IP
-3225BM		16	25	26	32	32	170	39				
R/LF123K32 -2525BM		32	25	26	25	25	150	58		N123K2-0600-CR	30IP	7.5
-3225BM		32	25	26	32	32	170	58				
L	R/LF123L16 -2525BM	16	25	26	25	25	150	41		N123L2-0800-GM	30IP	6.5
	R/LF123L25 -2525BM	25	25	26	25	25	150	52		N123L2-0800-GM	30IP	7.0
	-3225BM	25	25	26	32	32	170	52				
	R/LF123L32 -3225BM	32	25	26	32	32	170	60		N123L2-0800-GM	30IP	7.5
	R/LF123L25 -2525BM	25	25	26	25	25	150	52		N123L2-0800-GM	30IP	7.0
	CoroCut® 1-2 stezanje vijkom											
E	R/LF123E17 -2020D	42	17	20	20.5	20	125	35.5		N123E2-0200-CM	20IP	4.0
F	R/LF123F17 -2020D	42	17	20	20.5	20	125	37		N123F2-0250-CM	20IP	4.0
	R/LF123F17 -2525D	42	17	25	20.5	25	150	37				
G	R/LF123G22 -2020D	44	22	20	20.6	20	125	43		N123G2-0300-CM	25IP	5.0
	R/LF123G22 -2525D	44	22	25	25.6	25	150	43				
H	R/LF123H22 -2020D	52	22	20	20.6	20	125	44		N123H2-0400-CM	25IP	6.0
	R/LF123H22 -2525D	52	22	25	25.6	25	150	44		N123H2-0400-CM		

¹⁾ Da odgovara veličini sedišta pločice.

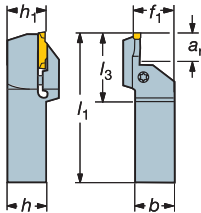
Primer poručivanja: 2 komada RF123H13-1616B
R = Desna verzija, L = Leva verzija

Spoljašnji nosači sa prizmatičnom drškom za čeono ukopavanje

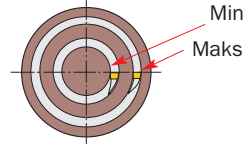
CoroCut® 1-2




Pažnja! Prilikom korišćenja CoroCut 2-strane pločice, ar pločice definiše maksimalnu dubinu reza.



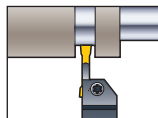
Prečnik prvog reza



Prečnik prvog reza	Veličina sedišta ¹⁾	Kataloška oznaka	a_{max}	b	f_1	h	h_1	l_1	l_3	Osnovna pločica		Nm
34– 44 38– 48 42– 60 54– 75 67–100 90–160 130–300	G	R/LF123G12 -2525B-034B -2525B-038B R/LF123G19 -2525B-042B -2525B-054B R/LF123G22 -2525B-067B -2525B-090B -2525B-130B	12 12 19 19 22 22 22	25 25 25 25 25 25 25	26 26 26 26 26 26 26	25 25 25 25 25 25 25	25 25 25 25 25 25 25	150 150 150 150 150 150 150	32 32 40 40 43 43 43	N123G2-0300-TF N123G2-0300-TF N123G2-0300-TF	25IP 25IP 25IP	3.5 3.5 3.5
40– 60 52– 72 64–100 92–140 132–230 220–500 300–1100	H	R/LF123H13 -2525B-040BM -2525B-052BM -2525B-064BM -2525B-092BM -2525B-132BM -2525B-220BM -2525B-300BM R/LF123H20 -2525B-040BM -2525B-052BM R/LF123H25 -2525B-064BM -2525B-092BM -2525B-132BM -2525B-220BM -2525B-300BM	13 13 13 13 13 13 13 20 20 25 25 25 25 25	25 25 25 25 25 25 25 25 25 25 25 25 25 25	26 26 26 26 26 26 26 26 26 26 26 26 26 26	25 25 25 25 25 25 25 25 25 25 25 25 25 25	25 25 25 25 25 25 25 25 25 25 25 25 25 25	150 150 150 150 150 150 150 150 150 150 150 150 150 150 150	34 34 34 34 34 34 34 42 42 47 47 47 47 47	N123H2-0400-TF N123H2-0400-TF N123H2-0400-TF	30IP 30IP 30IP	2.8 3.0 3.2 3.7 4.0 4.3 4.3 3.5 3.5 3.5
40– 70 60– 95 85–130 120–180 175–500 180–980	J	R/LF123J20 -2525B-040BM R/LF123J25 -2525B-060BM -2525B-085BM -2525B-120BM -2525B-175BM R/LF123J20 -2525B-180BM	20 25 25 25 25 25	25 25 25 25 25 25	26 26 26 26 26 26	25 25 25 25 25 25	25 25 25 25 25 25	150 150 150 150 150 150	43 48 48 48 48 43	N123J2-0500-TF N123J2-0500-TF N123J2-0500-TF	30IP 30IP 30IP	4.0 4.0 4.0
40– 70 58–100 88–180 168–400 220–1000	K	R/LF123K20 -2525B-040BM R/LF123K25 -2525B-058BM -2525B-088BM -2525B-168BM -2525B-220BM	20 25 25 25 25	25 25 25 25 25	26 26 26 26 26	25 25 25 25 25	25 25 25 25 25	150 150 150 150 150	44 49 49 49 49	N123K2-0600-TF N123K2-0600-TF	30IP 30IP	4.5 4.5
50– 80 75–150 140–400	L	R/LF123L25 -2525B-050BM R/LF123L28 -2525B-075BM -2525B-140BM	25 28 25	25 25 25	26 26 26	25 25 25	25 25 25	150 150 150	55 56 56	N123L2-0800-TF N123L2-0800-TF	30IP 30IP	4.5 4.5

¹⁾ Da odgovara veličini sedišta pločice.

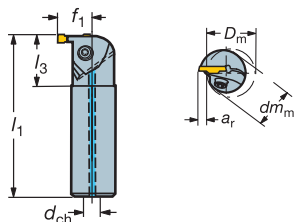
Primer poručivanja: 2 komada RF123G12-2525B-034B
R = Desna verzija, L = Leva verzija



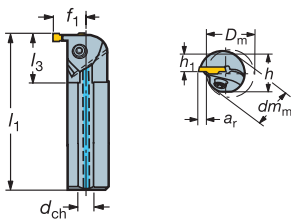
Nosači za unutrašnje ukopavanje

CoroCut® 1-2

Cilindrični



Sa zaravnjenjem



D_m min ²⁾	a_r maks. za nosač	Veličina sedišta ¹⁾	Kataloška oznaka								Osnovna pločica	 Nm
				d_m	f_1	h	h_1	l_1	l_3	d_{ch}		
Cilindrični												
25	4.5	D	R/LAG123D 04-16B	16	12.5	-	-	150	25	6	N123D2-0150-CM	3.0
32	5		05-20B	20	15.25	-	-	180	30	6		
32	5	E	R/LAG123E 05-20B ²⁾	20	15.25	-	-	180	30	6	N123E2-0200-GM	3.5
32	7		07-25B	25	19.75	-	-	200	35	9		
32	6	G	R/LAG123G 06-20B ²⁾	20	15.25	-	-	180	30	6	N123G2-0300-GM	4.0
32	7		07-25B	25	19.75	-	-	200	35	9		
32	7	H	R/LAG123H 07-25B	25	19.25	-	-	200	35	9	N123H2-0400-GM	4.5
32	8	J	R/LAG123J 08-25B	25	19.75	-	-	200	35	9	N123J2-0500-GM	5.0
Sa zaravnjenjem												
40	9.5	E	R/LAG123E 09-32B	32	25.5	30	15	250	45	9	N123E2-0200-GM	4.0
40	9	G	R/LAG123G 09-32B	32	25.25	30	15	250	45	9	N123G2-0300-GM	4.5
50	11		11-40B	40	31	37	18.5	300	55	12		
40	10	H	R/LAG123H 10-32B	32	26.5	30	15	250	45	9	N123H2-0400-GM	4.5
50	11		11-40B	40	31	37	18.5	300	55	12		
60	13		13-50B	50	38.25	47	23.5	350	65	12		
40	11	J	R/LAG123J 11-32B	32	27	30	15	250	45	9	N123J2-0500-GM	5.0
50	11		11-40B	40	31	37	18.5	300	55	12		
60	13		13-50B	50	38.25	47	23.5	350	65	12		
50	11	K	R/LAG123K 11-40B	40	31	37	18.5	300	55	12	N123K2-0600-GM	5.5
60	13		13-50B	50	38.25	47	23.5	350	65	12		

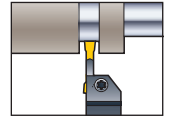
¹⁾ Da odgovara veličini sedišta pločice.

²⁾ Prilikom korišćenja pločice sa -GF geometrijom, min. prečnik rupe (D_m) je 25 mm

Primer poručivanja: 2 komada RAG123D04-16B

R = Desna verzija, L = Leva verzija

Nosači za unutrašnje ukopavanje



T-MAX Q-Cut®

R/LAG151.32 Cilindrično ekscentrični dizajn $D_m = 12-18$ mm		R/LAG151.32 Cilindrični $D_m = 20-32$ mm		R/LAG151.32 Sa zaravnjenjem $D_m = 40-50$ mm								
D_m min	a_r maks. za nosač	Veličina sedišta ¹⁾	Kataloška oznaka	dm	h	h_1	f_1	l_1	l_3	d_{ch}	Osnovna pločica	 Nm
12	2	20	R/LAG151.32-16M12-20 ²⁾	16	-	-	10	150	20	6	N151.3-200-20-4G	8IP 2.5
20	3.5		R/LAG151.32-16M-20	16	-	-	11.5	150	24	6	N151.3-200-20-4G	15IP 2.5
25	4.5		R/LAG151.32-20Q-20	20	-	-	14.5	180	30	6	N151.3-200-20-4G	
15	4	25	R/LAG151.32-16M15-25 ²⁾	16	-	-	12	150	20	6	N151.3-300-25-4G	8IP 2.5
20	3.5		R/LAG151.32-16M-25	16	-	-	11.6	150	24.2	6	N151.3-265-25-4G	15IP 3
25	4.6		R/LAG151.32-20Q-25	20	-	-	14.6	180	30	6	N151.3-265-25-4G	
32	6.1		R/LAG151.32-25R-25	25	-	-	18.6	200	32.2	8.5	N151.3-265-25-4G	
40	7.1		R/LAG151.32-32S-25 ³⁾	32	30	15	23.1	250	36.3	8.5	N151.3-265-25-4G	
16	4.5	30	R/LAG151.32-20Q16-30 ²⁾	20	-	-	14.2	180	21.5	6	N151.3-400-30-4G	8IP 2.5
25	4.5		R/LAG151.32-20Q-30	20	-	-	14.5	180	30	6	N151.3-300-30-4G	15IP 3.5
32	6		R/LAG151.32-25R-30	25	-	-	18.5	200	32.2	8.5	N151.3-300-30-4G	
40	7		R/LAG151.32-32S-30 ³⁾	32	30	15	23	250	36.2	8.5	N151.3-300-30-4G	
18	5	40	R/LAG151.32-20Q18-40 ²⁾	20	-	-	14.7	180	23	6	N151.3-500-40-4G	8IP 3.5
32	6.1		R/LAG151.32-25R-40	25	-	-	18.5	200	32.2	8.5	N151.3-400-40-4G	15IP 4.5
40	7.1		R/LAG151.32-32S-40 ³⁾	32	30	15	23.1	250	36.3	8.5	N151.3-400-40-4G	30IP 4.5
50	8.1		R/LAG151.32-40T-40 ³⁾	40	37	18.5	28.1	300	42.3	11.5	N151.3-400-40-4G	

¹⁾ Da odgovara veličini sedišta pločice.

²⁾ Ekscentričan dizajn.

³⁾ Sa zaravnjenjem.

Primer poručivanja: 2 komada R/LAG151.32-16M12-20

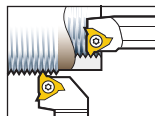
R= Desna, L= Leva verzija

Pločice za unutrašnje ukopavanje

	Veličina se- dišta ¹⁾	Kataloška oznaka	GC1125 GC1145 H13A	Dimenzije, mm				Preporuke kvaliteta CoroKey režimi obrade		Kvaliteti					
				l_a	r_ϵ	α_n	α_f	f_{nx} mm/obr	P	M	K	N	S		
														Prvi izbor	
-4G	20	N151.3-200-20-4G	★	★	★	2.00	0.2	11°	3°	0.05 (0.03 - 0.12)					
	25	N151.3-265-25-4G	★	★	★	2.65	0.15	11°	3°	0.07 (0.03 - 0.15)					
	30	N151.3-300-30-4G	★	★	★	3.00	0.2	11°	3°	0.04 (0.02 - 0.11)					
	40	N151.3-400-40-4G	★	★	★	4.00	0.2	11°	3°	0.08 (0.04 - 0.15)					
										v_c m/min					
										140	90	95	1500	25	

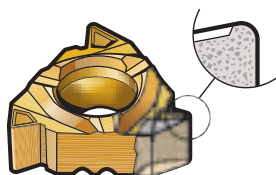
Za druge geometrije pločica i kvalitete, videti glavni katalog strane B58-B59.

Za crtež sa dimenzijama pogledati stranu 107



Opšte smernice

CoroThread® 266



Univerzalna geometrija

Pun profil i V - profil pločice.

Odlične univerzalne performanse

Dugačka, predvidljiva postojanost

PRVI IZBOR

Univerzalna geometrija

Zaobljena (ER-tretirana)
reznica ivica



Kvaliteti

	Prvi izbor	Drugi izbor
P	GC1125	GC1135
M	GC1135	GC1125
K	GC1125	GC1135
N	GC1125	GC1135
S	GC1135	GC1125

Dopunske geometrije

Oštra reznica ivica F*

Oštra reznica ivica



Pogodne za materijale koji otvrdnjavaju pri obradi i sa strugotinom koja prijanja na reznica ivicu.

Geometrija sa lomačem strugotine C*

Geometrija za lomljenje strugotine



Maksimalna kontrola strugotine uz minimalnu pažnju.

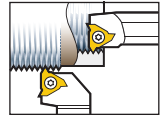
Optimizujući izbor za niskouglenične i niskolegirane čelike.

Dostupno u drugoj polovini 2010 godine

*

Informacije o poručivanju, pogledajte najnoviji Glavni katalog ili suplement

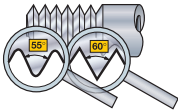
Opšte smernice



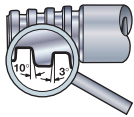
CoroThread® 266

Tipovi navoja

CoroThread 266 sistem za rezanje navoja nudi pločice za širok opseg tipova i koraka navoja pogledajte osnovni katalog ili dodatak



- Sve oblasti mašinske industrije (ISO MM, UN)
- Cevni spojni elementi za gasne, kanalizacione i instalacije za vodu (Whitworth, NPT)
- Cevne spojke za prehrambenu industriju i protivpožanu opremu (Round DIN 405)
- Cevni navoji za gasne, kanalizacione i instalacije za vodu. (BSPT, NPTF)
- Navoji za avio-industriju. (MJ, UNJ)
- Nafta i gas. (API 60°, API Rounded, API Buttress, VAM)
- Trapezni navoj za pokretne elemente (DIN 103, ACME, STUB-ACME)

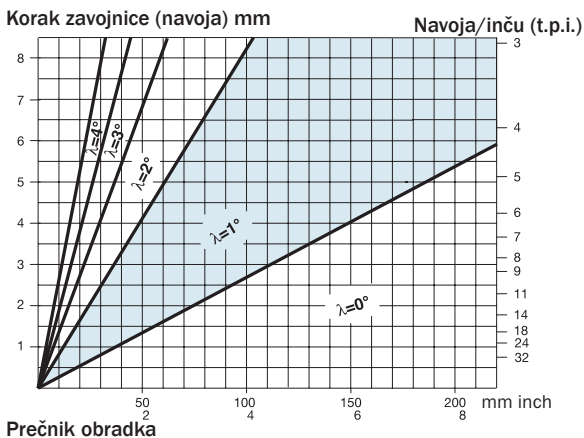


Podložne pločice

Podložne pločice se koriste za dobijanje različitih zakošenja pločice i dostupne su u koracima od 1° u dijapazonu od -2° do +4°.

Uglovi zavojnice

Nosači za izradu navoja se isporučuju sa podložnim pločicama sa uglom od +1° za kombinaciju prečnika obratka i koraka u zatamljenom delu dijagrama



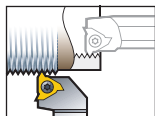
Standardno se isporučuje
 λ = Ugao nagiba

Desnorezni alat za spoljašnju obradu
 Levorezni alat za unutrašnju obradu

-2°	5322 389-22
-1°	5322 389-21
0°	5322 389-10
1°	5322 389-11
2°	5322 389-12
3°	5322 389-13
4°	5322 389-14

Levorezni alat za spoljašnju obradu
 Desnorezni alat za unutrašnju obradu

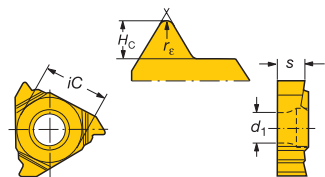
-2°	5322 390-22
-1°	5322 390-21
0°	5322 390-10
1°	5322 390-11
2°	5322 390-12
3°	5322 390-13
4°	5322 390-14



Spoljšanje rezanje navoja

CoroThread® 266 pločice sa univerzalnom geometrijom

ISO/ANSI



	iC	d_1	s
16	9.525	4.4	3.97

nap = broj prolaza

Profil navoja Korak navoja	Korak navoja		Kataloška oznaka	GC1125 ²⁾ GC1135 ²⁾		Dimenzije, mm			CoroKey režimi obrade											
	mm	(t.p.i.)		r_e	H_c	nap	P	M	K	N	S	H								
Pun profil Metrički 60° 	0.50		266R/LG -16MM01A050 -16MM01A075 -16MM01A100 -16MM01A125 -16MM01A150 -16MM01A175 -16MM01A200 -16MM01A250 -16MM01A300	★	★	-	0.29	4/5	Prvi izbor											
	0.75			★	★	-	0.45	4/5	GC1125 GC1135 GC1125 GC1125 GC1135	GC1135 GC1125 GC1125 GC1135	GC1125 GC1125 GC1125 GC1125	GC1125 GC1125 GC1125 GC1125	GC1125 GC1125 GC1125 GC1125	GC1125 GC1125 GC1125 GC1125						
	1.00			★	★	-	0.60	5/6												
	1.25			★	★	-	0.74	6												
	1.50			★	★	-	0.90	6/7												
	1.75			★	★	-	1.06	8/9												
	2.00			★	★	-	1.21	8/9												
	2.50			★	★	-	1.51	10/11												
	3.00			★	★	-	1.83	12/13												
	Pun profil UN 60° 			32	266R/LG -16UN01A320 -16UN01A280 -16UN01A240 -16UN01A200 -16UN01A180 -16UN01A160 -16UN01A140 -16UN01A130 -16UN01A120 ¹⁾ -16UN01A110 -16UN01A100 -16UN01A090 -16UN01A080	★	★	-							0.49	4/5	GC1125 GC1135 GC1125 GC1125 GC1135	GC1135 GC1125 GC1125 GC1125 GC1135	GC1125 GC1125 GC1125 GC1125 GC1125	GC1125 GC1125 GC1125 GC1125 GC1125
		28	★	★		-	0.55	5/6												
		24	★	★		-	0.65	5/6												
		20	★	★		-	0.79	6/7												
		18	★	★		-	0.87	6/7												
		16	★	★		-	0.99	7/8												
		14	★	★		-	1.12	8/9												
		13	★	★		-	1.21	8/9												
		12	★	★		-	1.30	8/9												
		11	★	★		-	1.42	9/10												
		10	★	★		-	1.57	10/11												
		9	★	★		-	1.74	11/12												
		8	★	★		-	1.97	12												
Pun profil Whitworth 55° 		28	266RG -16WH01A280 -16WH01A200 -16WH01A190 -16WH01A180 ¹⁾ -16WH01A160 ¹⁾ -16WH01A140 -16WH01A120 -16WH01A110 [*] -16WH01A100 -16WH01A090 ¹⁾ -16WH01A080	★	★	-	0.59	5/6	GC1125 GC1135 GC1125 GC1125 GC1135	GC1135 GC1125 GC1125 GC1125 GC1135	GC1125 GC1125 GC1125 GC1125 GC1125	GC1125 GC1125 GC1125 GC1125 GC1125	GC1125 GC1125 GC1125 GC1125 GC1125	GC1125 GC1125 GC1125 GC1125 GC1125						
		20		★	★	-	0.83	6/7												
		19		★	★	-	0.87	6/7												
		18		★	★	-	0.92	7/8												
		16		★	★	-	1.03	7/8												
		14		★	★	-	1.18	8/9												
		12		★	★	-	1.37	8/9												
		11		★	★	★	-	1.49												
		10		★	★	-	1.65	10/11												
		9		★	★	-	1.82	11/12												
		8		★	★	-	2.05	12/13												
V-profil VM = 60° 	1.0-2.0	24-12	266R/LG -16VM01A001 -16VM01A002	★	★	0.13	1.54	-	Prvi izbor											
	1.5-3.0	16-8		★	★	0.20	2.44	-	GC1125 GC1135 GC1125 GC1125 GC1135	GC1135 GC1125 GC1125 GC1125 GC1135	GC1125 GC1125 GC1125 GC1125 GC1125	GC1125 GC1125 GC1125 GC1125 GC1125	GC1125 GC1125 GC1125 GC1125 GC1125							
VW = 55° 		28-14	266R/LG -16VW01A001 -16VW01A002	★	★	0.11	1.55	-						Prvi izbor						
		14-8		★	★	0.23	2.53	-	GC1125 GC1135 GC1125 GC1125 GC1135	GC1135 GC1125 GC1125 GC1125 GC1135	GC1125 GC1125 GC1125 GC1125 GC1125	GC1125 GC1125 GC1125 GC1125 GC1125	GC1125 GC1125 GC1125 GC1125 GC1125							

¹⁾ Dostupno u drugoj polovini 2010 godine

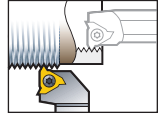
²⁾ GC 1135 dostupan samo u desnoj izvedbi

Primer poručivanja: 10 komada 266R/LG-16MM01A050 1125

R = Desna verzija, L = Leva verzija

Spoljašnje rezanje navoja

CoroThread® 266 rezne jedinice i prizmatični držači alata



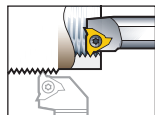
	Kataloška oznaka	Dimenzije, mm						Pločica	
		b	f_1	h	h_1	l_1	l_3	iC	Nm
	266R/LFG							16	15IP 3.0
	-1616-16	16	20	16	16	100	21.4		
	-2020-16	20	25	20	20	125	21.6		
	-2525-16	25	32	25	25	150	22.2		
	Coromant Capto®	D_{sm}	l_1	f_1				16	15IP 3.0
	C3-266R/LFG -22040-16	32	40	22					
	C4-266R/LFG -27050-16	40	50	27					
	C5-266R/LFG -35060-16	50	60	35					
	C6-266R/LFG -45065-16	63	65	45					
C8-266R/LFG -55080-16	80	80	55						

Za x i z dimenzije, vidi tabele u glavnom katalogu

Prikazan desni tip

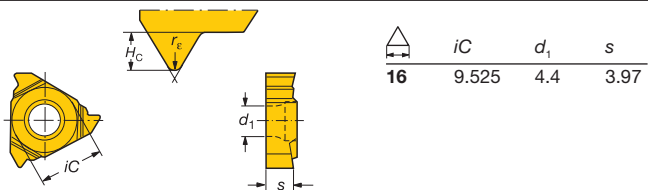
Primer poručivanja: 2 komada C4-266R/LFG-22040-16

R = Desna verzija, L = Leva verzija



Unutrašnje rezanje navoja

CoroThread® 266 pločice sa univerzalnom geometrijom



nap = broj prolaza

Profil navoja	Korak navoja		Kataloška oznaka	GC1125	GC1135 ²⁾	Dimenzije, mm			CoroKey režimi obrade					
	mm	(t.p.i.)				r_s	H_c	nap	P	M	K	N	S	H
Pun profil Metrički 60° 	0.50		266R/LL -16MM01A050	★	★	-	0.29	4/5	Prvi izbor					
	0.75		-16MM01A075	★	★	-	0.43	4/5						
	1.00		-16MM01A100	★	★	-	0.58	5/6	GC1125	GC1135				
	1.25		-16MM01A125	★	★	-	0.72	6/7			GC1125			
	1.50		-16MM01A150	★	★	-	0.87	6/7				GC1125		
	1.75		-16MM01A175	★	★	-	1.00	8/9					GC1135	
	2.00		-16MM01A200	★	★	-	1.15	8/9						
	2.50		-16MM01A250	★	★	-	1.43	10/11						
	3.00		-16MM01A300	★	★	-	1.73	12						
Pun profil UN 60° 	20		266R/LL -16UN01A200	★	★	-	0.73	6/7						
	18		-16UN01A180	★	★	-	0.81	6/7						
	16		-16UN01A160	★	★	-	0.91	7/8						
	14		-16UN01A140	★	★	-	1.02	8/9						
	12		-16UN01A120	★	★	-	1.20	8/9						
	11		-16UN01A110	★	★	-	1.31	9/10						
	10		-16UN01A100	★	★	-	1.43	10/11						
	9		-16UN01A090	★	★	-	1.59	11/12						
	8		-16UN01A080	★	★	-	1.80	12						
Pun profil Whitworth 55° 	20		266RL -16WH01A200	★	★	-	0.82	6/7						
	19		-16WH01A190	★	★	-	0.87	6/7						
	16		-16WH01A160 ¹⁾	★	★	-	1.03	7/8						
	14		-16WH01A140	★	★	-	1.18	8						
	12		-16WH01A120	★	★	-	1.37	8						
	11		-16WH01A110	★	★	-	1.50	9/10						
	10		-16WH01A100 ¹⁾	★	★	-	1.65	10/11						
	9		-16WH01A090 ¹⁾	★	★	-	1.83	11/12						
	8		-16WH01A080	★	★	-	2.06	12/13						
										155	130	160	500	15
V-profil VM = 60° 	1.0-2.0	24-12	266R/LL -16VM01-001 -16VM01-002	★	★	0.06	1.39	-	Prvi izbor					
	1.5-3.0	16-8		★	★	0.09	2.45	-	GC1125	GC1135				
	VW = 55° 	28-14	266R/LL -16VW01-001 -16VW01-002	★	★	0.11	1.48	-	v _c m/min					
		14-8		★	★	0.23	2.55	-	155	130	160	500	15	

¹⁾ Dostupno u drugoj polovini 2010 godine

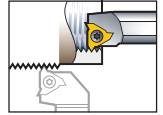
²⁾ GC 1135 dostupan samo u desnoj izvedbi

Primer poručivanja: 10 komada 266R/LL-16MM01A050 1125

R = Desna verzija, L = Leva verzija

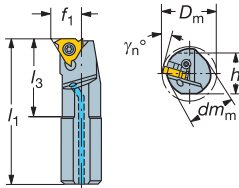
Unutrašnje rezanje navoja

CoroThread® 266 rezne jedinice i alati sa prizmatičnom drškom



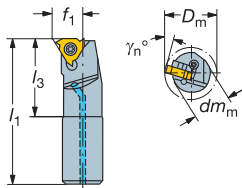
Cilindrična drška sa zaravnjenim delom

266R/LKF -R

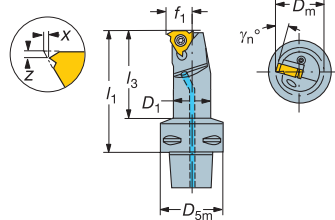


Cilindrična drška sa žljebom za EasyFix čaure

266R/LKF



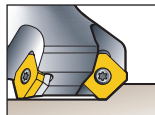
266R/LKF-R



Za x i z dimenzije, vidi tabele u glavnom katalogu

Prikazan desni tip

	Kataloška oznaka	Dimenzije, mm							Pločica	
		$d_{m\ min}$	$D_{m\ min}$	f_1	h	l_1	l_3	γ_n	iC	Nm
	Cilindrična drška sa zaravnjenim delom									
	266R/LKF -20-16	20	25	14	18	250	29.0	15°	16	15IP 3.0
	-25-16	25	32	17	23	300	29.0	15°		
	-32-16	32	40	22	30	250	30.9	15°		
	-40-16	40	50	27	37	300	31.5	15°		
-50-16	50	63	35	49	350	40.2	15°			
	Cilindrična drška sa žljebom za EasyFix čaure									
	266R/LKF -20-16-R	20	25	14	-	140	28.7	15°	16	15IP 3.0
-25-16-R	25	32	17	-	180	28.8	15°			
	Coromant Capto®									
	C4-266R/LKF -14060-16	D_1	$D_{m\ min}$	D_{5m}	f_1	l_1	l_3	γ_n	16	15IP 3.0
	-17070-16	18.5	25	40	14	60	38	15°		
	C4-266RKF -22090-16	24.5	32	40	17	70	48	15°		
		32	40	40	22	90	69	15°		
	C5-266R/LKF -17070-16	24.5	32	50	17	70	47	15°		
	-22090-16	32	40	50	22	90	68	15°		
	C5-266RKF -27105-16	40	50	50	27	105	84	15°		
	C6-266R/LKF -14070-16	18.5	25	63	14	70	42	15°		
	-17075-16	24.5	32	63	17	75	48	15°		
-22090-16	32	40	63	22	90	64	15°			
-27105-16	40	50	63	27	105	80	15°			



CoroMill® za svaku aplikaciju

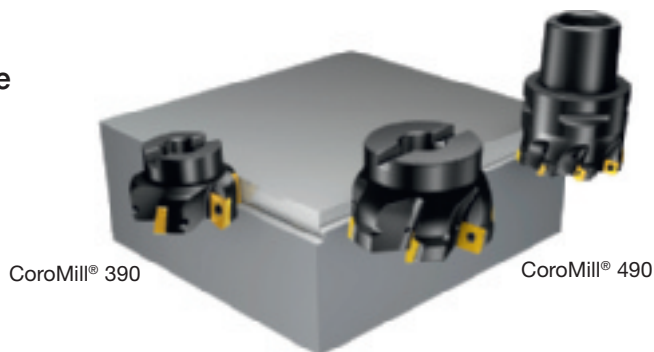
Smernice za upotrebu



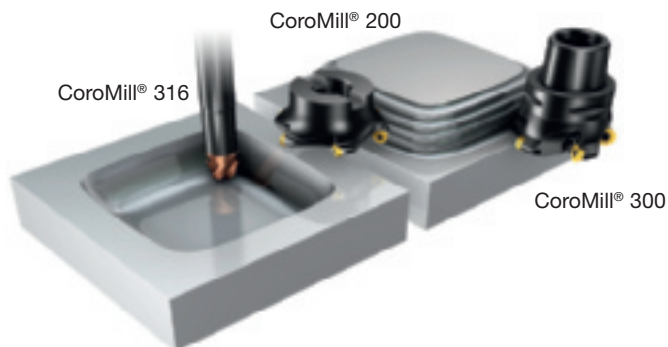
Plansko glodanje



Ugaono glodanje



Profilno glodanje

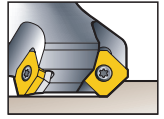


Za potpune informacije o kompletnom programu alata za glodanje, pogledajte Glavni katalog.

ISO/ANSI



Za CoroKey priručnik odabran program CoroMill® alata za glodanje



Glodala sa izmenljivim pločicama

Opšte plansko glodanje



CoroMill® 345
Ø 40 – 250 mm



Strane 145-147

Opšte plansko glodanje



CoroMill® 245
Ø 50 – 250 mm

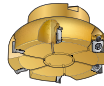


Strane 148-150

Plansko glodanje neferitnih materijala

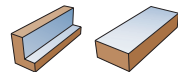


CoroMill® Century
Ø 40 – 200 mm



Strane 169-170

Ugaono glodanje

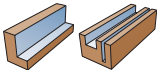


CoroMill® 490
Ø 20 – 250 mm



Strane 151-155

Glodanje vretenastim glodalima/Ugaono glodanje/Glodanje žljebova

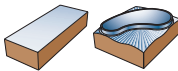


CoroMill® 390
Ø 12 – 200 mm



Strane 156-162

Plansko glodanje/Profilisanje Gruba/Teška obrada

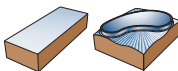


CoroMill® 200
Ø 50 – 100 mm



Strane 163-165

Plansko glodanje/Profilisanje Lako gruba/Poluzavršna obrada



CoroMill® 300
Ø 25 – 80 mm



Strane 166-168

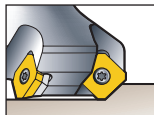
Glodanje vretenastim glodalima/Obaranje ivica/Profilisanje



CoroMill® 316
Ø 10 – 25 mm



Strane 171-177



Kako koristiti priručnik kod glodanja

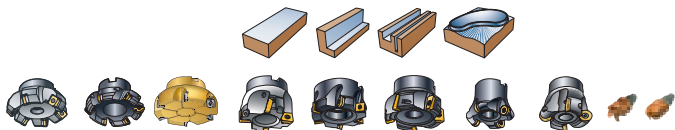
Izabrati alat



Definišite materijal, vrstu operacije i tip alata za glodanje



1



1

Nizak

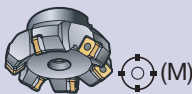


Široka podela

Smanjen broj pločica, male sile rezanja. Male mašine. Najbolja produktivnost kada su stabilnost i snaga limitirani. Veliki prepusti.

2

Prvi izbor Stabilnost operacije Podela kod glodala



Uska podela

Opšte glodanje i mešana proizvodnja. Uvek prvi izbor



Veoma uska podela

Maksimalan broj pločica. Najbolja produktivnost u stabilnim uslovima. Materijali sa kratkom strugotinom ili HRSA.

2

Velik

Geometrija pločice



Laka obrada

Ekstra pozitivne rezne ivice. Laka obrada. Male sile rezanja. Mali pomaci.

3



Srednja obrada

Za opštu primenu kod većine materijala.



Teška obrada

Ojačana rezna ivica. Teška obrada. Najviša sigurnost rezne ivice. Veliki pomaci.

3

Otpornost na habanje



Dobri uslovi

Dubina rezanja 25% ili manje od ap. Prepusti manji od 2xD. Kontinualan rez. Suva ili mokra obrada.

4

Uslovi obrade/ Kvaliteti



Prosečni uslovi

Dubina rezanja 50% ili više od ap. Prepusti dva ili tri puta prečnik prihvata/glodala. Prekinut rez. Suva ili mokra obrada.



Teži uslovi

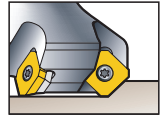
Dubina rezanja 75% ili više od ap. Prepusti preko 3xD. Prekinut rez. Suva ili mokra obrada.

4

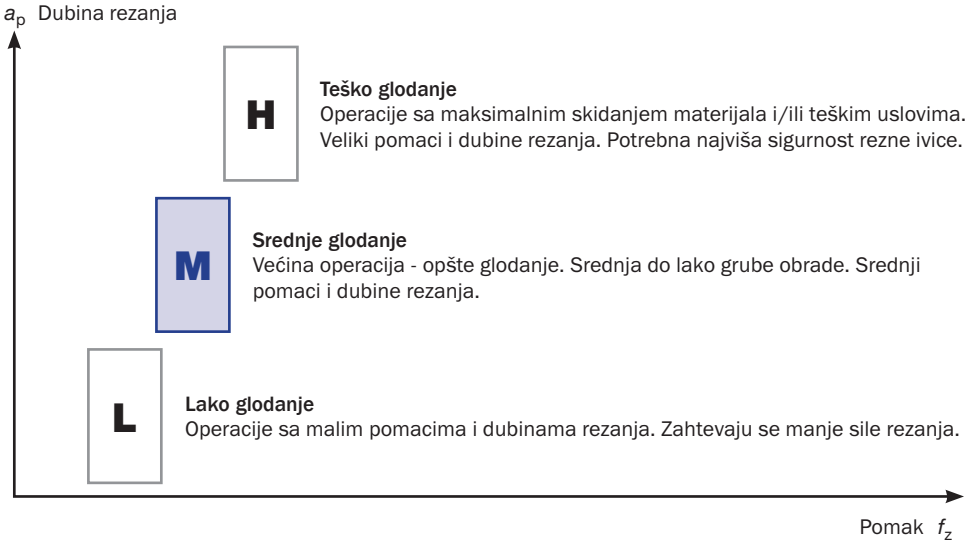
Žilavost



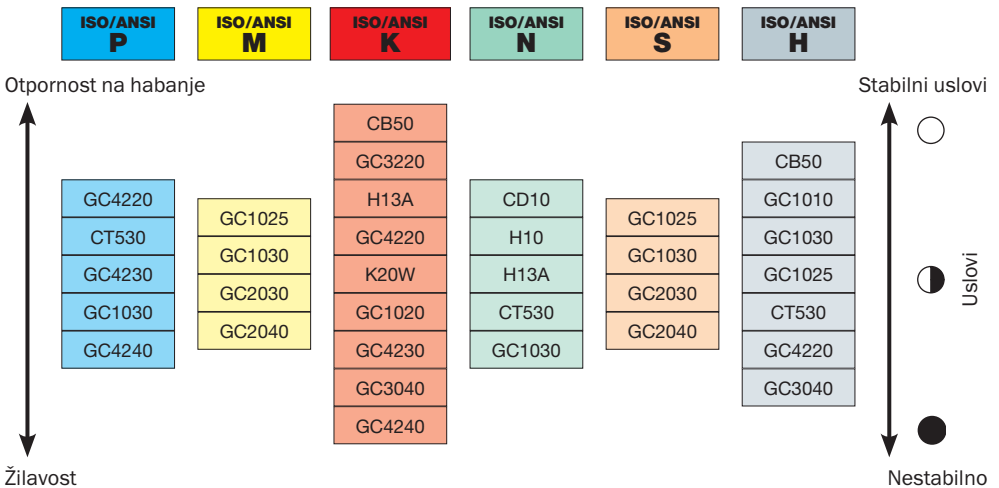
Kako koristiti priručnik kod glodanja

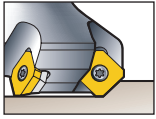


Vrsta aplikacije



Kvaliteti za glodanje





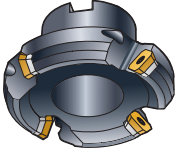
Opšte smernice

Izabrati alat



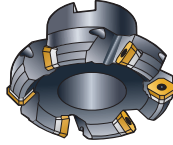
Tela glodala

Široka podela (-L)



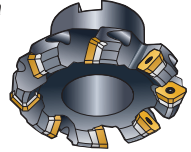
Smanjen broj pločica, sa diferencijalnom podelom, za najbolju produktivnost kada je snaga limitirana. Veliki prepusti. Male mašine, kao napr. sa konusom SK 40.

Uska podela (-M)



Opšte glodanje i mešana proizvodnja.

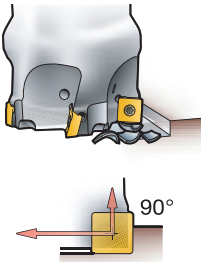
Veoma uska podela (-H)



Maksimalan broj pločica za najbolju produktivnost u stabilnim uslovima. Materijali sa kratkom strugotinom.

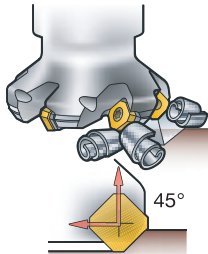
Napadni ugao

90° napadni ugao



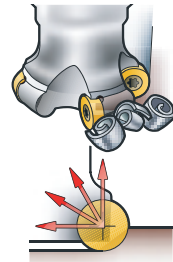
- Tankozide komponente
- Za slabo stegnute komponente
- Kada se traži forma sa 90°

45° napadni ugao



- Prvi izbor za opšte namene
- Smanjuje vibracije kod velikih prepusta
- Efekat stanjivanja strugotine omogućava povećanje produktivnosti

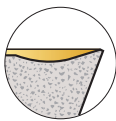
Glodala sa okruglim pločicama



- Najjača rezna ivica. Višestruko okretanje pločice.
- Glodalo opšte namene
- Povećan efekat stanjivanja strugotine kod vatrootpornih legura.

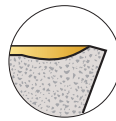
Geometrije pločica

Lakorezna geometrija -L



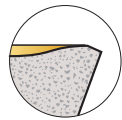
Oštre, pozitivne rezne ivice. Lako rezanje. Mali pomaci. Mala snaga mašine. Zahtevaju se manje sile rezanja.

Geometrija za opšte namene -M

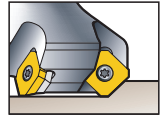


Geometrija za opšte namene -M
Pozitivna geometrija za mešanu proizvodnju. Srednji pomaci.

Jaka geometrija -H



Potrebna najviša sigurnost rezne ivice. Veliki pomaci.



Saveti za izbor glodala, pločica i kvaliteta

Završna obrada

Izaberite glodala sa maksimalnim brojem pločica i L geometrijom.

Izaberite kvalitete CT530 ili GC1030.

Za najbolji kvalitet obrađene površine koristiti $f_z = 0.08$ mm/zubu i $a_p = 0.7 - 0.8$ mm (startne vrednosti).

Najbolji kvalitet obrađene površine se ostvaruje ako se pomak po obrtaju održava unutar 70% širine paralelne faze. Takođe, za najbolju površinu, koristiti brzine rezanja od 300-400 m/min. Nema potrebe za korišćenjem rashladnog sredstva.

Tvrde komponente

Izaberite veliki radijus. Izaberite najveću moguću veličnu pločice.

Slabi pribori/komponente

Izaberite periferno brušene pločice.

Prekinut rez ili ponovno rezanje strugotine

Izaberite -H geometriju i žilaviji kvalitet.

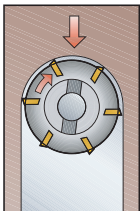
Nestabilni uslovi

Izaberite glodala sa širokom podelom.

Saveti za primenu

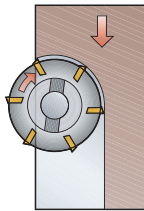
Prečnik glodala i pozicija

100% prečnika glodala D_C u zahvatu.



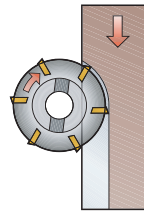
$v_C = 240$ m/min
 $f_z = 0.14$ mm/tooth

70% prečnika glodala D_C u zahvatu.



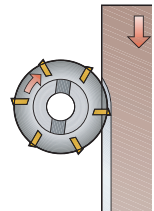
$v_C = 255$ m/min
 $f_z = 0.14$ mm/tooth

25% prečnika glodala D_C u zahvatu.



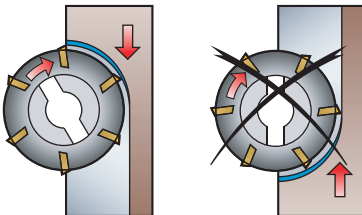
$v_C = 285$ m/min
 $f_z = 0.16$ mm/tooth

10% prečnika glodala D_C u zahvatu.



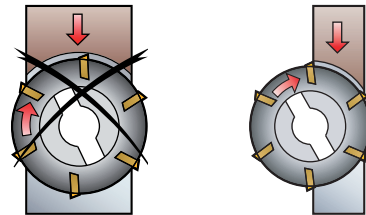
$v_C = 295$ m/min
 $f_z = 0.20$ mm/tooth

Smer glodanja

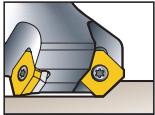


Istosmerno glodanje je poželjno kada god to dozvoljavaju mašina alatka, pribor i oblik obradka.

Pozicija glodala



Izaberite, ako je moguće, glodalo većeg prečnika od širine obradka.

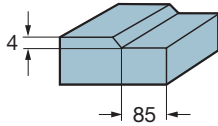


Opšte smernice

Proračun režima rezanja



Plansko glodanje



Glodalo ($D_c = 125$ mm)
 Pločica
 Materijal obradka
 Širina zahvata (a_e)
 Dubina rezanja (a_p)
 Napadni ugao (κ_r)
 Pomak/zubu (f_z)
 Brzina rezanja (v_c)

R245-125Q40-12M
 R245-12 T3 M-PM
 SS 1672-08 (HB =180)
 85
 4 mm
 45°
 0.21 mm
 250 m/min

$z_n = 5$
 GC4230
 CMC 02.1

Izračunaj broj obrtaja vretena (n)

$$n = \frac{v_c \times 1000}{\pi \times D_c}$$

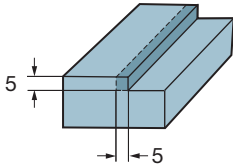
$$n = \frac{250 \times 1000}{\pi \times 125} \sim 635 \text{ rpm}$$

Izračunaj pomak stola (v_f)

$$v_f = z_n \times n \times f_z$$

$$v_f = 5 \times 635 \times 0.21 \sim 665 \text{ mm/min}$$

Ugaono glodanje sa napadnim uglom od 90°



Glodalo ($D_c = 63$ mm)
 Pločica
 Materijal obradka
 Širina zahvata (a_e)
 Dubina rezanja (a_p)
 Napadni ugao (κ_r)
 Pomak/zubu (f_z)
 Brzina rezanja (v_c)

R390-063Q22-17M
 R390-17 04 08M-PM
 SS 1672-08 (HB =180)
 5 mm
 5 mm
 0.15 mm
 265 m

$z_n = 5$
 GC1030
 CMC 02.1

Izračunaj broj obrtaja vretena (n)

$$n = \frac{v_c \times 1000}{\pi \times D_c}$$

$$n = \frac{265 \times 1000}{\pi \times 63} \sim 1300 \text{ rpm}$$

Izračunaj pomak stola (v_f)

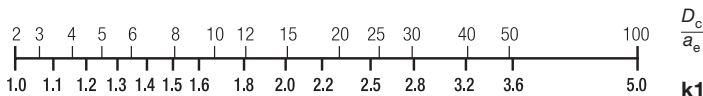
Kod bočnog glodanja, pomak se može povećati sa korektivnim faktorom.

$$v_f = k_1 \times z_n \times n \times f_z$$

$$v_f = 1.82 \times 5 \times 1300 \times 0.15 \sim 1775 \text{ mm/min}$$

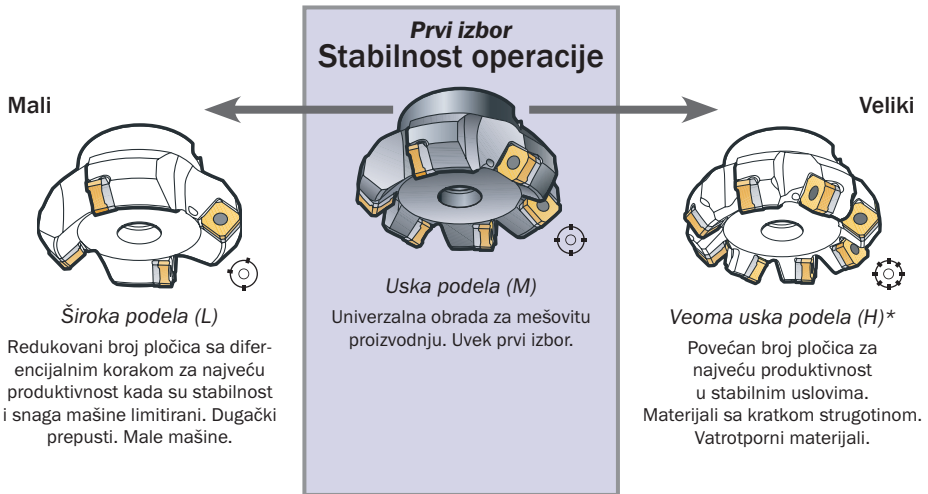
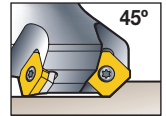
U tabeli ispod možete pronaći korektivni faktor, k_1 , izračunavši odnos D_c/a_e .

$$\frac{D_c}{a_e} = 12.6 \rightarrow k_1 = 1,82$$



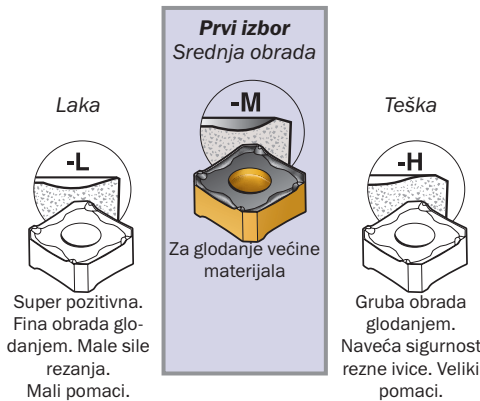
Plansko glodanje – CoroMill® 345

Troškovno efikasno glodalo - od srednjeg do lakog glodanja



*Za maksimalan broj pločica, ekstra uska podela (HX), pogledajte najnovij Glavni katalog ili datakata

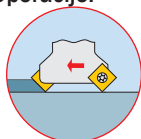
Geometrija pločice



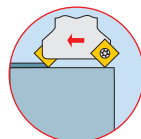
Materijal obratka/Geometrija

ISO/ANSI	L	M	H	Wiper
Čelik	P			
Nerđajući čelik	M			
Sivi liv	K			
Poboljšan materijal	H			

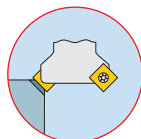
Operacije:



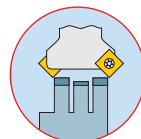
Opšte plansko glodanje



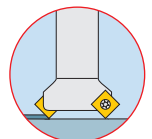
Plansko glodanje za super-finu površinu



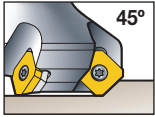
Obaranje ivica (stvarni ugađ 45°)



Prekinut rez



Dugačak prepust

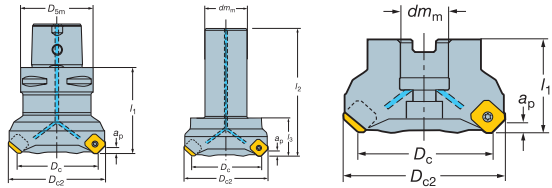


Plansko glodanje – CoroMill® 345

Prečnik 40 – 250 mm



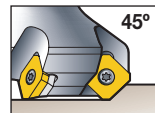
Maks. Dubina rezanja (a_p) 6mm
za pločicu veličine 13 mm



D_c	Kataloška oznaka Široka podela (L) Diferencijalna podela		Kataloška oznaka Uska podela (M) Jednaka podela		Kataloška oznaka Veoma uska podela (H) Jednaka podela		Dimenzije. mm			
	D_{5m}	D_{c2}	l_1	n	D_{5m}	D_{c2}	l_1	l_2	l_3	n
Coromant Capto										
40	345-040C4-13L	3	345-040C4-13M	4	–	–	–	–	–	–
50	050C5-13L	3	050C5-13M	4	345-050C5-13H	5	–	50	64.08	60
	050C6-13L	3	050C6-13M	4	050C6-13H	5	–	63	64.08	60
63	063C5-13L	4	063C5-13M	5	063C5-13H	6	–	50	78.08	60
	063C6-13L	4	063C6-13M	5	063C6-13H	6	–	63	77.08	60
80	080C6-13L	4	080C6-13M	6	080C6-13H	8	–	63	94.08	70
–	–	–	080C8-13M	6	080C8-13H	8	–	80	94.08	70
100	–	–	100C8-13M	7	100C8-13H	10	–	80	114.08	80
Cilindrična drška										
40	345-040A32-13L	3	345-040A32-13M	4	–	–	–	D_{m1}	D_{c2}	l_1
50	050A32-13L	3	050A32-13M	4	–	–	–	32	54.08	120
								32	64.08	120
										l_2
										l_3
										n
40								22	54.08	45
50								22	64.08	45
63								22	77.08	45
80								27	94.08	50
100								32	114.08	50
125								40	139.08	63
160								40	174.08	63
200								16	214.08	63
250								18	264.08	63
CIS Arbor prihvat										
80	A345-080J25-13L	4	A345-080J25-13M	6	A345-080J25-13H	8	–	25.4	94.08	50
100	100J31-13L	5	100J31-13M	7	100J31-13H	10	–	31.75	114.08	50
125	125J38-13L	6	125J38-13M	8	125J38-13H	12	–	38.1	139.08	63
160	160J51-13L	7	160J51-13M	10	160J51-13H	–	12	50.8	174.08	63
200	200J47-13L	8	200J47-13M	12	200J47-13H	–	16	47.625	214.08	63
250	250J47-13L	10	250J47-13M	14	250J47-13H	–	18	47.645	264.08	63

☉ = Jednak korak

☉☉ = Diferencijalni korak

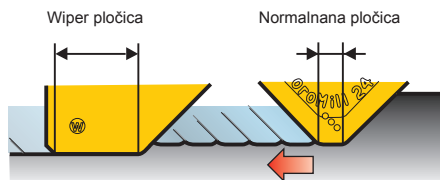


ISO/ANSI	L=Laka M=Srednja H=Teška	DOBRI USLOVI OBRADE			Prvi izbor SREDNJI USLOVI OBRADE			TEŠKI USLOVI OBRADE		
		Kataloška oznaka 	v_c	f_z	Kataloška oznaka 	v_c	f_z	Kataloška oznaka 	v_c	f_z
P	L	345R-1305E-PL 1030	300	0.12	345R-1305E-PL 1030	275	0.15	345R-1305E-PL 4240	200	0.15
	M	345R-1305M-PM 4220	290	0.30	345R-1305M-PM 4230	250	0.30	345R-1305M-PM 4240	225	0.30
	H	345R-1305M-PH 4220	250	0.45	345R-1305M-PH 4230	205	0.45	345R-1305M-PH 4240	175	0.45
M	L	345R-1305E-PL 2030	250	0.08	345R-1305E-PL 2030	240	0.18	345R-1305E-PL 2040	150	0.15
	M	345R-1305E-PL 2030	240	0.18	345R-1305M-PL 2030	180	0.18	345R-1305E-PL 2040	150	0.15
K	L	345R-1305M-KL 1020	285	0.12	345R-130M-KL 1020	230	0.12	345R-1305M-KL 3040	195	0.15
	M	345R-1305M-KM 3220	225	0.30	345R-130M-KM 3040	210	0.30	345R-1305M-KM 3040	175	0.30
	H	345R-1305M-KH 3220	190	0.35	345R-1305M-KH 3040	150	0.35	345R-1305M-KH 3040	150	0.35
H	L	345R-1305E-PL 530	70	0.12	345R-1305E-PL 1030	40	0.12	345R-1305M-PH 1030	40	0.25
	M	345R-1305M-PM 530	70	0.12	345R-1305M-PM 4220	40	0.30	345R-1305M-PH 1030	30	0.25
	H	345R-1305M-PM 530	70	0.12	345R-1305M-PH 4220	40	0.45	345R-1305M-PH 1030	30	0.30

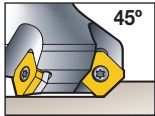
**Wiper pločica**

Wiper pločica će popraviti kvalitet obrađene površine pri velikim posmacima i dugačka paralelna faza pločice omogućava povećanje posmaka 4 puta više nego normalna, ne menjajući kvalitet površine. Obično je dovoljno koristiti samo jednu Wiper pločicu glodačkoj glavi.

Za informacije, pogledajte glavni katalog

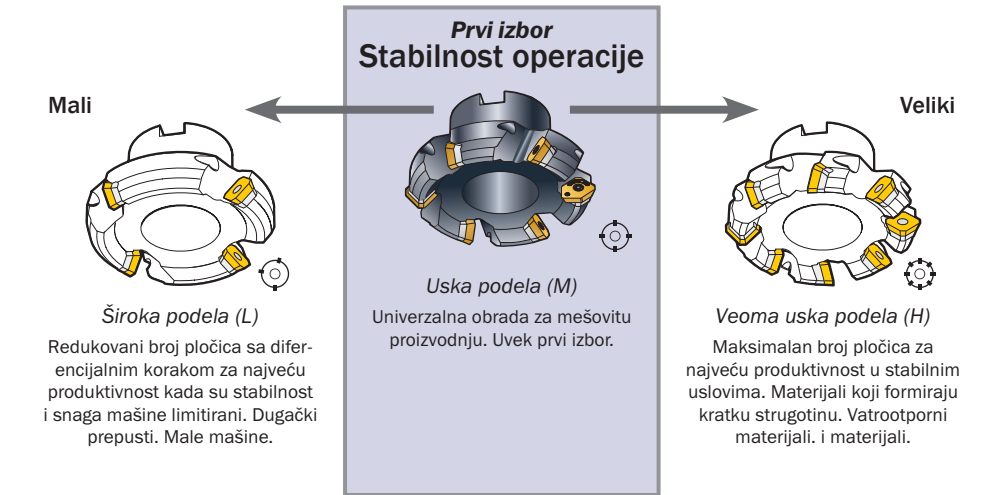


P GC1030	K GC1020
345N-1305EPW8 1030	345N-1305EPW8 1020

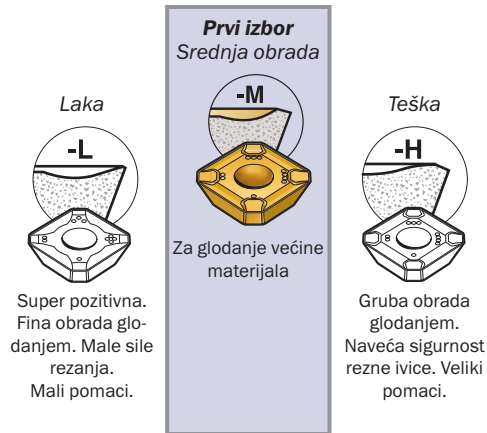


Plansko glodanje – CoroMill® 245

Univerzalna glodačka glava - od grube do fine obrade

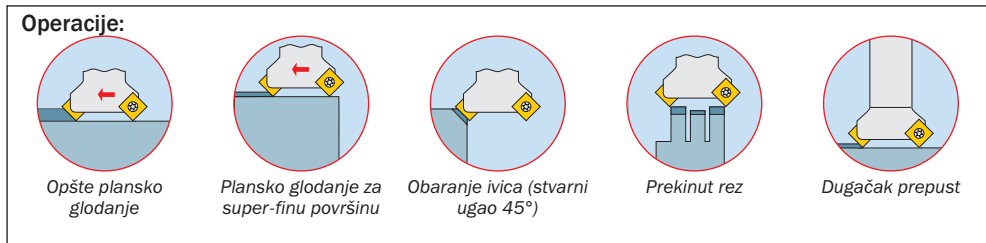


Geometrija pločice



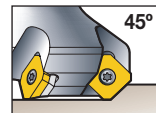
Materijal obratka/Geometrija

ISO/ANSI	L	M	H	Wiper
Čelik	P			
Nerđajući čelik	M			
Sivi liv	K			
Neferitni materijali	N			
Vatrootporni materijal	S			
Poboljšan materijal	H			

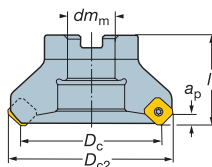


P	N	Plansko glodanje – CoroMill® 245
M	S	
K	H	

Prečnik 50 – 250 mm

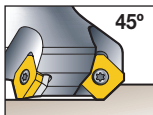


Maks. dubina rezanja (a_p)
za pločicu veličine 12=6mm,
za pločicu veličine 18=10mm



D_c	Kataloška oznaka		Kataloška oznaka		Kataloška oznaka		Dimenzije. mm				
	Široka podela (L) Diferencijalna podela		Uska podela (M) Jednaka podela		Veoma uska podela (H) Jednaka podela		dm_m	D_{c2}	l_1	n_{max}	
	Arbor prihvat										
50	R245-050Q22-12L	3	R245-050Q22-12M	4	R245-050Q22-12H	5	22	62.5	40	16250	12
63	063Q22-12L	4	063Q22-12M	5	063Q22-12H	6	22	75.5	40	14400	
80	080Q27-12L	4	080Q27-12M	6	080Q27-12H	8	27	92.5	50	12700	
100	100Q32-12L	5	100Q32-12M	7	100Q32-12H	10	32	112.5	50	11300	
125	125Q40-12L	6	125Q40-12M	8	125Q40-12H	12	40	137.5	63	10100	
160	160Q40-12L	7	160Q40-12M	10	160Q40-12H	16	40	172.5	63	8900	
200	200Q60-12L	8	200Q60-12M	12	200Q60-12H	20	60	212.5	63	7950	
250	250Q60-12L	10	250Q60-12M	14	250Q60-12H	24	60	262.5	63	7100	
80	–		R245-080Q32-18M	4	R245-080Q32-18H ¹⁾	5	32	98.8	50	6100	18
100	–		100Q32-18M	4	100Q32-18H ¹⁾	6	32	118.8	50	5400	
125	–		125Q40-18M	5	125Q40-18H	7	40	138.8	63	4900	
160	–		160Q40-18M	6	160Q40-18H	9	40	178.8	63	4300	
200	–		200Q60-18M	8	200Q60-18H	12	60	218.8	63	3800	
250	–		250Q60-18M	10	250Q60-18H	14	60	268.8	63	3400	
	CIS Arbor prihvat										
80	RA245-080J25.4-12L	4	RA245-080J25.4-12M	6	RA245-080J25.4-12H	8	25.4	92.5	50	12700	12
100	100J31.75-12L	5	100J31.75-12M	7	100J31.75-12H	10	31.75	112.5	63	11300	
125	125J38.1-12L	6	125J38.1-12M	8	125J38.1-12H	12	38.1	137.5	63	10100	
160	160J50.8-12L	7	160J50.8-12M	10	160J50.8-12H	16	50.8	172.5	63	8900	
200	200J47.625-12L	8	200J47.625-12M	12	200J47.625-12H	20	47.625	212.5	63	7950	
250	250J47.625-12L	10	250J47.625-12M	14	–	24	47.625	262.5	63	7100	
80	–		RA245-080J25-18M ¹⁾	4	RA245-080J25-18H ¹⁾	5	25.4	101.3	50	6100	18
100	–		100J31-18M ¹⁾	4	100J31-18H ¹⁾	6	31.75	118.8	50	5400	
125	–		125J38-18M	5	125J38-18H	7	38.1	143.8	63	4900	
160	–		160J51-18M	6	160J51-18H	9	50.8	178.8	63	4300	
200	–		200J47-18M	8	200J47-18H	12	47.625	218.8	63	3800	
250	–		250J47-18M	10	250J47-18H	14	47.625	268.8	63	3400	

¹⁾ Bez podložne pločice



Plansko glodanje – CoroMill® 245

Pločice i kvaliteti -
preporuke režima obrade - polazne vrednosti



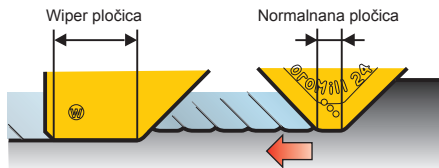
ISO/ANSI	L=Laka M=Srednja H=Teška	DOBRI USLOVI OBRABE			Prvi izbor SREDNJI USLOVI OBRABE			TEŠKI USLOVI OBRABE		
		Kataloška oznaka	v_c	f_z	Kataloška oznaka	v_c	f_z	Kataloška oznaka	v_c	f_z
P	L	R245-12T3E-PL 530	305	0.11	R245-12T3E-PL 1030	250	0.08	R245-12T3M-PL 4240	225	0.17
	M	R245-12T3M-PM 4220	290	0.24	R245-12T3M-PM 4230	250	0.21	R245-12T3M-PM 4240	225	0.24
		R245-18T6M-PM 4220	275	0.28	R245-18T6M-PM 4230	225	0.28	R245-18T6M-PM 4240	190	0.28
H	R245-12T3M-PH 4220	250	0.35	R245-12T3M-PH 4230	205	0.35	R245-12T3M-PH 4240	175	0.35	
M	L	R245-12T3E-ML 1025	295	0.08	R245-12T3E-ML 2030	230	0.14	R245-12T3E-ML 2040	220	0.14
	M/H	R245-12T3K-MM 2030	200	0.23	R245-12T3K-MM 2030	200	0.23	R245-12T3K-MM 2040	190	0.23
		R245-18T6M-MM 2030	185	0.28	R245-18T6M-MM 2040	175	0.28	R245-18T6M-MM 2040	175	0.28
K	L	R245-12T3E-KL 1020	285	0.11	R245-12T3M-KL 1020	230	0.18	R245-12T3M-KL 3040	195	0.17
	M	R245-12T3M-KM 3220	225	0.24	R245-12T3M-KM 1020	210	0.24	R245-12T3M-KM 3040	175	0.24
		R245-18T6M-KM 3220	285	0.28	R245-18T6M-KM 1020	200	0.28	R245-18T6M-KM 3040	165	0.28
H	R245-12T3M-KH 3220	190	0.35	R245-12T3M-KH 3040	150	0.35	R245-12T3M-KH 3040	150	0.35	
N	L	R245-12T3E CD10	1695	0.14	R245-12T3E-AL H10	760	0.24	R245-12T3E-KL H13A	700	0.11
	M/H	R245-12T3E CD10	1695	0.14	R245-12T3E-AL H10	760	0.24	R245-12T3M-KM H13A	610	0.24
S	L	R245-12T3E-ML 1025	40	0.08	R245-12T3E-ML 2030	35	0.14	R245-12T3E-ML 2040	35	0.14
	M/H	R245-12T3E-ML 2030	35	0.14	R245-12T3K-MM 2030	30	0.23	R245-12T3K-MM 2040	30	0.23
H	L	R245-12T3E CB50	145	0.14	R245-12T3E-PL 1030	40	0.08	R245-12T3M-KM 3040	35	0.24
	M/H	R245-12T3E CB50	145	0.14	R245-12T3M-PM 4220	45	0.24	R245-12T3M-KH 3040	30	0.35



Wiper pločica

Wiper pločica će popraviti kvalitet obradene površine pri velikim posmacima i dugačka paralelna faza pločice omogućava povećanje posmaka 4 puta više nego normalna, ne menjajući kvalitet površine. Obično je dovoljno koristiti samo jednu Wiper pločicu glodačkoj glavi.

Za informacije, pogledajte glavni katalog



P GC1030	M GC2030	K GC1020	H GC1010
R245-12 T3 E-W 1030 R245-18 T6 E-W 1030	R245-18 T6 E-W 2030	R245-12 T3 E-W 1020 R245-18 T6 E-W 1020	R245-12 T3 E-W 1010

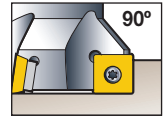
ISO/ANSI

P N
M S
K H

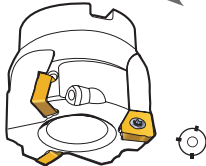
Ugaono glodanje – CoroMill® 490

Prvi izbor za lako rezanje kvadratnim pločicama i napadnim uglom od 90°

GLODANJE



Mali

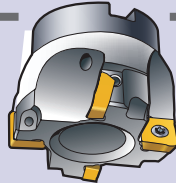


Široka podela (L)

Redukovani broj pločica sa diferencijalnim korakom za najveću produktivnost kada su stabilnost i snaga mašine limitirani.

Dugački prepusti.

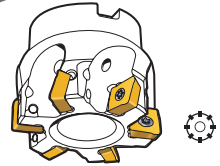
Prvi izbor
Stabilnost operacije



Uska podela (M)

Univerzalna obrada za mešovitu proizvodnju. Uvek prvi izbor.

Veliki



Veoma uska podela (H)

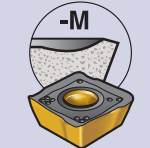
Veliki broj pločica za najbolju produktivnost pri stabilnim uslovi-ma. Materijali koji formiraju kratku strugotinu.

Geometrija pločice



Fina obrada glodanjem. Male sile rezanja. Mali posmaci.

Prvi izbor
Srednja obrada



Za glodanje većine materijala

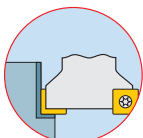


Gruba obrada glodanjem. Velike sile rezanja. Veliki pomaci.

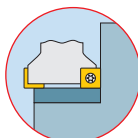
Materijal obratka/Geometrija

ISO/ANSI	L	M	H
Čelik	P		
Nerđajući čelik	M		
Sivi liv	K		
Poboljšan materijal	H		

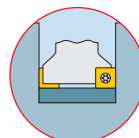
Operacije:



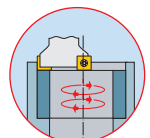
Uzastopno ugaono glodanje



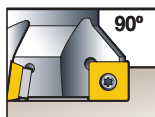
Ugaono glodanje sa kvadratnim pločicama



Glodanje žljebova



Kružna interpolacija

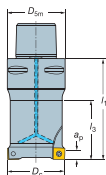


Ugaono glodanje – CoroMill® 490

Prečnik 20 – 84 mm



Maks. Dubina rezanja (a_p)
za pločicu veličine 8 = 5.5 mm,
za pločicu veličine 14 = 10 mm

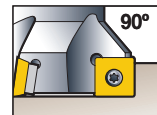


= Jednak korak

= Diferencijalan korak

D_c	Kataloška oznaka		Kataloška oznaka		Kataloška oznaka		Dimenzije mm					
	Široka podela (L)		Uska podela (M)		Veoma uska podela (H)		D_{5m}	l_1	l_3	n_{max}		
	Coromant Capto											
20	490-020C3-08L	2	–	–	–	–	32	80	40	48500	08	
	020C4-08L	2	–	–	–	–	40	70	40	39000		
	020C5-08L	2	–	–	–	–	50	75	40	28000		
	020C6-08L	2	–	–	–	–	63	80	40	20000		
25	–	–	490-025C3-08M	3	–	–	32	80	60	40400		
	–	–	025C4-08M	3	–	–	40	70	45	39000		
	–	–	025C5-08M	3	–	–	50	75	50	28000		
	–	–	025C6-08M	3	–	–	63	80	53	20000		
32	–	–	490-032C3-08M	4	–	–	32	80	60	33900		
	–	–	032C4-08M	4	–	–	40	70	45	33900		
	–	–	032C5-08M	4	–	–	50	75	50	28000		
	–	–	032C6-08M	4	–	–	63	80	53	20000		
	–	–	032C8-08M	4	–	–	80	80	45	14000		
36	–	–	490-036C3-08M	–	4	–	32	50	30	31300		
40	–	–	490-040C4-08M	–	4	490-040C4-08H	6	40	70	45		29300
	–	–	040C5-08M	–	4	040C5-08H	6	50	75	50		28000
	–	–	–	–	–	040C6-08H	6	63	80	53		20000
	–	–	–	–	–	040C8-08H	6	80	80	45		14000
44	–	–	490-044C4-08M	–	5	044C4-08H	6	40	60	40		27600
50	–	–	490-050C5-08M	–	5	050C5-08H	7	50	75	50		25500
	–	–	050C6-08M	–	5	050C6-08H	7	63	80	53		20000
	–	–	–	–	–	050C8-08H	7	80	80	45		14000
54	–	–	490-054C5-08M	–	5	054C5-08H	7	50	60	40		24300
63	–	–	490-063C6-08M	–	6	063C6-08H	8	63	50	23		20000
	–	–	–	–	–	063C8-08H	8	80	80	45	14000	
66	–	–	490-066C6-08M	–	6	066C6-08H	–	8	63	50	28	20000
80	–	–	490-080C8-08M	–	8	080C6-08H	–	10	80	80	45	14000
84	–	–	490-084C8-08M	–	8	084C6-08H	–	10	80	60	30	14000
40	–	–	490-040C4-14M ¹⁾	–	3	490-040C4-14H ¹⁾	4	40	70	45	26400	14
	–	–	040C5-14M ¹⁾	–	3	040C5-14H ¹⁾	4	50	75	50	26400	
	–	–	040C6-14M ¹⁾	–	3	040C6-14H ¹⁾	4	63	80	53	20000	
	–	–	–	–	–	040C8-14H ¹⁾	4	80	80	45	14000	
44	–	–	490-044C4-14M ¹⁾	–	3	490-044C4-14H ¹⁾	4	40	70	70	24600	
50	–	–	490-050C5-14M	–	4	490-050C5-14H ¹⁾	5	50	75	50	13700	
	–	–	050C6-14M	–	4	050C6-14H ¹⁾	5	63	80	53	13700	
	–	–	–	–	–	050C8-14H	5	80	80	45	13700	
54	–	–	490-054C5-14M	–	4	490-054C5-14H ¹⁾	5	50	60	60	13000	
63	–	–	490-063C6-14M	–	5	490-063C6-14H	6	63	80	53	11700	
	–	–	–	–	–	063C8-14H	6	80	80	45	11700	
66	–	–	490-066C6-14M	–	5	490-066C6-14H	6	63	65	65	11400	
80	–	–	490-080C6-14M	–	6	490-080C6-14H	8	63	65	65	10100	
	–	–	490-080C8-14M	–	6	490-080C8-14H	8	80	80	45	10100	
84	–	–	490-084C8-14M	–	6	490-084C8-14H	8	80	70	70	9800	

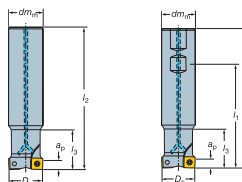
¹⁾ Bez podložnih pločica



Maks. dubina rezanja (a_p)
za pločicu veličine 8 = 5.5 mm,
za pločicu veličine 14 = 10 mm

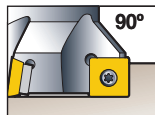
= Jednak korak

= Diferencijalan korak



D_c	Kataloška oznaka			Kataloška oznaka			Kataloška oznaka			Dimenzije. mm					
	Široka podela (L)		Uska podela (M)		Veoma uska podela (H)		D_{m1}	l_1	l_2	l_3	n_{max}				
	Weldon														
20	490-020B16-08L	2	–	–	–	–	–	–	–	16	50.5	74	25	48500	08
	020B20-08L	2	–	–	–	–	–	–	–	20	51.5	76	25	48500	
25	490-025B20-08L	2	–	–	–	–	–	–	–	20	58.5	83	32	40400	
	–	–	–	490-025B25-08M	3	–	–	–	–	25	56.5	88	32	40400	
32	490-032B25-08L	–	3	490-032B25-08M	4	–	–	–	–	25	66.5	98	40	33900	
	–	–	–	032B32-08L	–	3	–	–	–	32	64.5	100	40	33900	
40	–	–	–	490-040B32-08M	–	4	–	–	–	32	76.5	112	50	29300	
40	–	–	–	490-040B32-14M*	–	3	490-040B32-14H*	4	–	32	76.5	112	50	26400	14
	Cilindrična drška														
20	490-020A16-08L	2	–	–	–	–	–	–	–	16	100	25	48500	08	
	020A20-08L	2	–	–	–	–	–	–	–	20	110	25	48500		
22	490-022A20-08L	2	–	–	–	–	–	–	–	20	170	30	20300		
25	490-025A20-08L	2	–	490-025A20-08M	3	–	–	–	–	20	110	32	40400		
	025A25-08L	2	–	025A25-08M	3	–	–	–	–	25	120	32	40400		
28	490-028A25-08L	2	–	–	–	–	–	–	–	25	210	35	11000		
32	490-032A25-08L	–	3	490-032A25-08M	4	–	–	–	–	25	120	40	33900		
	–	–	–	032A32-08L	–	3	–	–	–	32	130	40	33900		
40	490-040A32-08L	–	3	490-040A32-08M	–	4	490-040A32-08H	6	–	32	170	50	20300		
40	–	–	–	490-040A32-14M*	–	3	490-040A32-14H*	4	–	32	170	50	26400	14	
	–	–	–	040A32L-14M ¹⁾	–	3	–	–	–	32	250	65	7600		
50	490-050A32-14L	–	3	490-050A32-14M	–	4	–	–	–	32	120	40	13700		
63	490-063A32-14L	–	4	490-063A32-14M	–	5	–	–	–	32	120	40	11700		

¹⁾ Bez podložnih pločica

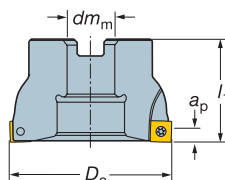


Ugaono glodanje – CoroMill® 490

Prečnik 40 – 250 mm



Maks. Dubina rezanja (a_p)
za pločicu veličine 8 = 5.5 mm,
za pločicu veličine 14 = 10 mm



= Jednak korak

= Diferencijalan korak

D_c	Kataloška oznaka		Kataloška oznaka		Kataloška oznaka		Dimenzije. mm				
	Široka podela (L)		Uska podela (M)		Veoma uska podela (H)		D_{m1}	D_{5m}	l_1	n_{max}	
	CIS Arbor prihvat										
80	A490-080J25.4-08L	– 6	A490-080J25.4-08M	– 8	A490-080J25.4-08H	– 10	25.4	58	50	19400	08
100	A490-100J31.75-08L	– 6	A490-100J31.75-08M	– 8	A490-100J31.75-08H	– 10	31.7	76	63	17100	
125	A490-125J38.1-08L	– 8	A490-125J38.1-08M	– 10	A490-125J38.1-08H	– 12	38.1	85	63	15200	
80	A490-080J25.4-14L	– 4	A490-080J25.4-14M	– 6	A490-080J25.4-14H	8 –	25.4	58	50	10100	14
100	A490-100J31.75-14L	– 5	A490-100J31.75-14M	– 7	A490-100J31.75-14H	10 –	31.7	76	63	8900	
125	A490-125J38.1-14L	– 6	A490-125J38.1-14M	– 8	–	–	38.1	85	63	7800	
160	–	–	A490-160J50.8-14M	– 12	–	–	50.8	110	63	6800	
200	–	–	A490-200J47.625-14M	– 16	–	–	47.6	160	63	6000	
250	–	–	A490-250J47.625-14M	– 18	–	–	47.6	160	63	5300	
	Arbor prihvat										
40	–	–	490-040Q16-08M	– 4	490-040Q16-08H	6 –	16	30	40	29300	08
44	–	–	490-044Q16-08M	– 5	–	–	16	30	40	27600	
50	490-050Q22-08L	– 4	490-050Q22-08M	– 5	490-050Q22-08H	7 –	22	46	40	25500	
54	–	–	490-054Q22-08M	– 5	–	–	22	46	40	24300	
63	490-063Q22-08L	– 5	490-063Q22-08M	– 6	490-063Q22-08H	8 –	22	46	40	22200	
80	490-080Q27-08L	– 6	490-080Q27-08M	– 8	490-080Q27-08H	– 10	27	58	50	19400	
100	490-100Q32-08L	– 6	490-100Q32-08M	– 8	490-100Q32-08H	– 10	32	76	50	17100	
125	490-125Q40-08L	– 8	490-125Q40-08M	– 10	490-125Q40-08H	– 12	40	85	63	15200	
50	–	–	490-050Q22-14M	– 4	490-050Q22-14H ¹⁾	5 –	22	41	40	13700	14
63	–	–	490-063Q22-14M	– 5	490-063Q22-14H	6 –	22	41	40	11700	
80	–	–	490-080Q27-14M	– 6	490-080Q27-14H	8 –	27	58	50	10100	
100	490-100Q32-14L	– 5	490-100Q32-14M	– 7	490-100Q32-14H	10 –	32	76	50	8900	
125	490-125Q40-14L	– 6	490-125Q40-14M	– 8	490-125Q40-14H	12 –	40	85	63	7800	
160	490-160Q40-14L	– 8	490-160Q40-14M	– 12	490-160Q40-14H	15 –	40	110	63	6800	
200	490-200Q60-14L	– 10	490-200Q60-14M	– 16	–	–	60	160	63	6000	
250	490-250Q60-14L	– 12	490-250Q60-14M	– 18	–	–	60	160	63	5300	

¹⁾ Bez podložnih pločica

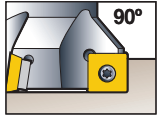
ISO/ANSI



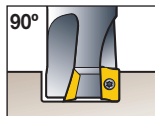
Ugaono glodanje – CoroMill® 490

Pločice i kvaliteti -

preporuke režima obrade - polazne vrednosti



ISO/ANSI	L=Laka M=Srednja H=Teška	DOBRI USLOVI OBRADE			Prvi izbor SREDNJI USLOVI OBRADE			TEŠKI USLOVI OBRADE		
		Kataloška oznaka 	v_c	f_z	Kataloška oznaka 	v_c	f_z	Kataloška oznaka 	v_c	f_z
P	L	490R-08T308M-PL 1030	325	0.12	490R-08T308M-PL 1030	290	0.10	490R-08T308M-PL 4240	250	0.10
		490R-140408M-PL 1030	325	0.12	490R-140408M-PL 1030	290	0.10	490R-140408M-PL 4240	250	0.10
	M	490R-08T308M-PM 1030	290	0.17	490R-08T308M-PM 1030	250	0.15	490R-08T308M-PM 4240	200	0.15
		490R-140408M-PM 4230	290	0.17	490R-140408M-PM 4240	230	0.15	490R-140408M-PM 4240	200	0.15
	H	490R-08T308M-PH 1030	250	0.24	490R-08T308M-PH 1030	200	0.21	490R-08T316M-PH 1030	180	0.21
		490R-140408M-PH 4230	250	0.24	490R-140408M-PH 4240	200	0.21	490R-140420M-PH 1030	180	0.21
M	L	490R-08T308E-ML 2030	220	0.14	490R-08T308E-ML 2030	200	0.14	490R-08T308E-ML 2040	180	0.14
	M/H	490R-08T312E-MM 2030	200	0.18	490R-08T312E-MM 2030	190	0.18	490R-08T316E-MM 2030	190	0.18
K	L	490R-08T308M-KL 1020	300	0.14	490R-08T308M-KL 1020	275	0.12	490R-08T308M-KL 3040	180	0.12
		490R-140408M-PL 1020	300	0.14	490R-140408M-PL 1020	275	0.12	490R-140408M-PL 3040	180	0.12
	M	490R-08T308M-KM 1020	280	0.19	490R-08T308M-KM 1020	250	0.17	490R-08T308M-KM 3040	160	0.17
		490R-140408M-PM 3040	250	0.19	490R-140408M-PM 3040	220	0.17	490R-140408M-PM 3040	180	0.17
	H	490R-08T308M-KH 1020	250	0.26	490R-08T308M-KH 1020	200	0.24	490R-08T316M-KH 1020	180	0.24
		490R-140408M-PH 3040	230	0.26	490R-140408M-PH 3040	190	0.24	490R-140420M-PH 1020	180	0.24
H	L	490R-08T308M-PL 1010	110	0.10	490R-08T308M-PL 1010	110	0.10	490R-08T308M-PL 1030	70	0.10
		490R-14T308M-PL 1030	70	0.10	490R-14T308M-PL 1030	70	0.10	490R-08T308M-PL 1030	70	0.10
	M/H	490R-08T308M-PM 1010	95	0.15	490R-08T308M-PM 1010	95	0.15	490R-08T308M-PM 1030	50	0.15
		490R-14T308M-PM 1030	50	0.15	490R-14T308M-PM 1030	50	0.15	490R-14T308M-PM 1030	50	0.15



Ugaono glodanje – CoroMill® 390

Veličine pločica 11 i 17 mm

ISO/ANSI

P	N
M	S
K	H

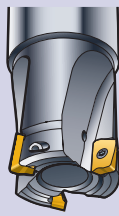
Prvi izbor Stabilnost operacije

Mali



Široka podela (L)

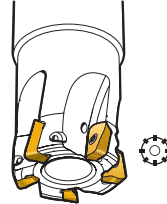
Redukovani broj pločica. Koristiti kada su stabilnost i snaga mašine limitirani. Glodanje žljebova. Dugački prepusti. Male mašine.



Uska podela (M)

Univerzalna obrada za mešovitu proizvodnju. Male i srednje mašine. Obični prvi izbor.

Veliki



Veoma uska podela (H)

Veliki broj pločica za najbolju produktivnost pri stabilnim uslovima. Materijali koji formiraju kratku strugotinu. Vatrootorni materijali. Ugaono glodanje priprema.

Geometrija pločice

Materijal obratka/Geometrija



Laka

Lako glodanje. Male sile rezanja. Mali pomaci.

Prvi izbor
Srednja obrada



Za glodanje većine materijala

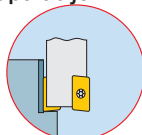
Teška



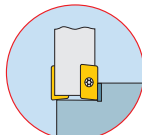
Gruba obrada glodanjem. Velike sile rezanja. Veliki pomaci.

ISO/ANSI	L	M	H
Čelik	P		
Nerđajući čelik	M		
Sivi liv	K		
Aluminijum	N		
Vatrootporne legure	S		
Kaljani materijal	H		

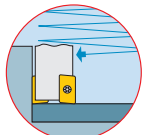
Operacije:



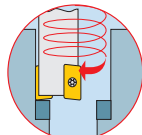
Uzastopno ugaono glodanje



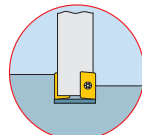
Ugaono glodanje



Ulazak pod uglom - ukopavanje



Bušenje - Helikoidna interpolacija

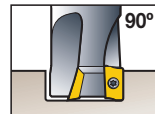


Glodanje žljebova

P N Ugaono glodanje – CoroMill® 390

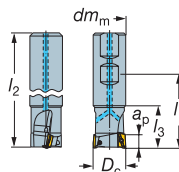
M S
K H

Prečnici 12 - 40 mm
Cilindrične i Weldon drške



Veličine pločica 11 i 17 mm

Maks. dubina reza (a_p)
veličina 11 = 10mm,
veličina 17 = 15.7 mm

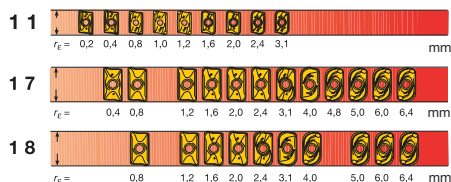


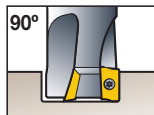
D_c	Kataloška oznaka		Kataloška oznaka		Kataloška oznaka		Dimenzije. mm					
	Široka podela (L)		Uska podela (M)		Veoma uska podela (H)		dm_m	l_1	l_2	l_3	n_{max}	
	Cilindrična drška											
12	R390-012A16-11L	1	–	–	–	–	16	–	95	20	68600	11
16	016A16-11L	2	–	–	–	16	–	100	25	41500		
20	020A20-11L	2	R390-020A20-11M	3	–	20	–	110	25	34600		
25	025A25-11L	2	025A25-11M	3	R390-025A25-11H	4	25	–	120	32	36500	
32	032A32-11L	2	032A32-11M ¹⁾	3	032A32-11H ¹⁾	5	32	–	130	40	31000	
40	040A32-11L	2	040A32-11M ¹⁾	4	040A32-11H ¹⁾	6	32	–	170	50	27000	
25	R390-025A25-17L	2	–	–	–	25	–	120	32	30800	17	
32	032A32-17L	2	R390-032A32-17M	3	–	32	–	130	40	25600		
40	040A32-17L	2	040A32-17M ¹⁾	3	R390-040A32-17H ¹⁾	4	32	–	170	50		21900
	Weldon											
12	R390-012B16-11L	1	–	–	–	16	44.5	68	20	68600	11	
16	016B16-11L	2	–	–	–	16	49.5	68	25	41500		
20	020B20-11L	2	R390-020B20-11M	3	–	20	56.5	81	25	34600		
25	025B25-11L	2	025B25-11M	3	R390-025B25-11H	4	25	56.5	88	32		36500
32	032B32-11L	2	032B32-11M ¹⁾	3	032B32-11H ¹⁾	5	32	64.5	100	40		31000
40	040B32-11L	2	040B32-11M ¹⁾	4	040B32-11H ¹⁾	6	32	74.5	110	50		27000
25	R390-025B25-17L	2	–	–	–	25	56.5	88	32	30800	17	
32	032B32-17L	2	R390-032B32-17M ¹⁾	3	–	32	64.5	100	40	25600		
40	040B32-17L	2	040B32-17M ¹⁾	3	R390-040B32-17H ¹⁾	4	32	74.5	110	50		21900

¹⁾ Diferencijalni korak

CoroMill 390 pločice standardnog radijusa.

Izabrati najveći mogući radijus za najveću postojanost i sigurnost rezne ivice.





Ugaono glodanje – CoroMill® 390

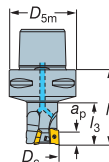
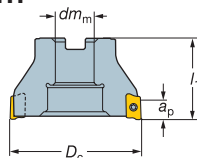
Prečnici 16 - 125

Nasadna glodala i Coromant Capto



Veličine pločica 11 i 17 mm

Maks. dubina reza (a_p)
 veličina 11 = 10mm,
 veličina 17 = 15.7 mm



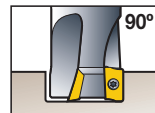
D_c	Kataloška oznaka		Kataloška oznaka		Kataloška oznaka		Dimenzije. mm				
	Široka podela (L)		Uska podela (M)		Veoma uska podela (H)		dm_m	l_1	l_3	n_{max}	
	Arbor prihvat										
40			R390-040Q16-11M ¹⁾	4	R390-040Q16-11H ¹⁾	6	16	40	–	27000	11
50			050Q22-11M ¹⁾	5	050Q22-11H ¹⁾	7	22	40	–	23700	
63			063Q22-11M ¹⁾	6	063Q22-11H ¹⁾	8	22	40	–	20700	
80			080Q27-11M ¹⁾	7	080Q27-11H ¹⁾	10	27	50	–	18200	
40	R390-040Q16-17L	2	R390-040Q16-17M ¹⁾	3	R390-040Q16-17H ¹⁾	4	16	40	–	21900	17
50	050Q22-17L ¹⁾	3	050Q22-17M ¹⁾	4	050Q22-17H ¹⁾	5	22	40	–	19000	
63	063Q22-17L ¹⁾	4	063Q22-17M ¹⁾	5	063Q22-17H ¹⁾	6	22	40	–	16500	
80	080Q27-17L ¹⁾	4	080Q27-17M ¹⁾	6	080Q27-17H ¹⁾	8	27	50	–	14400	
100	100Q32-17L	5	100Q32-17M	7	100Q32-17H	9	32	50	–	12700	
125	125Q40-17L	6	125Q40-17M	8	125Q40-17H	11	40	50	–	11200	
	CIS Arbor prihvat										
80	RA390-080J25.4-17L	4	RA390-080J25.4-17M	6	RA390-080J25.4-17H	8	25.4	50	–	14400	17
	Coromant Capto										
16	R390-016C4-11L	2	–	–	–	6	C4	50	25	39000	11
20	020C4-11L	2	–	–	–	6	C4	50	25	34600	
	–		R390-020C5-11M095	3	–	6	C5	95	40	34600	
	–		020C6-11M110	3	–	6	C6	110	40	34600	
25	025C4-11L	2	025C4-11M	3	–	6	C4	55	32	36500	
	–		025C5-11M095	3	–	6	C5	95	45	36500	
	–		025C6-11M110	3	–	6	C6	110	45	36500	
32	032C4-11L	2	032C4-11M ¹⁾	3	–	6	C4	65	40	31000	
	032C5-11L	2	032C5-11M ¹⁾	3	–	6	C5	65	40	31000	
	–		032C5-11M095	3	–	6	C5	95	50	31000	
	–		032C6-11M080	3	–	6	C6	80	40	31000	
	–		032C6-11M110	3	–	6	C6	110	50	31000	
36	–		036C3-11M050	3	–	6	C3	50	50	29000	
	–		036C3-11M075	3	–	6	C3	75	75	29000	
40	–		040C4-11M ¹⁾	4	–	6	C4	70	70	27000	
	–		–	–	R390-040C4-11H ¹⁾	6	C4	70	50	27000	
	–		040C5-11M ¹⁾	4	040C5-11H ¹⁾	6	C5	75	50	27000	
	–		040C6-11M080	4	–	6	C6	80	40	27000	
44	–		044C4-11M060	4	–	6	C4	60	60	25600	
	–		044C4-11M075	4	–	6	C4	75	75	25600	
50	–		050C5-11M060	5	–	6	C5	60	60	23700	
	–		050C6-11M080	5	–	6	C6	80	40	23700	
54	–		054C5-11M060	5	–	6	C5	60	60	22700	
	–		054C5-11M080	5	–	6	C5	80	80	22700	
63	–		063C5-11M060	5	–	6	C5	60	60	20700	
	–		063C6-11M080	6	–	6	C6	80	40	20700	
66	–		066C6-11M060	6	–	6	C6	60	60	20200	
	–		066C6-11M080	6	–	6	C6	80	80	20200	
80	–		080C6-11M060	7	–	6	C6	60	60	18200	
	–		080C6-11M080	7	–	6	C6	80	80	18200	

¹⁾ Diferencijalni korak

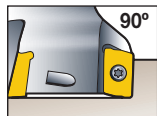
Ugaono glodanje – CoroMill® 390

Veličine pločica 11 i 17 mm.

Kvaliteti - preporuke režima rezanja - polazne vrednosti



ISO/ANSI	L=Laka M=Srednja H=Teška	DOBRI USLOVI OBRABE			Prvi izbor SREDNJI USLOVI OBRABE			TEŠKI USLOVI OBRABE		
		Kataloška oznaka □	v_c	f_z	Kataloška oznaka □	v_c	f_z	Kataloška oznaka □	v_c	f_z
P	L	R390-11T308M-PL 4230	320	0.08	R390-11T308M-PL 1030	275	0.08	R390-11T308M-PL 4240	270	0.10
	M	R390-11T308M-PM 4230	320	0.10	R390-11T308M-PM 1030	270	0.12	R390-11T308M-PM 4240	270	0.12
		R390-170408M-PM 4230	320	0.17	R390-170408M-PM 1030	265	0.15	R390-170408M-PM 4240	265	0.15
H	R390-170408M-PH 4240	260	0.20	R390-170408M-PH 4240	260	0.20	R390-170408M-PH 4240	260	0.20	
M	L	R390-11T308E-ML 2030	275	0.1	R390-11T308E-ML 2030	275	0.10	R390-11T308E-ML 2040	260	0.10
	M/H	R390-11T308M-PM 1030	290	0.12	R390-11T308M-MM 2030	270	0.13	R390-11T308M-MM 2040	260	0.13
		R390-170408M-PM 1030	285	0.15	R390-170408M-MM 2030	270	0.15	R390-170408M-MM 2040	255	0.15
K	L	R390-11T308M-KL 3040	235	0.10	R390-11T308M-KL 3040	235	0.10	R390-11T308M-KM 1020	280	0.12
	M	R390-11T308M-KM 3040	230	0.12	R390-11T308M-KM 3040	230	0.12	R390-11T308M-KM 1020	280	0.12
		R390-170408M-KM 3040	230	0.15	R390-170408M-KM 3040	230	0.15	R390-170408M-KH 1020	270	0.20
H	R390-170408M-KH 3040	225	0.20	R390-170408M-KH 3040	225	0.20	R390-170408M-KH 1020	270	0.20	
N	L/M/H	R390-11T304E-P4-NL CD10	1860	0.17	R390-11T308E-NL H13A	750	0.15	R390-11T308E-NL H13A	750	0.15
		R390-170408E-P6-NL CD10	1860	0.17	R390-170408E-NL H13A	750	0.15	R390-170408E-NL H13A	750	0.15
S	L/M/H	R390-11T308M-PL 1030	40	0.08	R390-11T308E-ML 2030	40	0.10	R390-11T308E-ML 2040	40	0.10
		R390-170408M-PL 1030	40	0.08	R390-170408E-ML 2030	40	0.10	R390-170408E-ML 2040	40	0.1
H	L/M/H	R390-11T308M-PL 530	90	0.08	R390-11T308M-KL 3040	50	0.10	R390-11T308M-PL 1025	45	0.08
		R390-170408M-PL 530	90	0.08	R390-170408M-KL 3040	50	0.10	R390-170408M-PL 1025	45	0.08



Ugaono glodanje – CoroMill® 390

Veličina pločica 18 mm

ISO/ANSI



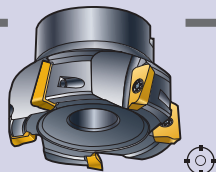
Prvi izbor Stabilnost operacije

Mali



Široka podela (L)

Redukovani broj pločica sa diferencijalnim korakom za najveću produktivnost kada su stabilnost i snaga mašine limitirani. Male sile rezanja



Uska podela (M)

Univerzalna obrada za mešovitu proizvodnju. Male i srednje mašine. Obično prvi izbor.

Veliki



Veoma uska podela (H)

Veliki broj pločica za najbolju produktivnost pri stabilnim uslovima. Materijali koji formiraju kratku strugotinu. Vatrootorni materijali. Ugaono glodanje priprema.

Geometrija pločice

Materijal obratka/Geometrija



Laka

Lako glodanje. Male sile rezanja. Mali pomaci..

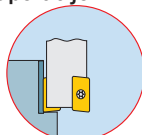
Prvi izbor
Srednja obrada



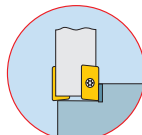
Za glodanje većine materijala

ISO/ANSI	L	M	H
Čelik	P		
Nerđajući čelik	M		
Sivi liv	K		
Vatrootporni materijali	S		

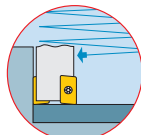
Operacije:



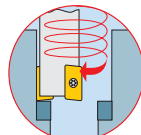
Uzastopno ugaono glodanje



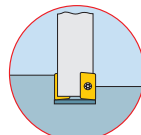
Ugaono glodanje



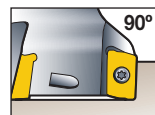
Ulazak pod uglom - ukopavanje



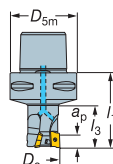
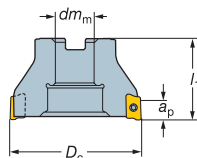
Bušenje - Helikoidna interpolacija



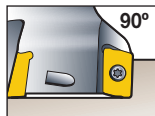
Glodanje žljebova



Veličina pločice 18 mm

Maks. dubina rezanja (a_p)= 15.7mm

D_c	Kataloška oznaka		Kataloška oznaka		Kataloška oznaka		Dimenzije. mm					
	Široka podela (L)		Uska podela (M)		Veoma uska podela (H)		dm_m	l_1	l_3	n_{max}		
	Arbor prihvat											
50	R390-050Q22-18L	3	R390-050Q22-18M	4	R390-050Q22-18H	5	22	40	–	7900	18	
63	063Q22-18L	4	063Q22-18M	5	063Q22-18H	6	22	40	–	6800		
80	080Q27-18L	4	080Q27-18M	6	–	–	27	50	–	5900		
100	100Q32-18L	5	100Q32-18M	7	–	–	32	50	–	5200		
125	125Q40-18L	6	125Q40-18M	8	–	–	40	63	–	4600		
160	160Q40-18L	8	160Q40-18M	12	–	–	40	63	–	4000		
200	200Q60-18L	10	–	–	–	–	60	63	–	3600		
	CIS Arbor prihvat											
80	–	–	RA390-080J25.4-18M	6	–	–	25.4	50	–	5900	18	
100	–	–	100J31.75-18M	7	–	–	31.8	50	–	5200		
125	–	–	125J38.1-18M	8	–	–	38.1	63	–	4600		
160	–	–	160J50.8-18M	12	–	–	50.8	63	–	4000		
200	RA390-200J47.625-18L	10	–	–	–	–	47.625	63	–	3600		
	Coromant Capto											
40	–	–	R390-040C4-18M060	3	–	–	C4	60	40	9200	18	
–	–	–	040C5-18M080	3	–	–	C5	80	40	9200		
–	–	–	040C6-18M100	3	–	–	C6	100	50	9200		
44	R390-044C4-18L080	2	–	–	–	–	C4	80	–	8600		
–	–	–	044C4-18M060	3	–	–	C4	60	–	8600		
–	–	–	044C4-18M080	3	–	–	C4	80	–	8600		
50	–	–	050C5-18M060	4	–	–	C5	60	40	7900		
–	–	–	050C6-18M080	4	–	–	C6	80	40	7900		
54	–	–	054C5-18M060	4	–	–	C5	60	–	7500		
–	–	–	054C5-18M080	4	–	–	C5	80	–	7500		
63	–	–	063C5-18M060	5	–	–	C5	60	–	6800		
–	–	–	063C6-18M060	–	–	–	C6	60	38–	6800		
66	–	–	066C6-18M060	5	–	–	C6	60	–	6700		
–	–	–	066C6-18M080	5	–	–	C6	80	–	6700		
80	–	–	080C6-18M060	6	–	–	C6	60	–	5900		
84	–	–	084C8-18M070	6	–	–	C8	70	–	5800		
–	–	–	084C8-18M100	6	–	–	C8	100	–	5800		



90° Ugaono glodanje - CoroMill® 390

Veličine pločica 18 mm. Kvaliteti - preporuke režima rezanja
- polazne vrednosti



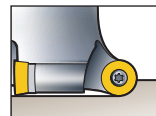
ISO/ANSI	L=Laka M=Srednja H=Teška	DOBRI USLOVI OBRADE			Prvi izbor SREDNJI USLOVI OBRADE			TEŠKI USLOVI OBRADE		
		L/M/H	Kataloška oznaka 	v_c	f_z	Kataloška oznaka 	v_c	f_z	Kataloška oznaka 	v_c
P	L	R390-180612M-PM 4220	375	0.18	R390-180612M-PM 4230	305	0.20	R390-180612M-PM 4240	255	0.22
	M	R390-180612M-PM 4220	375	0.18	R390-180612M-PM 4230	305	0.20	R390-180612M-PM 4240	255	0.22
	H	R390-180612H-PL 1030	270	0.11	R390-180612M-PM 4230	305	0.20	R390-180612M-PM 4240	255	0.22
M	L/M	R390-180612M-PM 1030	275	0.20	R390-180612M-MM 2030	265	0.18	R390-180612M-MM 2040	255	0.15
K	L/M	R390-180612M-KM 3040	220	0.22	R390-180612M-KM 3040	220	0.22	R390-180612M-KM 1020	270	0.22
	H	R390-180631H-KL 3040	230	0.13	R390-180631H-KL 3040	230	0.13	R390-180631H-KL 1020	280	0.13
S	L/M/H	R390-180612M-PM 1030	40	0.2	R390-180612M-MM 2030	40	0.18	R390-180612M-MM 2040	40	0.15



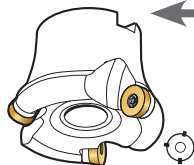
Plansko i profilno glodanje – CoroMill® 200

Veoma gruba obrada

GLODANJE



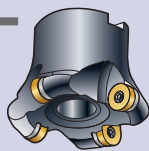
Mali



Široka podela (L)

Redukovani broj pločica sa diferencijalnim korakom za najveću produktivnost kada su stabilnost i snaga mašine limitirani. Kopanje dubokih kanala. Dugački prepusti. Male mašine. Male sile rezanja.

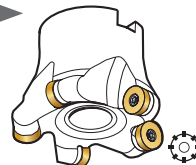
Prvi izbor Stabilnost operacije



Uska podela (M)

Univerzalna obrada za mešovitu proizvodnju. Male i srednje mašine. Uvek prvi izbor.

Veliki



Veoma uska podela (H)

Veliki broj pločica za najbolju produktivnost pri stabilnim uslovima. Materijali koji formiraju kratku strugotinu. Vatrootorni materijali. Ugaono glodanje priprema.

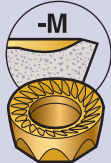
Geometrija pločice

Laka



Lako glodanje. Male sile rezanja. Mali pomaci.

Prvi izbor
Srednja obrada



Za glodanje većine materijala

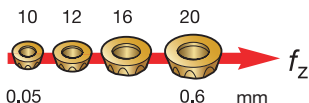
Teška



Gruba obrada glodanjem. Velike sile rezanja. Veliki pomaci.

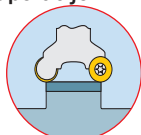
Materijal obratka/Geometrija

ISO/ANSI	L	M	H
Čelik			
Nerđajući čelik			
Sivi liv			
Kaljani materijal			

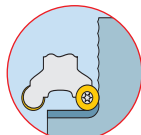


Četiri veličine pločica dostupne u tri geometrije, omogućavaju dubinu reza od 10 mm sa posmacima od 0.05 do 0.6 mm po zubu.

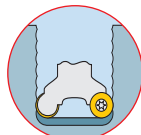
Operacije:



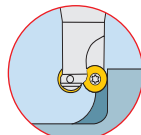
Opšte plansko glodanje



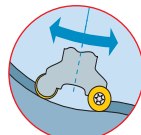
Ugaono glodanje



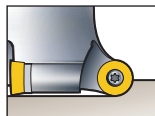
Glodanje žljebova punih širina



Glodanje preostalog materijala

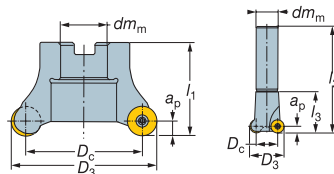


Profilisanje



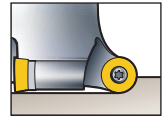
Plansko i profilno glodanje – CoroMill® 200

Prečnik 32 – 100 mm

Maks. dubina rezanja (a_p) = 6 mm

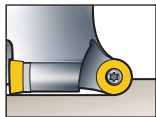
D_3	Kataloška oznaka Široka podela (L) Diferencijalna podela		Kataloška oznaka Uska podela (M) Diferencijalna podela		Kataloška oznaka Veoma uska podela (H) Jednaka podela		Dimenzije, mm					
	D_c		dm_m		l_1		n_{max}					
	Arbor prihvat											
50	R200-038Q22-12L	3	R200-038Q22-12M	4	R200-038Q22-12H	5	38	22	50	18800	12	
52	040Q22-12L	3	040Q22-12M	4	040Q22-12H	5	40	22	50	18000		
63	051Q22-12L	3	051Q22-12M	4	051Q22-12H	5	51	22	50	16200		
80	068Q27-12L	4	068Q27-12M	6	–	–	68	27	50	14000		
100	088Q32-12L	4	088Q32-12M	6	–	–	88	32	50	12300		
	CIS Arbor prihvat											
80	RA200-068J25.4-12L	4	RA200-068J25.4-12M	6	–	–	68	25.4	50	14000	12	
100	088J31.75-12L	4	088J31.75-12M	6	–	–	88	31.75	63	12300		
D_3	Široka podela (L) Jednaka podela		Uska podela (M) Jednaka podela		Veoma uska podela (H) Jednaka podela		D_c	dm_m	l_2	l_3	n_{max}	
	Cilindrična drška											
32	–		R200-020A25-12M	2	R200-020A25-12H	3	20	25	190	35	31100	12
40	R200-028A32-12L	2	028A32-12M	3	–	–	28	32	240	63	26300	
50	038A32-12L	3	038A32-12M	4	–	–	38	32	240	63	22500	

Za g. glave u drugim veličinama, (10, 16 i 20 mm) videti glavni katalog.



ISO/ANSI	L=Laka M=Srednja H=Teška	DOBRI USLOVI OBRABE			Prvi izbor SREDNJI USLOVI OBRABE			TEŠKI USLOVI OBRABE		
		L/M/H	Kataloška oznaka 	v_c	f_z	Kataloška oznaka 	v_c	f_z	Kataloška oznaka 	v_c
P	L	RCHT1204M0-PL 1030	250	0.08	RCHT1204M0-PL 1030	250	0.08	RCHT1204M0-PL 1030	250	0.08
	M	RCKT1204M0-PM 4220	290	0.24	RCKT1204M0-PM 4230	250	0.21	RCKT1204M0-PM 4240	205	0.24
	H	RCKT1204M0-PH 4220	250	0.35	RCKT1204M0-PH 4230	205	0.35	RCKT1204M0-PH 4240	175	0.35
M	L	RCHT1204M0-PL 1030	265	0.08	RCHT1204M0-ML 2030	205	0.21	RCHT1204M0-ML 2040	195	0.21
	M/H	RCKT1204M0-MM 2030	185	0.28	RCKT1204M0-MM 2030	185	0.28	RCKT1204M0-MM 2040	175	0.28
K	L	RCHT1204M0-KL H13A	105	0.11	RCHT1204M0-KL H13A	105	0.11	RCHT1204M0-KL H13A	105	0.11
	M	RCKT1204M0-KM 3220 ¹⁾	225	0.24	RCKT1204M0-KM 1020	210	0.24	RCKT1204M0-KM 1020	210	0.24
	H	RCKT1204M0-KH 3220 ¹⁾	190	0.35	RCKT1204M0-KH 3040	150	0.35	RCKT1204M0-KH 3040	150	0.35
H	L/M/H	RCHT1204M0-PL 1010	100	0.14	RCKT1204M0-PM 4220	45	0.24	RCKT1204M0-KM 3040	35	0.24

¹⁾ Kvalitet 3220 samo za suvo glodanje



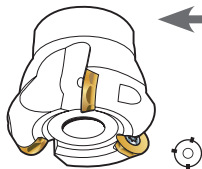
Plansko i profilno glodanje – CoroMill® 300

Gruba do polufine obrade i profilisanje



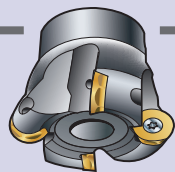
Prvi izbor Stabilnost operacije

Mali



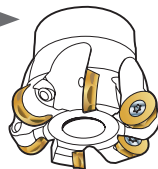
Široka podela (L)

Redukovani broj pločica sa diferencijalnom podelom za najveću produktivnost kada su stabilnost i snaga mašine limitirani. Male mašine.



Uska podela (M)

Univerzalna obrada za mešovitu proizvodnju. Uvek prvi izbor.



Veoma uska podela (H)

Maksimalan broj pločica za najveću produktivnost u stabilnim uslovima. Materijali koji formiraju kratku strugotinu. Vatrootporni materijali.

Geometrija pločice

Materijal obratka/Geometrija

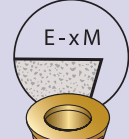


Visoka preciznost. Lako rezanje. Male sile rezanja. Mali pomaci.

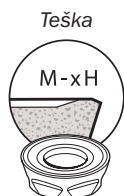


Laka obrada glodanjem. Male sile rezanja. Mali pomaci.

Prvi izbor
Srednja obrada

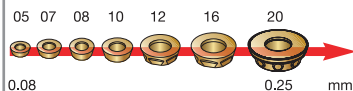


Za glodanje većine materijala



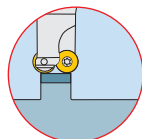
Gruba obrada glodanjem. Velike sile rezanja. Veliki pomaci.

	L	M	H
P			
M			
K			
N			
S			
H			

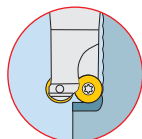


Sedam veličina pločica dostupno u četiri geometrije, pokrivajući dubine rezanja do 10 mm (preporuke za poprečni presek strugotine Hex od min 0,05 mm do max 0,55 mm)

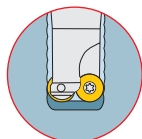
Operacije:



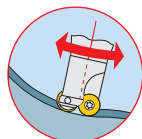
Opšte plansko glodanje



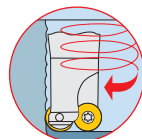
Ugaono glodanje



Glodanje žlebova punih širina



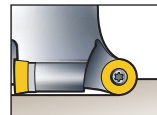
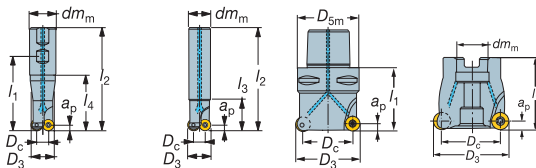
Profilisanje



Helikoidna interpolacija

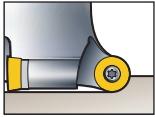
P	N	Plansko i profilno glodanje – CoroMill® 300
M	S	
K	H	

Prečnik 25 – 80 mm

Maks. dubina rezanja (a_p) = 6 mm

	Kataloška oznaka	Kataloška oznaka	Kataloška oznaka	Dimenzije. mm						
D_3	Široka podela (L)	Uska podela (M)	Veoma uska podela (H)	D_c	dm_m	l_2	l_3	n_{max}		
25	Cilindrični nosač - Neutralan dizajn R300-025A32L-12L 2	-	-	13	32	250	80	15800	12	
32	-	R300-032A25-12M 2	-	20	25	190	40	8900	12	
40	-	040A32-12M 3	-	28	32	250	40	11400		
32	-	-	R300-032A25-12H 3	20	25	150	40	35500		
40	-	-	040A32-12H 4	28	32	150	40	28500		
D_3	Široka podela (L) Jednaka podela	Uska podela (M) Diferencijalna podela	Veoma uska podela (H) Jednaka podela	D_c	dm_m	l_1	l_2	l_4	n_{max}	
25	Weldon - Neutralan dizajn R300-025B32L-12L 2	-	-	13	32	105	141	41	20200	12
D_3	Široka podela (L) Diferencijalna podela	Uska podela (M) Diferencijalna podela	Veoma uska podela (H) Jednaka podela	D_c	D_{5m}	dm_m	l_1	n_{max}		
35	-	R300-035C3-12M 3	R300-035C3-12H 4	23	C3	40	32900	12		
42	-	042C4-12M 3	042C4-12H 4	30	C4	40	28300			
52	R300-052C5-12L 3	052C5-12M 4	052C5-12H 5	40	C5	50	24400			
66	066C6-12L 4	066C6-12M 5	066C6-12H 7	54	C6	50	21700			
80	-	080C6-12M 6	080C6-12H 8	68	C6	50	18900			
50	Arbor prihvat - Pozitivni dizajn R300-050Q22-12L 3	R300-050Q22-12M 4	R300-050Q22-12H 5	38	22	50	25000	12		
52	052Q22-12L 3	052Q22-12M 4	052Q22-12H 5	40	22	50	24400			
63	063Q22-12L 4	063Q22-12M 5	063Q22-12H 7	51	22	50	22100			
80	-	080Q27-12M 6	080Q27-12H 8	68	22	50	18900			

Za g. glave u drugim veličinama, (5, 7, 8, 10, 16 i 20 mm) videti glavni katalog



Plansko i profilno glodanje – CoroMill® 300

Pločice i kvaliteti - preporuke režima obrade - polazne vrednosti

ISO/ANSI



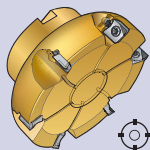
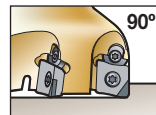
ISO/ANSI	L=Laka M=Srednja H=teška	DOBRI USLOVI OBRADE			Prvi izbor SREDNJI USLOVI OBRADE			TEŠKI USLOVI OBRADE		
		Kataloška oznaka	v_c	f_z	Kataloška oznaka	v_c	f_z	Kataloška oznaka	v_c	f_z
P	L	R300-1240M-PM 4230	250	0.21	R300-1240M-PM 1030	210	0.21	R300-1240M-PM 4240	210	0.21
	M	R300-1240M-PM 4230	250	0.21	R300-1240E-PM 1030	200	0.25	R300-1240E-PM 4240	200	0.25
	H	R300-1240M-PH 4230	225	0.28	R300-1240M-PH 1030	190	0.28	R300-1240M-PH 4240	190	0.28
M	L	R300-1240E-PM 1030	205	0.25	R300-1240M-MM 2030	205	0.21	R300-1240M-MM 2040	195	0.21
	M	R300-1240M-PM 1030	220	0.21	R300-1240E-MM 2030	195	0.25	R300-1240E-MM 2040	185	0.25
	H	R300-1240M-MH 2030	185	0.28	R300-1240M-MH 2030	185	0.28	R300-1240M-MH 2040	175	0.28
K	L	R300-1240M-PM 4220	190	0.21	R300-1240M-PM 4230	160	0.21	R300-1240M-PM 4240	145	0.21
	M	R300-1240M-PM 4220	190	0.21	R300-1240M-PM 4230	160	0.21	R300-1240E-PM 4240	140	0.25
	H	R300-1240M-KH 3220 ¹⁾	210	0.28	R300-1240M-KH 3040	165	0.28	R300-1240M-KH 3040	165	0.28
N	L/M/H	R300-1240E-PL 1030	945	0.18	R300-1240E-PL 1030	945	0.18	R300-1240M-PM 1030	915	0.21
S	L/M/H	R300-1240E-PM 1030	35	0.25	R300-1240E-MM 2030	30	0.25	R300-1240E-MM 2040	30	0.25
H	L/M/H	R300-1240E-PM 1010	80	0.25	R300-1240M-PM 4220	45	0.21	R300-1240M-KH 3040	30	0.28

¹⁾ Kvalitet 3220 samo za suvo glodanje



Plansko glodanje - CoroMill® Century

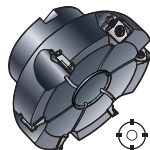
Za velike brzine obrade neferitnih materijala. Aluminijumska i čelična tela.



Glodačke glave od visokolegiranog aluminijuma za obradu neferitnih materijala.

Uska podela (M)

Lake glodačke glave za velike brzine rezanja pri obradi neferitnih materijala. Aluminijumsko telo smanjuje opterećenje na uležištenju. Veoma male sile rezanja sa veoma pozitivnom geometrijom. Prvi izbor za neferitne materijale.

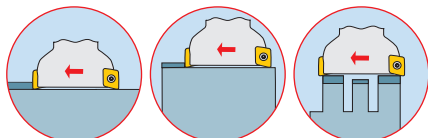


Glodačke glave od čelika za obradu veoma abrazivnog aluminijuma i zahtevne operacije.

Uska podela (M)

Glodačke glave od čelika koje mogu da zadovolje različite zahteve izazvane osobinama neferitnih materijala pri obradi. Veoma male sile rezanja sa pozitivnom geometrijom.

Operacije:



Opšte plansko glodanje

Super - finiš

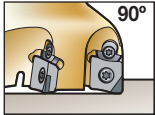
Prekinut rez

Oblasti primene

ISO/ANSI	Tvrđi metal		CBN		PCD	
	L	Wiper	L	Wiper	L	Wiper
Sivi liv K						
Neferitni materijali N						
Kaljani materijal H						

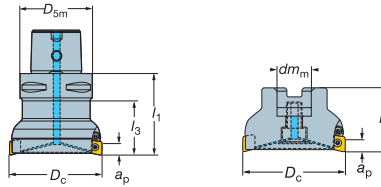
Pločice i kvaliteti - preporuke režima oobrade - polazne vrednosti

ISO/ANSI	L=Laka M=Srednja H=Teška	DOBRI USLOVI OBRADJE			Prvi izbor SREDNJI USLOVI OBRADJE			TEŠKI USLOVI OBRADJE		
		Kataloška oznaka	v_c	f_z	Kataloška oznaka	v_c	f_z	Kataloška oznaka	v_c	f_z
K	L	R590-1105H-ZC2-KL CB50	640	0.4	R590-1105H-ZC2-KL CB50	640	0.4	-		
N	L	R590-1105H-PR2-NL CD10	1570	0.15	R590-110504H-NL H10	730	0.20	R590-110504H-NL H10	730	0.20
H	L	R590-1105H-ZC2-KL CB50	140	0.24	R590-1105H-ZC2-KL CB50	140	0.24	-		



Plansko glodanje – CoroMill® Century

Prečnik 40 – 200 mm

Maks. dubina rezanja (a_p) = 2 - 10 mm
zavisno od tipa pločice

D_c	Kataloška oznaka		Telo glodačke glave	Dimenzije. mm				
	Uska podela (M)			dm_m	l_1	l_3	n_{max}	
	Arbor prihvat							
80	R590-080Q27A-11M	6	Aluminijum	27	50	–	27500	11
100	100Q32A-11M	6		32	50	–	23800	
125	125Q40A-11M	8		40	63	–	20700	
160	160Q40A-11M	10		40	63	–	17900	
200	200Q60A-11M	16		60	63	–	15700	
50	R590-050Q22S-11M	4	Čelik	22	40	–	41600	11
63	063Q22S-11M	5		22	40	–	35100	
80	080Q27S-11M	6		27	50	–	27500	
100	100Q32S-11M	6		32	50	–	23800	
125	125Q40S-11M	8		40	63	–	20700	
160	160Q40S-11M	10		40	63	–	17900	
200	200Q60S-11M	16	60	63	–	15700		
	CIS Arbor prihvat							
80	RA590-080J25A-11M	6	Aluminijum	25.3	50	–	27500	11
100	100J31A-11M	6		31.75	50	–	23800	
125	125J38A-11M	8		38.1	63	–	20700	
160	160J38A-11M	10		38.1	63	–	17900	
200	200J47A-11M	16		47.625	63	–	15700	
80	RA590-080J25S-11M	6	Čelik	25.4	50	–	27500	11
100	100J31S-11M	6		31.8	50	–	23800	
125	125J38S-11M	8		38.1	63	–	20700	
160	160J38S-11M	10		38.1	63	–	17900	
200	200J47S-11M	16		47.625	63	–	15700	
	Coromant Capto							
40	R590-040C3-11M	3	Čelik	C3	55	40	48000	11
40	040C4-11M	3		C4	63	40	39000	
50	050C5-11M	4		C5	63	40	28000	
63	063C5-11M	5		C5	63	40	28000	
80	080C6-11M	6		C6	71	–	20000	

Wiper pločica

	CB50	CD10	H10
K	R590-1105H-ZC2-KW CB50	–	–
N	–	R590-1105H-RR2-NW CD10	R590-110504H-NW H10
H	R590-1105H-ZC2-KW CB50	–	–

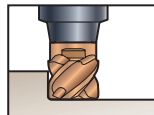
ISO/ANSI



CoroMill® 316

Glodanje bokom, obaranje ivica i profilno glodanje

Sistem za glodanje sa izmenljivim vrhovima



Glodalo za obaranje ivica

Obaranje ivica glodanjem.

Sa reznom ivicom do centra i bez
rezne ivice do centra.

Ugao obaranja ivica 15°, 30°, 45°,
60°.



Strana 173

Loptasta glodala

Profile milling

Sa reznom ivicom do centra.

Ugao zavojnice 40°.



Strana 173

Prvi izbor

Vretenasto glodalo sa radijusom

Univerzalno glodanje.

Sa reznom ivicom do centra.

Diferencijalna podela.

Ugao zavojnice 50°.



Strana 172

Vretenasto glodalo za velike pomake

Grubo glodanje.

Bez rezne ivice do centra.

Ugao zavojnice 50°.



Strana 174

Vretensto glodalo za grubu obradu

"Kordell" geometrija

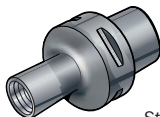
Sa reznom ivicom do centra.

Ugao zavojnice 40°, 45°.



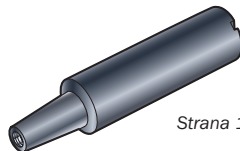
Strana 174

Coromant Capto® adapter



Strana 175

Cilindrični nosač



Strana 176

Operacije:



Univerzalno glodanje



Obaranje ivice



Profilno glodanje

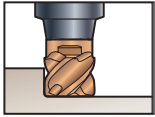


Glodanje velikim
pomakom



Grubo glodanje

Za informacije o kompletnom programu, videti Glavni katalog ili dodatak.



CoroMill® 316

Izmenljivi vrhovi

**Vretenasta glodala sa radijusom**

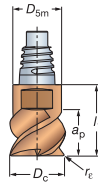
Prvi izbor za univerzalno glodanje

Prečnik: 10 - 25 mm

Sa reznom ivicom do centra

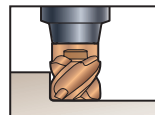
Diferencijalna podela zuba

Ugao zavojnice: 50°

Tolerancija: $D_c = h9$ 

D_c mm	Kataloška oznaka	Veličina prihvata	Dimenzije, mm					z_n	d_{5m}	l_1	r_ϵ	a_p	P	M	K	S		
			GC1030	GC1030	GC1030	GC1030												
10	316-10SM350-10005P	E10	3	9.7	12.4	0.5	5.5											
	-10SM350-10010P		3	9.7	12.4	1.0	5.5											
	-10SM450-10005P		4	9.7	12.4	0.5	5.5											
	-10SM450-10010P		4	9.7	12.4	1.0	5.5	★	★									
	-10SM450-10015P		4	9.7	12.4	1.5	5.5											
	-10SM450-10020P		4	9.7	12.4	2.0	5.5											
	-10SM450-10030P		4	9.7	12.4	3.0	5.5											
12	316-12SM350-12005P	E12	3	11.7	14.5	0.5	6.5											
	-12SM350-12010P		3	11.7	14.5	1.0	6.5											
	-12SM450-12005P		4	11.7	14.5	0.5	6.5											
	-12SM450-12010P		4	11.7	14.5	1.0	6.5											
	-12SM450-12015P		4	11.7	14.5	1.5	6.5	★	★									
	-12SM450-12020P		4	11.7	14.5	2.0	6.5											
	-12SM450-12030P		4	11.7	14.5	3.0	6.5											
16	316-16SM350-16005P	E16	3	15.5	18.7	0.5	8.5											
	-16SM350-16010P		3	15.5	18.7	1.0	8.5											
	-16SM450-16005P		4	15.5	18.7	0.5	8.5											
	-16SM450-16010P		4	15.5	18.7	1.0	8.5											
	-16SM450-16015P		4	15.5	18.7	1.5	8.5	★	★									
	-16SM450-16020P		4	15.5	18.7	2.0	8.5											
	-16SM450-16030P		4	15.5	18.7	3.0	8.5											
20	316-20SM350-20005P	E20	3	19.3	21.3	0.5	11.0											
	-20SM350-20010P		3	19.3	21.3	1.0	11.0											
	-20SM450-20005P		4	19.3	21.3	0.5	11.0											
	-20SM450-20010P		4	19.3	21.3	1.0	11.0	★	★									
	-20SM450-20015P		4	19.3	21.3	1.5	11.0											
	-20SM450-20020P		4	19.3	21.3	2.0	11.0											
	-20SM450-20040P		4	19.3	21.3	4.0	11.0											
25	316-25SM350-25010P	E25	5	24.2	25.6	1.0	13.0											
	-25SM350-25015P		5	24.2	25.6	1.5	13.0	★	★									
	-25SM450-25020P		5	24.2	25.6	2.0	13.0											

 z_n = broj reznih ivica

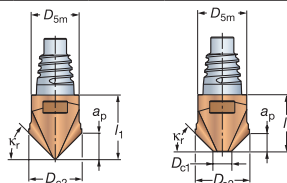
**Glodalo za obaranje ivica**

Obaranje ivica glodanjem

Prečnik: 10 – 16 mm

Sa reznom ivicom do centra i bez rezne ivice do centra

Ugao obaranja ivica: 15°, 30°, 45°, 60°

Tolerancija: $D_c = h10$ 

D_{c2} mm	Kataloška oznaka	Veličina prihvata	Dimenzije, mm						a_p	P GC1030	M GC1030	K GC1030	S GC1030
			z_n	d_{5m}	d_{c1}	l_1	K_f						
10	316-10CM400-10045G	E10	4	9.7			12.4	45	4.25	★	★	★	★
	-10CM400-10060G		4	9.7	3.50	12.4	60	5.5	★	★	★	★	
12	316-12CM600-12015G	E12	6	11.7			14.5	15	1.2				
	-12CM600-12030G		6	11.7		14.5	30	2.6	★	★	★	★	
	-12CM600-12045G		6	11.7		14.5	45	4.5					
	-12CM600-12060G		6	11.7	4.50	14.5	60	6.5	★	★	★	★	
16	316-16CM800-16045G	E16	8	15.5			18.7	45	6.5	★	★	★	★

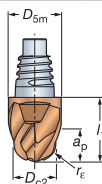
 z_n = broj reznih ivica**Loptasto glodalo**

Profilno glodanje

Prečnik: 10 – 25 mm

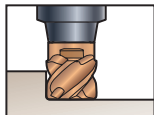
Sa reznom ivicom do centra

Ugao zavojnice: 40°

Tolerancija: $D_c = h9$ 

D_{c2} mm	Kataloška oznaka	Veličina prihvata	Dimenzije, mm					a_p	P GC1030	M GC1030	K GC1030	S GC1030
			z_n	d_{5m}	l_1	r_ε						
10	316-10BM440-10050G	E10	4	9.7	12.4	5.0	5.5	★	★	★	★	
12	316-12BM440-12060G	E12	4	11.7	14.5	6.0	6.5	★	★	★	★	
16	316-16BM440-16080G	E16	4	15.5	18.7	8.0	8.5	★	★	★	★	
20	316-20BM240-200AG	E20	2	19.3	21.3	10.0	11.0					
	-20BM440-200AG		4	19.3	21.3	10.0	11.0	★	★	★	★	
25	316-25BM240-250DG	E25	2	24.2	25.6	12.5	13.5					
	-25BM440-250DG		4	24.2	25.6	12.5	13.5	★	★	★	★	

 z_n = broj reznih ivica



CoroMill® 316

Izmenljivi vrhovi



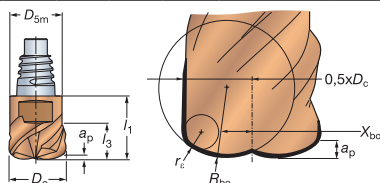
Vretenasto glodalo za velike pomake

Grubo glodanje

Prečnik: 10 – 25 mm

Bez rezne ivice do centra

Ugao zavojnice: 50°

Tolerancija: $D_c = h9$ 

D_c mm	Kataloška oznaka	Veličina prihvata	Dimenzije, mm										P	M	K	S
			z_n	d_{5m}	l_1	l_3	R_{comp}	R_{bo}	X_{bo}	r_ϵ	a_p	GC1030				
10	316-10HM350-10015P -10HM450-10015P	E10	3	9.7	12.4	5.5	1.99	5.00	1.70	1.5	0.7	★	★	★	★	
			4	9.7	12.4	5.5	1.99	5.00	1.70	1.5	0.7	★	★	★	★	
12	316-12HM350-12015P -12HM450-12015P	E12	3	11.7	14.5	6.5	2.10	6.00	2.25	1.5	0.8	★	★	★	★	
			4	11.7	14.5	6.5	2.10	6.00	2.25	1.5	0.8	★	★	★	★	
16	316-16HM350-16020P -16HM450-16020P	E16	3	15.5	18.7	8.5	2.75	8.00	3.10	2.0	1.0	★	★	★	★	
			4	15.5	18.7	8.5	2.75	8.00	3.10	2.0	1.0	★	★	★	★	
20	316-20HM350-20020P -20HM450-20020P	E20	3	19.3	21.3	11.0	3.07	10.00	4.00	2.0	1.3	★	★	★	★	
			4	19.3	21.3	11.0	3.07	10.00	4.00	2.0	1.3	★	★	★	★	
25	316-25HM450-25030P	E25	4	24.2	25.6	13.0	4.21	12.00	5.00	3.0	1.6	★	★	★	★	

 R_{comp} = vrednost koja mora biti programirana , pri obradi radijusa z_n = broj reznih ivica

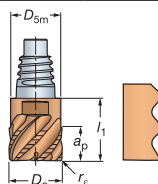
Glodalo za grubu obradu

Prečnik 10 – 25 mm

Kordell geometrija

Sa reznom ivicom do centra

Ugao zavojnice: 40°, 45°

Tolerancija: $D_c = h12$ 

D_{c2} mm	Kataloška oznaka	Veličina prihvata	Dimenzije, mm						P	M	K	S
			z_n	d_{5m}	l_1	r_ϵ	a_p	GC1030				
10	316-10SM440-10004K -10SM545-10004K	E10	4	9.7	12.4	0.4	5.5	★	★	★	★	
			5	9.7	12.4	0.4	5.5	★	★	★	★	
12	316-12SM440-12004K -12SM545-12004K	E12	4	11.7	14.5	0.4	6.5	★	★	★	★	
			5	11.7	14.5	0.4	6.5	★	★	★	★	
16	316-16SM440-16004K -16SM645-16004K	E16	4	15.5	18.7	0.4	8.5	★	★	★	★	
			6	15.5	18.7	0.4	8.5	★	★	★	★	
20	316-20SM845-20004K	E20	6	19.3	21.3	0.4	11.0	★	★	★	★	
25	316-25SM845-25004K	E25	8	24.2	25.6	0.4	13.5	★	★	★	★	

 z_n = broj reznih ivica

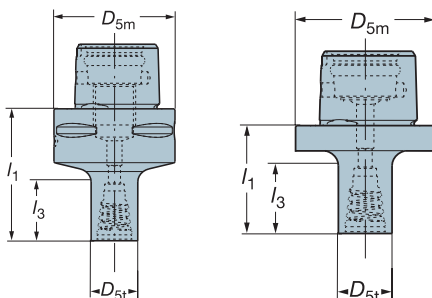
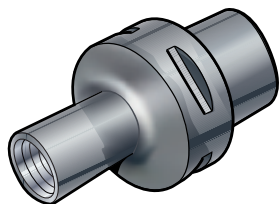
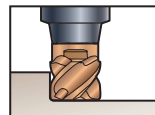
ISO/ANSI



CoroMill® 316

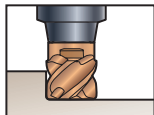
Coromant Capto® adapter za izmenljive vrhove

GLODANJE



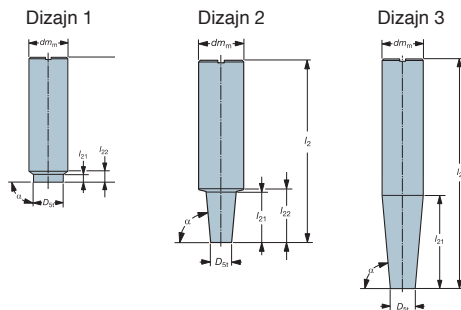
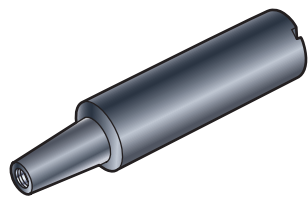
Coromant Capto Veličina	Veličina prihvata	Kataloška oznaka	Hladjenje*	Dimenzije, mm			
				D_{5m}	D_{5t}	l_1	l_3
C3	E10	C3-391.EH-10 035	3	32	9.6	35	13.2
	E12	-391.EH-12 038	3	32	11.6	38	16.4
	E16	-391.EH-16 043	3	32	15.4	43	21.9
C4	E10	C4-391.EH-10 041	3	40	9.6	41	13.1
	E12	-391.EH-12 044	3	40	11.6	44	16.4
	E16	-391.EH-16 049	3	40	15.4	49	21.9
	E20	-391.EH-20 046	3	40	19.2	46	19.4
C5	E10	C5-391.EH-10 042	3	50	9.6	42	12.8
	E12	-391.EH-12 045	3	50	11.6	45	16.0
	E16	-391.EH-16 050	3	50	15.4	50	21.5
	E20	-391.EH-20 047	3	50	19.2	47	19.0
	E25	-391.EH-25 052	3	50	24.1	52	24.7
C6	E12	C6-391.EH-12 049	3	63	11.6	49	16.3
	E16	-391.EH-16 054	3	63	15.4	54	21.8
	E20	-391.EH-20 051	3	63	19.2	51	19.3
	E25	-391.EH-25 056	3	63	24.1	56	25.0
Bez prihvatnog žljebova za manuelnu izmenu							
C3	E10	C3-391.EH-10 026	3	32	9.6	26	13.0
	E12	-391.EH-12 029	3	32	11.6	29	16.0
C4	E10	C4-391.EH-10 028	3	40	9.6	26	13.0
	E12	-391.EH-12 029	3	40	11.6	29	16.0
	E16	-391.EH-16 035	3	40	15.4	35	22.0

*Hlađenje je moguće i kroz centar i radialno

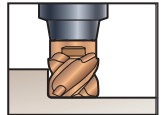


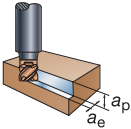
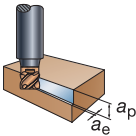
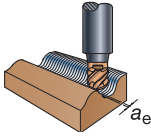
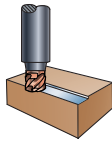
CoroMill® 316

Cilindrični držač za izmenljive vrhove



Veličina prihvata	Dizajn	Kataloška oznaka	Dimenzije, mm					n_{max}
			dm_m	D_{5t}	l_2	l_{21}	l_{22}	
Čelik								
E10	1	E10-A16-SS-065	16	9.6	65	5	7	40000
	1	-A10-SS-075	10	9.6	75	20	21	40000
	3	-A16-CS-140	16	9.6	140	36.5	-	16000
	2	-A16-CS-160	16	9.6	160	50	52	12000
	3	-A32-CS-250	32	9.6	250	63.5	-	10000
E12	1	E12-A16-SS-065	16	11.6	65	5	7	40000
	1	-A12-SS-100	12	11.6	100	22	23	31000
	3	-A16-CS-140	16	11.6	140	25.1	-	16000
	2	-A16-CS-170	16	11.6	170	60	62	12000
	3	-A32-CS-250	32	11.6	250	57.8	-	10000
E16	1	E16-A20-SS-070	20	15.4	70	5	7	40000
	1	-A20-SS-110	20	15.4	110	25	27	40000
	3	-A25-CS-170	25	15.4	170	54.8	-	18000
	2	-A20-CS-190	20	15.4	190	75	78	13000
E20	1	E20-A25-SS-080	25	19.2	80	5	7	40000
	1	-A20-SS-120	20	19.2	120	30	31	34000
	3	-A32-CS-180	32	19.2	180	73.1	-	20000
E25	1	E25-A32-SS-080	32	24.1	80	5	7	40000
	1	-A25-SS-140	25	24.1	140	40	41	25000
	3	-A32-CS-200	32	24.1	200	45.1	-	15000
Tvrđi metal								
E10	1	E10-A10-SE-100	10	9.6	100	50	51	35000
	2	-A16-CE-155	16	9.6	155	100	103	22000
E12	1	E12-A12-SE-100	12	11.6	100	48	49	40000
	2	-A16-CE-150	16	11.6	150	90	92	23000
E16	1	E16-A16-SE-135	16	15.4	135	80	81	27000
	2	-A20-CE-175	20	15.4	175	118	120	22000
E20	1	E20-A20-SE-095	20	19.2	95	38	39	40000
	1	-A20-SE-180	20	19.2	180	110	111	20000
E25	1	E25-A25-SE-200	25	24.1	200	120	121	19000

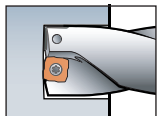


GC1030	ISO/ANSI	CMC	Brzina rezanja m/min	D_c mm	Pomak po zubu mm
			v_c		f_z
Gruba obrada $a_e \leq 1.0 \times D_c$ $a_p \leq 0.5 \times D_c$ 	P	02.1	165	10 12 16 20 25	0.045 0.055 0.065 0.080 0.100
	M	05.21	55		
	K	08.2	110		
	S	23.22	40		
	P	02.1	245		
Završna obrada $a_e \leq 0.3 \times D_c$ $a_p \leq 0.5 \times D_c$ 	M	05.21	85	10 12 16 20 25	0.070 0.085 0.110 0.130 0.160
	K	08.2	160		
	S	23.22	80		
	P	02.1	555		
	M	05.21	190		
Profilisanje $a_e < 0.005 \times D_c$ 	K	08.2	360	10 12 16 20 25	0.120 0.140 0.160 0.180 0.200
	S	23.22	150		
	P	02.1	555		
	M	05.21	190		
	K	08.2	360		
Obrada velikim pomakom *316-**H**50-****P 				10 12 16 20 25	0.250 0.300 0.400 0.500 0.600

Režimi obrade

Koristiti PluraGuide za izbor alata i režima obrade. Kataloški broj C-2948-117



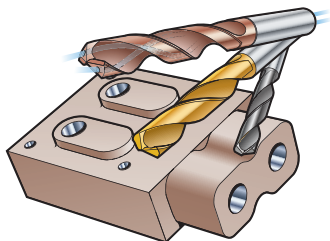


Bušenje

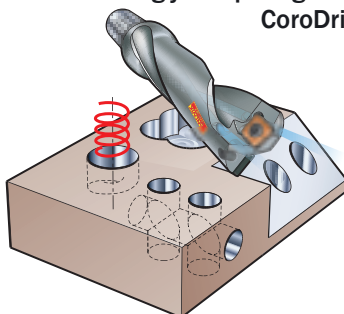
CoroDrill® Delta C i CoroDrill® 880



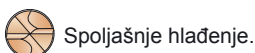
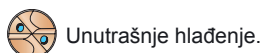
Burgija sa izmenljivim pločicama CoroDrill® Delta C



Burgija od punog tvrdog metala CoroDrill® 880



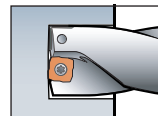
Tipovi burgija	Kvaliteti	Materijal	Svestranost	Maks.dubina Toler. otvora Kvalitet površine	Strana
CoroDrill® Delta C R840, Ø 3 – 20 mm 	 GC1220			$3-7 \times D_C$ IT8-10 R_a 1-2 μm	182-186
CoroDrill® Delta C R842, Ø 3.0 – 20 mm 	 GC1210			$3-5 \times D_C$ IT8-9 R_a 1-2 μm	187-188
CoroDrill® Delta C R846, Ø 3.0 – 12 mm 	 GC1220			$3-5 \times D_C$ IT8-9 R_a 1-2 μm	189
CoroDrill® Delta C R850, Ø 5.0 – 14 mm 	 N20D			$3-7 \times D_C$ IT9-10 R_a 1-2 μm	190-191
CoroDrill® 880 Ø 12 – 63.00 mm 	GC4014 GC4024 GC4034 GC4044 H13A GC2044 GC1044 H13A GC1144			$2-5 \times D_C$ IT 12-13 R_a 0.5 – 4 μm	194-201



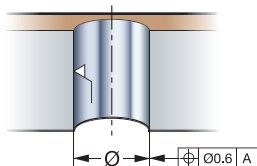


Kako koristiti vodič za bušenje

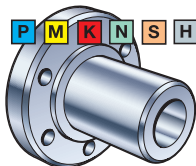
Izbor alata



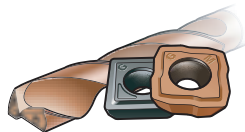
1. Definiši prečnik rupe, dubinu i zahteve kvaliteta



2. Definiši materijal radnog komada i njegove uslove obrade.



4. Izaberi kvalitet i geometriju burgije.



3. Izaberi tip burgije.

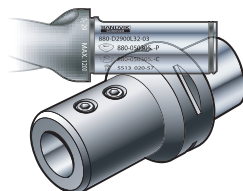
CoroDrill Delta C Ø 3-20 mm IT 8-10
CoroDrill 880 Ø 12-63 mm IT 12-13



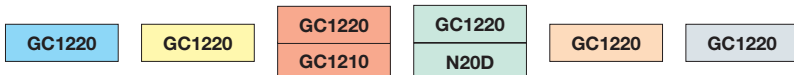
CoroDrill Delta C za uske tolerancije i dobar kvalitet obrađene površine

CoroDrill 880 za visoku produktivnost i najbolju proizvodnu ekonomičnost.

5. Izbor tipa nosača.



Kvaliteti za burgije CoroDrill Delta C



Kvaliteti za bušenje

Otpornost na habanje

Stabilno



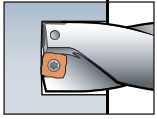
GC4014	GC4024	H13A		H13A	GC4024
GC4024	GC4034	GC4014	H13A	GC1044	GC1044
GC4034	GC1044	GC4024	GC1044	GC4044	GC4044
GC1044	GC4044	GC4034	GC4044	GC1144	
GC4044	GC1144	GC1044		GC2044	
	GC2044	GC4044			



Uslovi

Žilavost

Nestabilno



Bušenje

Preporuke za uspešno bušenje

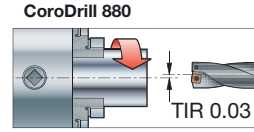
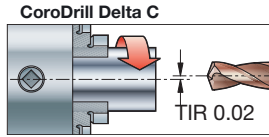


Polje primene burgija

Da bi potpuno iskoristili prednosti Sandvik Coromant burgija pri bušenju visokim brzinama, obezbedite maksimalnu stabilnost i sigurno stezanje u celom sistemu, od vretena, preko alata do obratka. Vibracije imaju negativan uticaj na sigurnost procesa, vek alata i kvalitet otvora.

Ukupno bacanje alata (TIR)

Minimalno bacanje je najvažnije kod bušenja. Jedan od glavnih kriterijuma kod bušenja je najmanje moguće bacanje. Loše centriranje je najčešći uzrok loših rezultata. Maksimalno bacanje (TIR) ne bi trebalo da pređe 0.02 / 0.03 mm ukupno za burgiju i stezne čeljusti.



Dovod SHP

Da bi ste potpuno iskoristili prednosti velikih brzina i posmaka Sandvik Coromant burgija, mora postojati efikasno odvođenje strugotine - ovo se jedino može uraditi pomoću SHP. Rashladna tečnost može biti dopremana kroz alat ili spolja. CoroDrill Delta C burgije su dostupne sa spoljašnjim i unutrašnjim hlađenjem, a burgije 880 sa unutrašnjim dovodom.

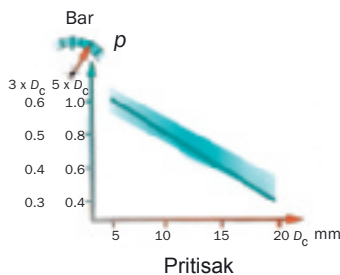
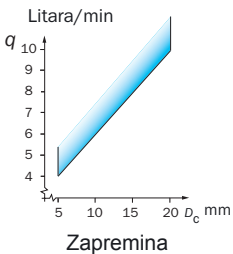
Unutrašnje hlađenje

Količine rashladne tečnosti zavise od prečnika burgije kao i pritisak. Manje burgije zahtevaju veći pritisak jer je dovod tečnosti manji.

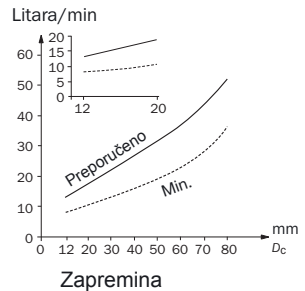
Dijagrami pored daju grube vrednosti. Protok rashladnog sredstva treba da bude odgovarajući prečniku burgije u l/min.

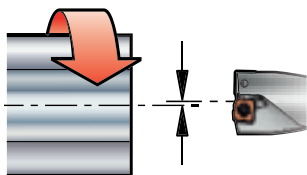
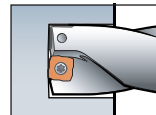
Boja strugotine nikada ne treba da bude plava ili braon.

CoroDrill® Delta C



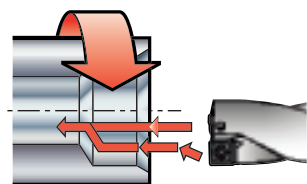
CoroDrill® 880





CoroDrill 880 kao stacionarna burgija

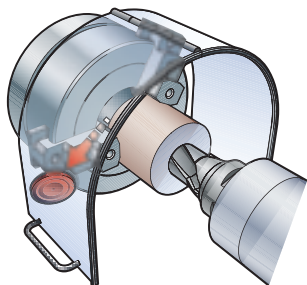
Ako koristite burgiju statično, kao na strugu, centar burgije mora biti saosan sa vretenom.



CoroDrill 880 - mogućnosti stacionarne burgije

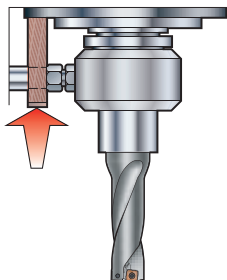
Pri korišćenju ovih burgija, rupa za navoj može biti pripremljena u jednom prolazu zajedno sa obaranjem ivice.

Rupe veće od prečnika burgije mogu se napraviti sa CoroDrill 880.



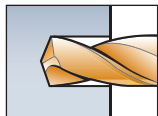
Sigurnosne mere

Pri bušenju prolaznih otvora na rotirajućim komadima sa burgijom sa izmenljivim pločicama, biće napravljen disk na izlazu burgije. Disk je često izbačen velikom brzinom i može izazvati povredu. Zato se preporučuje da se oko stezne glave montira adekvatna zaštita.



Blokada rotacije

Ako SHP sadrži deliće strugotine oni se mogu zaglaviti u steznoj čauri i kao rezultat kućište će se rotirati. Dovodno crevo će biti namotano oko kućišta što može da prouzrokuje ozbiljan incident. Rotacija mora stoga biti onemogućena.



CoroDrill® Delta C

Burgije od tvrdog metala za pitke rupe visokog kvaliteta



Prvi izbor
Prvi izbor - bušenje **sa unutrašnjim** hlađenjem

Unutrašnje hlađenje

Da bi ste iskoristili pune mogućnosti CoroDrill Delta - C burgije, koristite unutrašnje hlađenje, kruto i sigurno stezanje i kvalitetan prenos momenta što su faktori za dobru postojanost i proizvodnost.

Dopunski program bušenja **sa spoljašnjim** hlađenjem

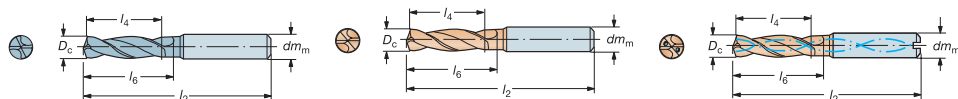
Spoljašnje hlađenje

Iste mere predostrožnosti moraju biti izvedene kada bušimo sa spoljašnjim hlađenjem.

Oblasti primene i kvaliteti

ISO/ANSI	D_c^*	Prečnici burgija / Kvaliteti			
		Prvi izbor		Generalni izbor	
Čelik	P	3-20	R840- GC1220	R840- GC1220	R840- GC1220
Nerđajući čelik	M	3-16 (20)	R846- GC1220	R840- GC1220	R840- GC1220
Sivi liv	K	3-20	R842- GC1210	R840- GC1210	R840- GC1220
Neferitni materijali	N	3-14 (20)	R850- N20D	R840- GC1220	R840- GC1220
Legure Titanijuma	S	3-16 (20)	R846- GC1220	R840- GC1220	R840- GC1220
Kaljani materijali	H	3-20	R840- GC1220	R840- GC1220	R840- GC1220

Tehnički crteži i informacije za poručivanje.



Primer : R840-0300-x0-AyA

Kada poručujete, zamenite x u kodu sa :

- 3 za 2-3 x D_c ,
- 5 za 4-5 x D_c ,
- 7 za 6-7 x D_c

Zameniti "y" u kodu sa :
0 za spoljašnje hlađenje,
1 za unutrašnje hlađenje

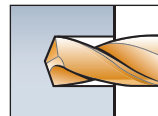
Primer kompletne oznake R840-0300-30-A1A 1220

CoroDrill® Delta C – R840

Prečnik burgije 3 – 20 mm

Maks. dubina rupe: 2-7 x prečnik burgije (D_c)

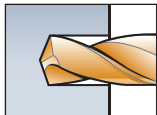
Cilindrična drška



D_c mm	d_m	Kataloška oznaka	GC1220		2 - 3 x D_c			4 - 5 x D_c			6 - 7 x D_c		
			0 ¹⁾	1 ²⁾	l_2	l_4	l_6	l_2	l_4	l_6	l_2	l_4	l_6
3.00	6.0	R840-0300-x0-AyA	☆	★	62	13	20	66	20	28	-	-	-
3.10	6.0	0310-x0-AyA	☆	★	62	13	20	66	20	28	-	-	-
3.17	6.0	0317-x0-AyA	-	★	62	13	20	66	20	28	-	-	-
3.20	6.0	0320-x0-AyA	☆	★	62	13	20	66	20	28	-	-	-
3.30	6.0	0330-x0-AyA	☆	★	62	13	20	66	20	28	-	-	-
3.38	6.0	0338-x0-AyA	☆	-	-	-	-	66	20	28	-	-	-
3.40	6.0	0340-x0-AyA	☆	★	62	13	20	66	20	28	-	-	-
3.45	6.0	0345-x0-AyA	-	★	62	14	20	66	20	28	-	-	-
3.50	6.0	0350-x0-AyA	☆	★	62	14	20	66	20	28	-	-	-
3.55	6.0	0355-x0-AyA	-	★	62	14	20	66	20	28	-	-	-
3.57	6.0	0357-x0-AyA	-	★	62	14	20	66	20	28	-	-	-
3.60	6.0	R840-0360-x0-AyA	☆	★	62	14	20	66	20	28	-	-	-
3.70	6.0	0370-x0-AyA	☆	★	62	14	20	66	20	28	-	-	-
3.80	6.0	0380-x0-AyA	☆	★	62	14	20	66	20	28	-	-	-
3.90	6.0	0390-x0-AyA	☆	★	62	14	20	66	20	28	-	-	-
3.97	6.0	0397-x0-AyA	-	★	66	17	24	74	27	36	-	-	-
4.00	6.0	0400-x0-AyA	☆	★	66	17	24	74	27	36	-	-	-
4.10	6.0	0410-x0-AyA	☆	★	66	17	24	74	27	36	-	-	-
4.20	6.0	0420-x0-AyA	☆	★	66	17	24	74	27	36	-	-	-
4.30	6.0	0430-x0-AyA	☆	★	66	17	24	74	27	36	-	-	-
4.36	6.0	0436-x0-AyA	-	★	66	17	24	74	27	36	-	-	-
4.40	6.0	R840-0440-x0-AyA	☆	★	66	17	24	74	27	36	-	-	-
4.50	6.0	0450-x0-AyA	☆	★	66	17	24	74	27	36	-	-	-
4.55	6.0	0455-x0-AyA	-	★	66	17	24	74	27	36	-	-	-
4.60	6.0	0460-x0-AyA	☆	★	66	17	24	74	27	36	-	-	-
4.70	6.0	0470-x0-AyA	☆	★	66	17	24	74	27	36	-	-	-
4.76	6.0	0476-x0-AyA	-	★	66	18	28	74	27	36	-	-	-
4.80	6.0	0480-x0-AyA	☆	★	66	18	28	74	27	36	-	-	-
4.90	6.0	0490-x0-AyA	☆	★	66	18	28	82	34	44	-	-	-
5.00	6.0	R840-0500-x0-AyA	☆	★	66	18	28	82	35	44	93	42	50
5.10	6.0	0510-x0-AyA	☆	★	66	18	28	82	35	44	93	42	50
5.16	6.0	0516-x0-AyA	-	★	66	18	28	82	35	44	93	42	50
5.20	6.0	0520-x0-AyA	☆	★	66	18	28	82	35	44	93	42	50
5.25	6.0	0525-x0-AyA	-	★	-	-	-	82	35	44	-	-	-
5.30	6.0	0530-x0-AyA	☆	★	66	18	28	82	35	44	93	42	50
5.40	6.0	0540-x0-AyA	☆	★	66	18	28	82	35	44	93	42	50
5.50	6.0	0550-x0-AyA	☆	★	66	19	28	82	35	44	93	42	50
5.55	6.0	0555-x0-AyA	-	★	-	-	-	82	35	44	-	-	-
5.56	6.0	0556-x0-AyA	-	★	66	19	28	82	35	44	93	42	50
5.60	6.0	R840-0560-x0-AyA	☆	★	66	19	28	82	35	44	93	42	50
5.70	6.0	0570-x0-AyA	☆	★	66	19	28	82	35	44	93	42	50
5.80	6.0	0580-x0-AyA	☆	★	66	19	28	82	35	44	93	42	50
5.90	6.0	0590-x0-AyA	☆	★	66	19	28	82	35	44	93	42	50
5.95	6.0	0595-x0-AyA	-	★	66	19	28	82	35	44	93	42	50
6.00	6.0	0600-x0-AyA	☆	★	66	19	28	82	35	44	93	49	50
6.10	8.0	0610-x0-AyA	☆	★	79	22	34	91	39	53	105	49	59
6.20	8.0	0620-x0-AyA	☆	★	79	22	34	91	39	53	105	49	59
6.30	8.0	0630-x0-AyA	☆	★	79	22	34	91	39	53	105	49	59
6.35	8.0	0635-x0-AyA	-	★	79	22	34	91	39	53	105	49	59

1) Spoljašnje hlađenje.

2) Unutrašnje hlađenje.



CoroDrill® Delta C – R840

Prečnik burgije 3 – 20 mm

Maks. dubina rupe: 2-7 x prečnik burgije (D_c)

Cilindrična drška



D_c mm	d_{m1}	Kataloška oznaka	GC1220 0 ¹⁾ 1 ²⁾		2 - 3 x D_c			4 - 5 x D_c			6 - 7 x D_c		
			☆	★	l_2	l_4	l_6	l_2	l_4	l_6	l_2	l_4	l_6
6.40	8.0	R840-0640-x0-AyA	☆	★	79	22	34	91	39	53	105	49	59
6.50	8.0	0650-x0-AyA	☆	★	79	22	34	91	39	53	105	49	59
6.60	8.0	0660-x0-AyA	☆	★	79	22	34	91	39	53	105	49	59
6.70	8.0	0670-x0-AyA	☆	★	79	22	34	91	39	53	105	49	59
6.75	8.0	0675-x0-AyA	—	★	79	22	34	91	39	53	105	49	59
6.80	8.0	0680-x0-AyA	☆	★	79	22	34	91	39	53	105	49	59
6.90	8.0	0690-x0-AyA	☆	★	79	22	34	91	39	53	105	49	59
7.00	8.0	0700-x0-AyA	☆	★	79	22	34	91	40	53	105	49	59
7.10	8.0	0710-x0-AyA	☆	★	79	28	41	91	40	53	105	56	67
7.14	8.0	0714-x0-AyA	—	★	79	28	41	91	40	53	105	56	67
7.20	8.0	R840-0720-x0-AyA	☆	★	79	28	41	91	40	53	105	56	67
7.30	8.0	0730-x0-AyA	☆	★	79	28	41	91	40	53	105	56	67
7.40	8.0	0740-x0-AyA	☆	★	79	28	41	91	40	53	105	56	67
7.50	8.0	0750-x0-AyA	☆	★	79	28	41	91	40	53	105	56	67
7.54	8.0	0754-x0-AyA	—	★	79	28	41	91	40	53	105	56	67
7.60	8.0	0760-x0-AyA	☆	★	79	28	41	91	40	53	105	56	67
7.70	8.0	0770-x0-AyA	☆	★	79	28	41	91	40	53	105	56	67
7.80	8.0	0780-x0-AyA	☆	★	79	28	41	91	40	53	105	56	67
7.90	8.0	0790-x0-AyA	☆	★	79	28	41	91	40	53	105	56	67
7.94	8.0	0794-x0-AyA	—	★	79	28	41	91	40	53	105	56	67
8.00	8.0	R840-0800-x0-AyA	☆	★	79	28	41	91	40	53	105	56	67
8.10	10.0	0810-x0-AyA	☆	★	89	30	47	103	44	61	120	62	75
8.15	10.0	0815-x0-AyA	—	★	—	—	—	103	44	61	—	—	—
8.20	10.0	0820-x0-AyA	☆	★	89	30	47	103	44	61	120	62	75
8.30	10.0	0830-x0-AyA	☆	★	89	30	47	103	44	61	120	62	75
8.33	10.0	0833-x0-AyA	—	★	89	30	47	103	44	61	120	62	75
8.40	10.0	0840-x0-AyA	☆	★	89	30	47	103	44	61	120	62	75
8.50	10.0	0850-x0-AyA	☆	★	89	30	47	103	44	61	120	62	75
8.60	10.0	0860-x0-AyA	☆	★	89	30	47	103	44	61	120	62	75
8.70	10.0	0870-x0-AyA	☆	★	89	30	47	103	44	61	120	62	75
8.73	10.0	R840-0873-x0-AyA	—	★	89	30	47	103	44	61	120	62	75
8.80	10.0	0880-x0-AyA	☆	★	89	30	47	103	44	61	120	62	75
8.90	10.0	0890-x0-AyA	☆	★	89	30	47	103	45	61	120	62	75
9.00	10.0	0900-x0-AyA	☆	★	89	31	47	103	45	61	133	70	84
9.10	10.0	0910-x0-AyA	☆	★	89	31	47	103	45	61	133	70	84
9.13	10.0	0913-x0-AyA	—	★	89	31	47	103	45	61	133	70	84
9.20	10.0	0920-x0-AyA	☆	★	89	31	47	103	45	61	133	70	84
9.30	10.0	0930-x0-AyA	☆	★	89	31	47	103	45	61	133	70	84
9.40	10.0	0940-x0-AyA	☆	★	89	31	47	103	45	61	133	70	84
9.50	10.0	0950-x0-AyA	☆	★	89	31	47	103	45	61	133	70	84
9.52	10.0	R840-0952-x0-AyA	—	★	89	31	47	103	45	61	133	70	84
9.60	10.0	0960-x0-AyA	☆	★	89	31	47	103	45	61	133	70	84
9.70	10.0	0970-x0-AyA	☆	★	89	31	47	103	45	61	133	70	84
9.80	10.0	0980-x0-AyA	☆	★	89	31	47	103	45	61	133	70	84
9.90	10.0	0990-x0-AyA	☆	★	89	31	47	103	45	61	133	70	84
9.92	10.0	0992-x0-AyA	—	★	89	31	47	103	45	61	133	70	84
10.00	12.0	1000-x0-AyA	☆	★	89	31	47	103	45	61	133	76	84
10.10	12.0	1010-x0-AyA	☆	★	102	34	55	118	50	71	140	76	91
10.20	12.0	1020-x0-AyA	☆	★	102	34	55	118	50	71	140	76	91

¹⁾ Spoljašnje hlađenje.

²⁾ Unutrašnje hlađenje.

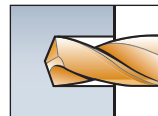


CoroDrill® Delta C – R840

Prečnik burgije 3 – 20 mm

Maks. dubina rupe: 2-7 x prečnik burgije (D_c)

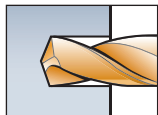
Cilindrična drška



D_c mm	dm_m	Kataloška oznaka	GC1220		2 - 3 x D_c			4 - 5 x D_c			6 - 7 x D_c		
			0 ¹⁾	1 ²⁾	l_2	l_4	l_6	l_2	l_4	l_6	l_2	l_4	l_6
10.30	12.0	R840-1030-x0-AyA	☆	★	102	34	55	118	50	71	140	76	91
10.32	12.0	1032-x0-AyA	—	★	102	34	55	118	50	71	140	76	91
10.40	12.0	1040-x0-AyA	☆	★	102	34	55	118	50	71	140	76	91
10.50	12.0	1050-x0-AyA	☆	★	102	34	55	118	50	71	140	76	91
10.60	12.0	1060-x0-AyA	☆	★	102	34	55	118	50	71	140	76	91
10.70	12.0	1070-x0-AyA	☆	★	102	34	55	118	50	71	140	76	91
10.71	12.0	1071-x0-AyA	—	★	102	34	55	118	50	71	140	76	91
10.80	12.0	1080-x0-AyA	☆	★	102	34	55	118	50	71	140	76	91
10.90	12.0	1090-x0-AyA	☆	★	102	34	55	118	50	71	140	76	91
11.00	12.0	1100-x0-AyA	☆	★	102	35	55	118	51	71	151	84	101
11.10	12.0	R840-1110-x0-AyA	☆	★	102	35	55	118	51	71	152	84	101
11.11	12.0	1111-x0-AyA	☆	★	102	35	55	118	51	71	151	84	101
11.20	12.0	1120-x0-AyA	☆	★	102	35	55	118	51	71	151	84	101
11.30	12.0	1130-x0-AyA	☆	★	102	35	55	118	51	71	151	84	101
11.40	12.0	1140-x0-AyA	☆	★	102	35	55	118	51	71	151	84	101
11.50	12.0	1150-x0-AyA	☆	★	102	35	55	118	51	71	151	84	101
11.51	12.0	1151-x0-AyA	—	★	102	35	55	118	51	71	151	84	101
11.60	12.0	1160-x0-AyA	☆	★	102	35	55	118	51	71	151	84	101
11.70	12.0	1170-x0-AyA	☆	★	102	35	55	118	51	71	151	84	101
11.80	12.0	1180-x0-AyA	☆	★	102	35	55	118	51	71	151	84	101
11.90	12.0	R840-1190-x0-AyA	☆	★	102	35	55	118	51	71	151	84	101
12.00	12.0	1200-x0-AyA	☆	★	102	35	55	118	51	71	151	84	101
12.10	14.0	1210-x0-AyA	☆	★	107	38	60	124	55	77	160	89	107
12.20	14.0	1220-x0-AyA	—	★	107	38	60	124	55	77	160	89	107
12.30	14.0	1230-x0-AyA	☆	★	107	38	60	124	55	77	160	89	107
12.40	14.0	1240-x0-AyA	☆	★	107	38	60	124	55	77	160	89	107
12.50	14.0	1250-x0-AyA	—	★	107	38	60	124	55	77	160	89	107
12.60	14.0	1260-x0-AyA	☆	★	107	38	60	124	55	77	160	89	107
12.70	14.0	1270-x0-AyA	☆	★	107	38	60	124	55	77	160	89	107
12.80	14.0	1280-x0-AyA	☆	★	107	38	60	124	55	77	160	89	107
13.00	14.0	R840-1300-x0-AyA	☆	★	107	39	60	124	56	77	160	89	107
13.10	14.0	1310-x0-AyA	—	★	107	39	60	124	56	77	160	89	107
13.25	14.0	1325-x0-AyA	☆	★	107	39	60	124	56	77	160	89	107
13.50	14.0	1350-x0-AyA	☆	★	107	39	60	124	56	77	160	89	107
13.75	14.0	1375-x0-AyA	☆	★	107	39	60	124	56	77	160	89	107
13.80	14.0	1380-x0-AyA	☆	★	107	39	60	124	56	77	160	89	107
13.89	14.0	1389-x0-AyA	—	★	107	39	60	124	56	77	160	89	107
14.00	14.0	1400-x0-AyA	☆	★	107	39	60	124	56	77	160	89	107
14.25	16.0	1425-x0-AyA	☆	★	115	41	65	133	59	83	—	—	—
14.29	16.0	1429-x0-AyA	—	★	115	41	65	133	59	83	—	—	—
14.50	16.0	R840 1450-x0-AyA	☆	★	115	41	65	133	59	83	—	—	—
14.69	16.0	1469-x0-AyA	—	★	115	41	65	133	59	83	—	—	—
14.75	16.0	1475-x0-AyA	☆	★	115	41	65	133	59	83	—	—	—
14.80	16.0	1480-x0-AyA	☆	★	115	41	65	133	59	83	—	—	—
15.00	16.0	1500-x0-AyA	☆	★	115	42	65	133	60	83	—	—	—
15.50	16.0	1550-x0-AyA	☆	★	115	42	65	133	60	83	—	—	—
15.80	16.0	1580-x0-AyA	☆	★	115	42	65	133	60	83	—	—	—
15.87	16.0	1587-x0-AyA	—	★	115	42	65	133	60	83	—	—	—
16.00	16.0	1600-x0-AyA	☆	★	115	42	65	133	60	83	178	105	128

1) Spoljašnje hlađenje.

2) Unutrašnje hlađenje.



CoroDrill® Delta C – R840

Prečnik burgije 3 – 20 mm

Maks. dubina rupe: 2-7 x prečnik burgije (D_c)

Cilindrična drška

ISO/ANSI



D_c mm	$d_{m,m}$	Kataloška oznaka	GC1220		2 - 3 x D_c			4 - 5 x D_c			6 - 7 x D_c		
			0 ¹⁾	1 ²⁾	l_2	l_4	l_6	l_2	l_4	l_6	l_2	l_4	l_6
16.08	18.0	R840-1608-x0-AyA	–	★	123	46	73	133	66	93	–	–	–
16.10	18.0	1610-x0-AyA	☆	★	123	46	73	143	66	93	–	–	–
16.30	18.0	1630-x0-AyA	–	★	–	–	–	–	–	–	187	114	137
16.50	18.0	1650-x0-AyA	☆	★	123	46	73	143	66	93	–	–	–
16.80	18.0	1680-x0-AyA	☆	★	123	46	73	143	66	93	–	–	–
17.00	18.0	1700-x0-AyA	☆	★	123	47	73	143	67	93	–	–	–
17.46	18.0	1746-x0-AyA	–	★	123	47	73	143	67	93	–	–	–
17.50	18.0	1750-x0-AyA	☆	★	123	47	73	143	67	93	–	–	–
17.80	18.0	1780-x0-AyA	☆	★	123	47	73	143	67	93	–	–	–
18.00	18.0	R840-1800-x0-AyA	☆	★	123	47	73	143	67	93	–	–	–
18.50	20.0	1850-x0-AyA	☆	★	131	49	79	153	71	101	–	–	–
18.80	20.0	1880-x0-AyA	☆	★	131	49	79	153	71	101	–	–	–
19.00	20.0	1900-x0-AyA	☆	★	131	50	79	153	72	101	–	–	–
19.05	20.0	1905-x0-AyA	–	★	131	50	79	153	72	101	–	–	–
19.25	20.0	1925-x0-AyA	–	★	131	50	79	153	72	101	–	–	–
19.30	20.0	1930-x0-AyA	–	★	131	50	79	153	72	101	–	–	–
19.50	20.0	1950-x0-AyA	☆	★	131	50	79	153	72	101	–	–	–
19.80	20.0	1980-x0-AyA	☆	★	131	50	79	153	72	101	–	–	–
20.00	20.0	2000-x0-AyA	☆	★	131	50	79	153	72	101	–	–	–

¹⁾ Spoljašnje hlađenje.

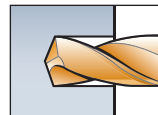
²⁾ Unutrašnje hlađenje.

CoroDrill® Delta C – R842

Prečnik burgije 3 – 16 mm

Maks. dubina rupe: 2-5 x prečnik burgije (D_c)

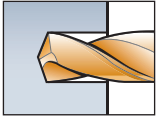
Cilindrična drška



D_c mm	d_{m_1}	Kataloška oznaka	GC1210		2 - 3 x D_c			4 - 5 x D_c		
			0 ¹⁾	1 ²⁾	l_2	l_4	l_6	l_2	l_4	l_6
3.00	6.0	R842-0300-x0-A0A	☆		62	13	20	66	20	28
3.20	6.0	0320-x0-A0A	☆		62	13	20	66	20	28
3.30	6.0	0330-x0-A0A	☆		62	13	20	66	20	28
3.38	6.0	0338-x0-A0A	☆		62	13	20	66	20	28
3.50	6.0	0350-x0-A0A	☆		62	14	20	66	20	28
4.00	6.0	0400-x0-A0A	☆		66	17	24	74	27	36
4.10	6.0	0410-x0-A0A	☆		66	17	24	74	27	36
4.20	6.0	0420-x0-A0A	☆		66	17	24	74	27	36
4.30	6.0	0430-x0-A0A	☆		66	17	24	74	27	36
4.50	6.0	0450-x0-A0A	☆		66	17	24	74	27	36
4.80	6.0	0480-x0-A0A	☆		66	18	28	74	27	36
5.00	6.0	R842-0500-x0-A0A	☆		66	18	28	82	35	44
5.10	6.0	0510-x0-A0A	☆		66	18	28	82	35	44
5.20	6.0	0520-x0-A0A	☆		66	18	28	82	35	44
5.30	6.0	0530-x0-A0A	☆		66	18	28	82	35	44
5.50	6.0	0550-x0-A0A	☆		66	19	28	82	35	44
5.56	6.0	0556-x0-A0A	☆		66	19	28	82	35	44
6.00	6.0	0600-x0-A0A	☆		66	19	28	82	35	44
6.10	8.0	R842-0610-x0-A1A		☆	-	-	-	91	39	53
6.20	8.0	0620-x0-A1A		☆	-	-	-	91	39	53
6.30	8.0	0630-x0-A1A		☆	79	22	34	91	39	53
6.35	8.0	0635-x0-A1A		☆	-	-	-	91	39	53
6.50	8.0	0650-x0-A1A		☆	79	22	34	91	39	53
6.60	8.0	0660-x0-A1A		☆	-	-	-	91	39	53
6.70	8.0	0670-x0-A1A		☆	79	22	34	91	39	53
6.80	8.0	0680-x0-A1A		☆	79	22	34	91	39	53
6.90	8.0	0690-x0-A1A		☆	79	22	34	91	40	53
7.00	8.0	R842-0700-x0-A1A		☆	79	22	34	91	40	53
7.10	8.0	0710-x0-A1A		☆	-	-	-	91	40	53
7.14	8.0	0714-x0-A1A		☆	-	-	-	91	40	53
7.40	8.0	0740-x0-A1A		☆	-	-	-	91	40	53
7.50	8.0	0750-x0-A1A		☆	79	28	41	91	40	53
7.80	8.0	0780-x0-A1A		☆	-	-	-	91	40	53
7.94	8.0	0794-x0-A1A		☆	79	28	41	91	44	53
8.00	8.0	R842-0800-x0-A1A		☆	79	28	41	91	44	53
8.10	10.0	0810-x0-A1A		☆	-	-	-	103	44	61
8.20	10.0	0820-x0-A1A		☆	89	30	47	103	44	61
8.30	10.0	0830-x0-A1A		☆	89	30	47	103	44	61
8.40	10.0	0840-x0-A1A		☆	89	30	47	103	44	61
8.50	10.0	0850-x0-A1A		☆	89	30	47	103	44	61
8.60	10.0	0860-x0-A1A		☆	89	30	47	103	44	61
8.70	10.0	0870-x0-A1A		☆	89	30	47	103	44	61
8.80	10.0	0880-x0-A1A		☆	-	-	-	103	45	61
8.90	10.0	0890-x0-A1A		☆	89	30	47	103	45	61
9.00	10.0	R842-0900-x0-A1A		☆	89	31	47	103	45	61
9.10	10.0	0910-x0-A1A		☆	-	-	-	103	45	61
9.30	10.0	0930-x0-A1A		☆	-	-	-	103	45	61
9.40	10.0	0940-x0-A1A		☆	-	-	-	103	45	61
9.50	10.0	0950-x0-A1A		☆	89	31	47	103	45	61
9.52	10.0	0952-x0-A1A		☆	-	-	-	103	45	61
9.60	10.0	0960-x0-A1A		☆	-	-	-	103	45	61
9.80	10.0	0980-x0-A1A		☆	89	31	47	103	45	61

1) Spoljašnje hlađenje.

2) Unutrašnje hlađenje.



CoroDrill® Delta C – R842

Prečnik burgije 3 – 16 mm

Maks. dubina rupe: 2-5 x prečnik burgije (D_c)

Cilindrična drška

D_c mm	$d_{m_{in}}$	Kataloška oznaka	GC1210		2 - 3 x D_c			4 - 5 x D_c		
			0 ¹⁾	1 ²⁾	l_2	l_4	l_6	l_2	l_4	l_6
10.00	10.0	R842-1000-x0-A1A		☆	89	31	47	103	45	61
10.10	12.0	1010-x0-A1A		☆	102	34	55	118	50	71
10.20	12.0	1020-x0-A1A		☆	102	34	55	118	50	71
10.30	12.0	1030-x0-A1A		☆	102	34	55	118	50	71
10.40	12.0	1040-x0-A1A		☆	102	34	55	118	50	71
10.50	12.0	1050-x0-A1A		☆	102	34	55	118	50	71
10.60	12.0	1060-x0-A1A		☆	–	–	–	118	50	71
10.70	12.0	1070-x0-A1A		☆	102	34	55	118	50	71
10.80	12.0	1080-x0-A1A		☆	102	34	55	118	50	71
11.00	12.0	R842-1100-x0-A1A		☆	102	35	55	118	51	71
11.10	12.0	1110-x0-A1A		☆	–	–	–	118	51	71
11.20	12.0	1120-x0-A1A		☆	–	–	–	118	51	71
11.50	12.0	1150-x0-A1A		☆	102	35	55	118	51	71
11.70	12.0	1170-x0-A1A		☆	–	–	–	118	51	71
11.80	12.0	1180-x0-A1A		☆	–	–	–	118	51	71
12.00	12.0	R842-1200-x0-A1A		☆	102	35	55	118	51	71
12.10	14.0	1210-x0-A1A		☆	107	38	60	124	55	77
12.20	14.0	1220-x0-A1A		☆	107	38	60	124	55	77
12.30	14.0	1230-x0-A1A		☆	107	38	60	124	55	77
12.50	14.0	1250-x0-A1A		☆	107	38	60	124	55	77
12.70	14.0	1270-x0-A1A		☆	107	38	60	124	55	77
13.00	14.0	1300-x0-A1A		☆	107	39	60	124	56	77
13.10	14.0	1310-x0-A1A		☆	107	39	60	124	56	77
13.25	14.0	1325-x0-A1A		☆	–	–	–	124	56	77
13.50	14.0	1350-x0-A1A		☆	107	39	60	124	56	77
14.00	14.0	R842-1400-x0-A1A		☆	107	39	60	124	56	77
14.10	16.0	1410-x0-A1A		☆	115	41	65	133	59	83
14.25	16.0	1425-x0-A1A		☆	–	–	–	133	59	83
14.29	16.0	1429-x0-A1A		☆	–	–	–	133	59	83
14.50	16.0	1450-x0-A1A		☆	115	41	65	133	59	83
15.00	16.0	1500-x0-A1A		☆	115	42	65	133	60	83
15.50	16.0	1550-x0-A1A		☆	115	42	65	133	60	83
15.87	16.0	1587-x0-A1A		☆	115	42	65	133	60	83
16.00	16.0	1600-x0-A1A		☆	115	42	65	133	60	83

¹⁾ Spoljašnje hlađenje.

²⁾ Unutrašnje hlađenje.

ISO/ANSI

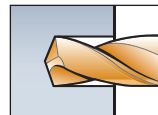


CoroDrill® Delta C – R846

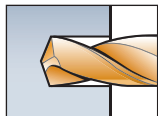
Prečnik burgije 3 – 12 mm

Maks. dubina rupe: 2-5 x prečnik burgije (D_c)

Cilindrična drška



D_c mm	$d_{m,m}$	Kataloška oznaka	GC1220	2 - 3 x D_c			4 - 5 x D_c		
				l_2	l_4	l_6	l_2	l_4	l_6
3.00	6.0	R846-0300-x0-A1A	☆	62	13	20	66	20	28
4.00	6.0	0400-x0-A1A	☆	66	17	24	74	27	36
4.30	6.0	0430-x0-A1A	☆	66	17	24	74	27	36
4.50	6.0	0450-x0-A1A	☆	66	17	24	74	27	36
4.80	6.0	0480-x0-A1A	☆	66	18	28	74	27	36
5.00	6.0	0500-x0-A1A	☆	66	18	28	82	35	44
5.10	6.0	0510-x0-A1A	☆	66	18	28	-	-	-
5.50	6.0	0550-x0-A1A	☆	66	19	28	-	-	-
5.55	6.0	0555-x0-A1A	☆	66	19	28	-	-	-
5.60	6.0	0560-x0-A1A	☆	66	19	28	-	-	-
5.80	6.0	0580-x0-A1A	☆	66	19	28	82	35	44
6.00	6.0	R846-0600-x0-A1A	☆	66	19	28	82	35	44
6.50	8.0	0650-x0-A1A	☆	79	22	34	-	-	-
6.60	8.0	0660-x0-A1A	☆	79	22	34	-	-	-
6.70	8.0	0670-x0-A1A	☆	79	22	34	-	-	-
6.80	8.0	0680-x0-A1A	☆	-	-	-	91	39	53
6.90	8.0	0690-x0-A1A	☆	79	22	34	-	-	-
7.00	8.0	0700-x0-A1A	☆	79	22	34	91	40	53
7.10	8.0	0710-x0-A1A	☆	79	28	41	-	-	-
7.30	8.0	0730-x0-A1A	☆	79	28	41	-	-	-
7.40	8.0	0740-x0-A1A	☆	79	28	41	-	-	-
7.50	8.0	0750-x0-A1A	☆	79	28	41	-	-	-
8.00	8.0	R846-0800-x0-A1A	☆	79	28	41	91	40	53
8.10	10.0	0810-x0-A1A	☆	89	30	47	-	-	-
8.20	10.0	0820-x0-A1A	☆	89	30	47	-	-	-
8.50	10.0	0850-x0-A1A	☆	89	30	47	103	44	61
8.60	10.0	0860-x0-A1A	☆	89	30	47	-	-	-
8.70	10.0	0870-x0-A1A	☆	89	30	47	-	-	-
9.00	10.0	0900-x0-A1A	☆	89	31	47	103	45	61
9.30	10.0	0930-x0-A1A	☆	-	-	-	103	45	61
9.50	10.0	0950-x0-A1A	☆	89	31	47	-	-	-
9.60	10.0	0960-x0-A1A	☆	89	31	47	103	45	61
9.80	10.0	0980-x0-A1A	☆	-	-	-	103	45	61
10.00	10.0	1000-x0-A1A	☆	89	31	47	103	45	61
10.20	12.0	1020-x0-A1A	☆	102	34	55	118	50	71
10.50	12.0	1050-x0-A1A	☆	102	34	55	-	-	-
11.00	12.0	1100-x0-A1A	☆	102	35	55	118	51	71
12.00	12.0	1200-x0-A1A	☆	102	35	55	118	51	71



CoroDrill® Delta C – R850

Prečnik burgije 3 – 14 mm

Maks. dubina rupe: 2-3, 6-7 x prečnik burgije (D_c)

Cilindrična drška

ISO/ANSI



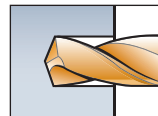
D_c mm	$d_{m,m}$	Kataloška oznaka	N20D	2 - 3 x D_c			6 - 7 x D_c		
				l_2	l_4	l_6	l_2	l_4	l_6
5.00	6.0	R850-0500-x0-A1A	☆	66	18	28	93	42	50
5.10	6.0	0510-x0-A1A	☆	66	18	28	93	42	50
5.16	6.0	0516-x0-A1A	☆	66	18	28	93	42	50
5.20	6.0	0520-x0-A1A	☆	66	18	28	93	42	50
5.30	6.0	0530-x0-A1A	☆	66	18	28	93	42	50
5.40	6.0	0540-x0-A1A	☆	66	18	28	93	42	50
5.50	6.0	0550-x0-A1A	☆	66	19	28	93	42	50
5.56	6.0	0556-x0-A1A	☆	66	19	28	93	42	50
5.60	6.0	0560-x0-A1A	☆	66	19	28	93	42	50
5.70	6.0	0570-x0-A1A	☆	66	19	28	93	42	50
5.80	6.0	0580-x0-A1A	☆	66	19	28	93	42	50
5.90	6.0	0590-x0-A1A	☆	66	19	28	93	42	50
5.95	6.0	0595-x0-A1A	☆	66	19	28	93	42	50
6.00	8.0	R850-0600-x0-A1A	☆	66	19	28	93	42	50
6.10	8.0	0610-x0-A1A	☆	79	22	34	105	49	59
6.20	8.0	0620-x0-A1A	☆	79	22	34	105	49	59
6.30	8.0	0630-x0-A1A	☆	79	22	34	105	49	59
6.35	8.0	0635-x0-A1A	☆	79	22	34	105	49	59
6.40	8.0	0640-x0-A1A	☆	79	22	34	105	49	59
6.50	8.0	0650-x0-A1A	☆	79	22	34	105	49	59
6.60	8.0	0660-x0-A1A	☆	79	22	34	105	49	59
6.70	8.0	0670-x0-A1A	☆	79	22	34	105	49	59
6.75	8.0	0675-x0-A1A	☆	79	22	34	105	49	59
6.80	8.0	0680-x0-A1A	☆	79	22	34	105	49	59
6.90	8.0	0690-x0-A1A	☆	79	22	34	105	49	59
7.00	8.0	R850-0700-x0-A1A	☆	79	22	34	105	49	59
7.10	8.0	0710-x0-A1A	☆	79	28	41	105	56	67
7.14	8.0	0714-x0-A1A	☆	79	28	41	105	56	67
7.20	8.0	0720-x0-A1A	☆	79	28	41	105	56	67
7.30	8.0	0730-x0-A1A	☆	79	28	41	105	56	67
7.40	8.0	0740-x0-A1A	☆	79	28	41	105	56	67
7.50	8.0	0750-x0-A1A	☆	79	28	41	105	56	67
7.60	8.0	0760-x0-A1A	☆	79	28	41	105	56	67
7.70	8.0	0770-x0-A1A	☆	79	28	41	-	-	-
7.80	8.0	0780-x0-A1A	☆	79	28	41	105	56	67
7.90	8.0	0790-x0-A1A	☆	79	28	41	105	56	67
7.94	8.0	0794-x0-A1A	☆	79	28	41	105	56	67
8.00	8.0	R850-0800-x0-A1A	☆	79	28	41	105	56	67
8.10	10.0	0810-x0-A1A	☆	89	30	47	120	62	75
8.20	10.0	0820-x0-A1A	☆	89	30	47	120	62	75
8.30	10.0	0830-x0-A1A	☆	89	30	47	120	62	75
8.33	10.0	0833-x0-A1A	☆	89	30	47	-	-	-
8.40	10.0	0840-x0-A1A	☆	89	30	47	120	62	75
8.50	10.0	0850-x0-A1A	☆	89	30	47	120	62	75
8.60	10.0	0860-x0-A1A	☆	89	30	47	120	62	75
8.70	10.0	0870-x0-A1A	☆	89	30	47	120	62	75
8.73	10.0	0873-x0-A1A	☆	89	30	47	120	62	75
8.80	10.0	0880-x0-A1A	☆	89	30	47	120	62	75
8.90	10.0	0890-x0-A1A	☆	-	-	-	120	62	75

CoroDrill® Delta C – R850

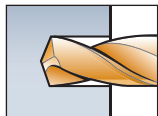
Prečnik burgije 3 – 14 mm

Maks. dubina rupe: 2-3, 6-7 x prečnik burgije (D_c)

Cilindrična drška



D_c mm	$d_{m,m}$	Kataloška oznaka	N20D	2 - 3 x D_c			6 - 7 x D_c		
				l_2	l_4	l_6	l_2	l_4	l_6
9.00	10.0	R850-0900-x0-A1A	☆	89	31	47	133	70	84
9.10	10.0	0910-x0-A1A	☆	89	31	47	133	70	84
9.13	10.0	0913-x0-A1A	☆	89	31	47	133	70	84
9.20	10.0	0920-x0-A1A	☆	89	31	47	133	70	84
9.30	10.0	0930-x0-A1A	☆	89	31	47	133	70	84
9.40	10.0	0940-x0-A1A	☆	89	31	47	133	70	84
9.50	10.0	0950-x0-A1A	☆	89	31	47	133	70	84
9.52	10.0	0952-x0-A1A	☆	89	31	47	133	70	84
9.60	10.0	0960-x0-A1A	☆	89	31	47	133	70	84
9.70	10.0	0970-x0-A1A	☆	89	31	47	133	70	84
9.80	10.0	0980-x0-A1A	☆	89	31	47	133	70	84
9.90	10.0	0990-x0-A1A	☆	89	31	47	133	70	84
9.92	10.0	0992-x0-A1A	☆	–	–	–	133	70	84
10.00	10.0	R850-1000-x0-A1A	☆	89	31	47	133	70	84
10.10	12.0	1010-x0-A1A	☆	102	34	55	140	76	91
10.20	12.0	1020-x0-A1A	☆	102	34	55	140	76	91
10.30	12.0	1030-x0-A1A	☆	102	34	55	140	76	91
10.32	12.0	1032-x0-A1A	☆	102	34	55	140	76	91
10.40	12.0	1040-x0-A1A	☆	102	34	55	140	76	91
10.45	12.0	1045-x0-A1A	☆	102	34	55	–	–	–
10.50	12.0	1050-x0-A1A	☆	102	34	55	140	76	91
10.60	12.0	1060-x0-A1A	☆	102	34	55	140	76	91
10.70	12.0	1070-x0-A1A	☆	102	34	55	140	76	91
10.71	12.0	1071-x0-A1A	☆	102	34	55	140	76	91
10.80	12.0	1080-x0-A1A	☆	–	–	–	140	76	91
10.90	12.0	1090-x0-A1A	☆	102	34	55	–	–	–
11.00	12.0	R850-1100-x0-A1A	☆	102	35	55	151	84	101
11.10	12.0	1110-x0-A1A	☆	102	35	55	151	84	101
11.11	12.0	1111-x0-A1A	☆	102	35	55	151	84	101
11.20	12.0	1120-x0-A1A	☆	102	35	55	151	84	101
11.50	12.0	1150-x0-A1A	☆	102	35	55	151	84	101
11.60	12.0	1160-x0-A1A	☆	102	35	55	151	84	101
11.70	12.0	1170-x0-A1A	☆	–	–	–	151	84	101
11.80	12.0	1180-x0-A1A	☆	102	35	55	151	84	101
11.90	12.0	1190-x0-A1A	☆	102	35	55	151	84	101
12.00	12.0	R850-1200-x0-A1A	☆	102	35	55	151	84	101
12.10	14.0	1210-x0-A1A	☆	107	38	60	160	89	107
12.20	14.0	1220-x0-A1A	☆	107	38	60	160	89	107
12.30	14.0	1230-x0-A1A	☆	107	38	60	160	89	107
12.40	14.0	1240-x0-A1A	☆	107	38	60	–	–	–
12.50	14.0	1250-x0-A1A	☆	107	38	60	160	89	107
12.60	14.0	1260-x0-A1A	☆	107	38	60	–	–	–
12.70	14.0	1270-x0-A1A	☆	107	38	60	160	89	107
12.80	14.0	1280-x0-A1A	☆	107	38	60	–	–	–
13.00	14.0	1300-x0-A1A	☆	107	39	60	160	89	107
13.10	14.0	1310-x0-A1A	☆	107	39	60	–	–	–
13.25	14.0	1325-x0-A1A	☆	107	39	60	160	89	107
13.50	14.0	1350-x0-A1A	☆	107	39	60	160	89	107
13.80	14.0	1380-x0-A1A	☆	107	39	60	–	–	–
14.00	14.0	1400-x0-A1A	☆	107	39	60	160	89	107



CoroDrill® Delta C

Režimi obrade (polazne vrednosti)

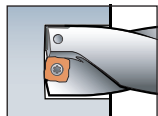
ISO/ANSI



ISO/ANSI	Materijal		HB	Prečnik burgije	Kvalitet	Brzina rezanja m/ min	Pomak mm/ob
	CMC			D_C mm		v_C	f_n
P	02.1	Niskolegirani čelik	180	3.00- 6.00	GC1220	70-120	0.10-0.20
				6.01-10.00			0.14-0.30
				10.01-14.00			0.18-0.35
				14.01-20.00			0.20-0.40
M	05.21	Nerđajući čelik	180	3.00- 6.00	GC1220	40-80	0.08-0.14
				6.01-10.00			0.08-0.20
				10.01-14.00			0.12-0.22
				14.01-20.00			0.14-0.24
K	08.2	Sivi liv	260	3.00- 6.00	GC1220	70-130	0.15-0.25
				6.01-10.00			0.20-0.35
				10.01-14.00			0.30-0.55
				14.01-20.00			0.35-0.55
				3.00- 6.00	GC1210	100-140	0.15-0.25
				6.01-10.00			0.20-0.35
10.01-14.00	0.30-0.55						
N	30.21	Legure aluminijuma	75	3.00- 6.00	GC1220	120-230	0.15-0.25
				6.01-10.00			0.20-0.40
				10.01-14.00			0.30-0.50
				14.01-20.00			0.40-0.60
				3.00- 6.00	N20D	120-230	0.15-0.25
				6.01-10.00			0.20-0.40
				10.01-14.00			0.30-0.50
				14.01-20.00			0.40-0.60
S	20.22	Vatrootporne super legure	350	3.00- 6.00	GC1220	10-25	0.06-0.12
				6.01-10.00			0.08-0.15
				10.01-14.00			0.08-0.15
				14.01-20.00			0.10-0.16
H	04.1	Veoma tvrd čelik	50 HRC	3.00- 6.00	GC1220	15-25	0.06-0.10
				6.01-10.00			0.08-0.12
				10.01-14.00			0.10-0.15
				14.01-20.00			0.12-0.18



CoroDrill® 880

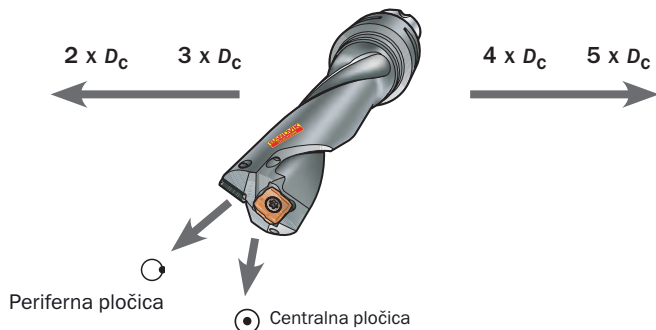


Burgija sa izmenljivim pločicama CoroDrill® 880

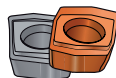
Izbor burgije



Dubina bušenja



Dve rezne ivice
12.00-13.99 mm



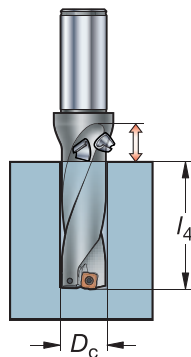
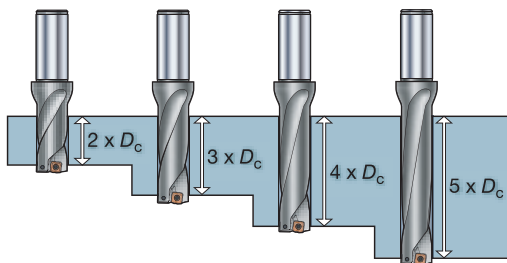
Četiri rezne ivice
14.00-63.00 mm



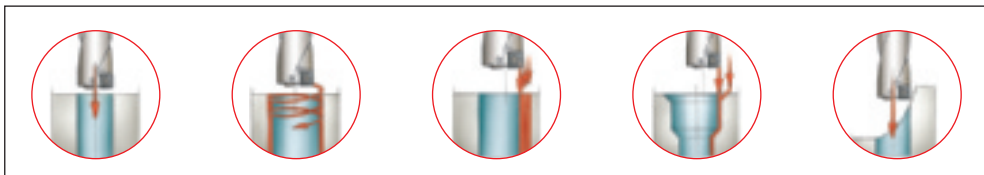
Za postizanje najbolje stabilnosti i tolerancije rupe, izabrati najkraću moguću dužinu burgije l_4 .

Maksimalna dubina rupe je funkcija prečnika rupe D_c i dubine rupe l_4 .

Definicija dubine bušenja, l_4



Operacije:



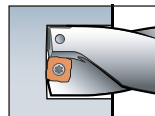
konvencionalno bušenje

Helikoidna interpolacija

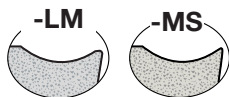
Radijalno podešeno bušenje

Stepenasto bušenje i obaranje ivice

Bušenje zakošenih površina

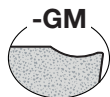


Pomak /geometrija

**Optimalne geometrije**

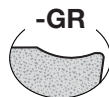
LM geometrija je prvi izbor za materijale sa dužom strugotinom, za male i srednje pomake.

MS geometrija je geometrija sa oštrom reznom ivicom optimalna za nerđajuće čelike (ISO M). Za male i srednje pomake.

**Laka obrada**

Prvi izbor za laku obradu. Kratak i plitak lomač strugotine obezbeđuje odličnu kontrolu strugotine u području pomaka.

Mali radijus osigurava smanjeno skretanje burgije pri obradi. Za male i srednje pomake.

**Geometrija za univerzalnu i grubu obradu**

Prvi izbor za čelik i sivi liv. Jaka ojačana ivica sa velikim radijusom. Za male i velike pomake.

**Geometrija za teške uslove obrade**

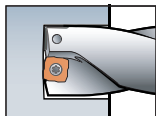
Za sve materijale u teškim uslovima obrade. Veoma jaka ojačana ivica.

Izbor u nestabilnim uslovima obrade i isprekidanom rezu. Za male i velike pomake.

	ISO/ANSI	Veličina pločice	Diameter	Prvi izbor		
				⊙	⊙	
P	Čelik	Nisko ugljenični	01-03	12.00-19.99	LM / GC4044	LM / GC1044
			04-09	20.00-63.00	LM / GC4024	
		Visoko ugljenični	01-03	12.00-19.99	GR / GC4044	GR / GC1044
			04-09	20.00-63.00	GR / GC4024	
M	Nerđajući čelik	01	12.00-13.99	LM / GC4044	LM / GC1044	
		02-06	14.00-35.99	MS / GC2044	LM / GC1144	
		07-09	36.00-63.00	LM / GC4024	LM / GC1044	
K	Sivi Liv	01-03	12.00-19.99	GR / GC4044	GR / GC1044	
		04-09	20.00-63.00	GR / GC4024		
N	Neferitni materijali	01-02	12.00-16.49	LM / GC4044	LM / GC1044	
		03-09	16.50-63.00	LM / H13A	LM / H13A	
S	Vatrootporni materijali	01-02	12.00-16.49	LM / GC4044	LM / GC1044	
		03-09	16.50-63.00	LM / H13A	LM / H13A	
H	Kaljeni materijali	01	12.00-13.99	GR / GC4044	GR / GC1044	
		02-09	14.00-63.00	GM / GC4044	GR / GC1044	

⊙ Periferna pločica

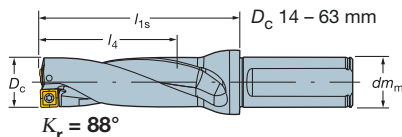
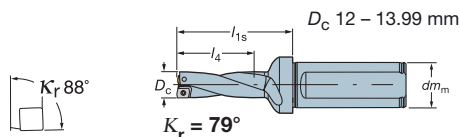
⊙ Centralna pločica



CoroDrill® 880

Prečnik burgije 12 – 29.5 mm

Maks. dubina rupe 2-3-4-5 x prečnik burgije (D_c)



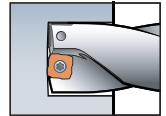
Cilindrična drška - zaravnjenje prema ISO 9766

l_{1s} = dužina za programiranje

D_c mm	$D_c^{2)}$	dm_m	$2 \times D_c$ Kataloška oznaka		l_{1s}	$l_4^{1)}$	$3 \times D_c$ Kataloška oznaka		l_{1s}	$l_4^{1)}$	$4 \times D_c$ Kataloška oznaka		l_{1s}	$l_4^{1)}$
12	12.5	20	880-D1200L20-02	39	24	880-D1200L20-03	51	36	880-D1200L20-04	63	48	→		
12.5	13.0		D1250L20-02	41	25	D1250L20-03	53	38	D1250L20-04	66	50			
12.7	13.2		D1270L20-02	41	25	D1270L20-03	54	38	D1270L20-04	66	51			
13	13.5		D1300L20-02	42	26	D1300L20-03	55	39	D1300L20-04	68	52			
13.5	14.0		D1350L20-02	43	27	D1350L20-03	56	41	D1350L20-04	70	54			
14	15	20	880-D1400L20-02	44	28	880-D1400L20-03	58	42	880-D1400L20-04	72	56	→		
14.5	15.4		D1450L20-02	46	29	D1450L20-03	60	44	D1450L20-04	75	58			
15	15.8		D1500L20-02	47	30	D1500L20-03	62	45	D1500L20-04	77	60			
15.5	16.1		D1550L20-02	49	31	D1550L20-03	64	47	D1550L20-04	79	62			
16	16.6		D1600L20-02	51	32	D1600L20-03	66	48	D1600L20-04	82	64			
16.5	17.7	20	880-D1650L20-02	52	33	880-D1650L20-03	68	50	880-D1650L20-04	84	66	→		
17	18.2		D1700L20-02	53	34	D1700L20-03	69	51	D1700L20-04	86	68			
17.5	18.5	25	880-D1750L25-02	55	35	880-D1750L25-03	72	53	880-D1750L25-04	89	70	→		
18	18.8		D1800L25-02	56	36	D1800L25-03	73	54	D1800L25-04	91	72			
18.5	19.3		D1850L25-02	57	37	D1850L25-03	75	56	D1850L25-04	93	74			
19	19.6		D1900L25-02	58	38	D1900L25-03	76	57	D1900L25-04	95	76			
19.5	20.1		D1950L25-02	60	39	D1950L25-03	79	59	D1950L25-04	99	78			
20	21.8	25	880-D2000L25-02	61	40	880-D2000L25-03	81	60	880-D2000L25-04	101	80	→		
20.5	22.1		-	-	-	D2050L25-03	82	62	-	-				
20.9	22.5		-	-	-	D2090L25-03	84	63	-	-				
21	22.6		D2100L25-02	64	42	D2100L25-03	84	63	D2100L25-04	105	84			
21.5	22.9		-	-	-	D2150L25-03	86	65	-	-				
22	23.2	25	880-D2200L25-02	66	44	880-D2200L25-03	87	66	880-D2200L25-04	109	88	→		
22.5	23.5		-	-	-	D2250L25-03	90	68	-	-				
23	24.0		D2300L25-02	69	46	D2300L25-03	91	69	D2300L25-04	114	92			
23.5	24.3		-	-	-	D2350L25-03	93	71	-	-				
23.9	24.5		-	-	-	D2390L25-03	95	72	-	-				
24	26.2	25	880-D2400L25-02	71	48	880-D2400L25-03	95	72	880-D2400L25-04	119	96	→		
24.5	26.5		-	-	-	D2450L25-03	97	74	-	-				
25	27.0		D2500L25-02	74	50	D2500L25-03	99	75	D2500L25-04	124	100			
25.5	27.4		-	-	-	D2550L25-03	100	77	-	-				
26	27.8	32	880-D2600L32-02	77	52	880-D2600L32-03	102	78	880-D2600L32-04	128	104	→		
26.4	28.0		-	-	-	D2640L32-03	104	79	-	-				
26.5	28.1		-	-	-	D2650L32-03	104	80	-	-				
27	28.4		D2700L32-02	79	54	D2700L32-03	105	81	D2700L32-04	132	108			
27.5	28.7		-	-	-	D2750L32-03	108	83	-	-				
28	29.2	32	880-D2800L32-02	82	56	880-D2800L32-03	109	84	880-D2800L32-04	137	112	→		
28.5	29.5		-	-	-	D2850L32-03	111	86	-	-				
29	30.0		D2900L32-02	84	58	D2900L32-03	112	87	D2900L32-04	141	116			
29.4	30.2		-	-	-	D2940L32-03	115	88	-	-				
29.5	30.3		-	-	-	D2950L32-03	115	89	-	-				

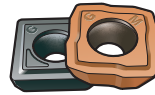
¹⁾ Maks. Dubina rupe

²⁾ Vrednost posle max radijalnog podešavanja.
5 x D_c , videti glavni katalog.

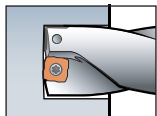


Pločice

- ⊙ = centralna pločica
○ = periferna pločica



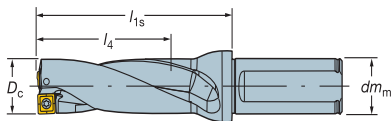
D _c mm	veličina	Kataloška oznaka	P		M				K			N	S		H				
			1044	4014	4024	4034	4044	1044	1144	2044	4024	4034	4044	1044	4044	H13A	1044	4044	
→ 12 12.5 12.7 13 13.5	01	880-010203H-C-GR	⊙	★															
		010203H-C-LM	⊙	★															
		880-0102W04H-P-GR	○		☆	☆	★			☆	☆	☆		☆				☆	☆
		0102W04H-P-LM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
→ 14 14.5 15 15.5 16	02	880-020204H-C-GR	⊙	★															
		020204H-C-GM	⊙	★															
		880-0202W05H-P-GR	○			☆	★												
		0202W04H-P-GM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
		0202W05H-P-GT	○		☆	☆	★			☆	☆	☆		☆				☆	☆
0202W05H-P-LM	○		☆	☆	★			☆	☆	☆		☆				☆	☆		
0202W05H-P-MS	○						★								☆				
→ 16.5 17	03	880-030305H-C-GR	⊙	★															
		030305H-C-GM	⊙	★															
		880-0303W06H-P-GR	○			☆	★												
		0303W05H-P-GM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
		0303W06H-P-LM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
0303W06H-P-MS	○						★								☆				
→ 20 20.5 20.9 21 21.5	04	880-040305H-C-GR	⊙	★															
		040305H-C-GM	⊙	★															
		880-0403W07H-P-GR	○			☆	★												
		0403W05H-P-GM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
		0403W07H-P-LM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
0403W07H-P-MS	○						★							☆					
→ 22 22.5 23 23.5 23.9	05	880-050305H-C-GR	⊙	★															
		050305H-C-GM	⊙	★															
		880-0503W08H-P-GR	○			☆	★												
		0503W05H-P-GM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
		0503W08H-P-LM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
0503W08H-P-MS	○						★							☆					
→ 24 24.5 25 25.5	06	880-060305H-C-GR	⊙	★															
		060305H-C-GM	⊙	★															
		880-0603W10H-P-GR	○			☆	★												
		0603W05H-P-GM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
		0603W10H-P-LM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
0603W10H-P-MS	○						★							☆					
→ 26 26.4 26.5 27 27.5	07	880-070305H-C-GR	⊙	★															
		070305H-C-GM	⊙	★															
		880-0703W12H-P-GR	○			☆	★												
		0703W05H-P-GM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
		0703W12H-P-LM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
0703W12H-P-MS	○						★							☆					
→ 28 28.5 29 29.4 29.5	08	880-080305H-C-GR	⊙	★															
		080305H-C-GM	⊙	★															
		880-0803W14H-P-GR	○			☆	★												
		0803W05H-P-GM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
		0803W14H-P-LM	○		☆	☆	★			☆	☆	☆		☆				☆	☆
0803W14H-P-MS	○						★							☆					



CoroDrill® 880

Prečnik burgije 30 – 63 mm*

Maks. dubina rupe 2-3-4-5 x prečnik burgije (D_c)



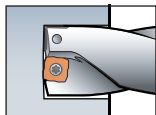
Cilindrična drška - zaravnjenje prema ISO 9766

l_{1s} = dužina za programiranje

D_c mm	$D_c^{(2)}$	dm_m	2 x D_c Kataloška oznaka	l_{1s}	$l_4^{(1)}$	3 x D_c Kataloška oznaka	l_{1s}	$l_4^{(1)}$	4 x D_c Kataloška oznaka	l_{1s}	$l_4^{(1)}$
30	32.2	32	880-D3000L32-02	87	60	880-D3000L32-03	117	90	880-D3000L32-04	147	120
30.5	32.6		-	-	-	D3050L32-03	118	92	-	-	-
31	33.0	40	880-D3100L40-02	90	62	880-D3100L40-03	121	93	880-D3100L40-04	152	124
31.5	33.4		-	-	-	D3150L40-03	122	95	-	-	-
32	33.7		D3200L40-02	92	64	D3200L40-03	124	96	D3200L40-04	156	128
32.5	34.1		-	-	-	D3250L40-03	126	98	-	-	-
33	34.5		D3300L40-02	95	66	D3300L40-03	128	99	D3300L40-04	161	132
33.5	34.9	40	880-D3400L40-02	98	68	880-D3350L40-03	130	101	-	-	-
34	35.3		-	-	-	D3400L40-03	131	102	880-D3400L40-04	165	136
34.5	35.6		-	-	-	D3450L40-03	134	104	-	-	-
35	36.0		D3500L40-02	101	70	D3500L40-03	135	105	D3500L40-04	170	140
35.5	36.4		-	-	-	D3550L40-03	137	107	-	-	-
36	38.8	40	880-D3600L40-02	104	72	880-D3600L40-03	139	108	880-D3600L40-04	175	144
37	39.5		D3700L40-02	105	74	D3700L40-03	142	111	D3700L40-04	179	148
38	40.3		D3800L40-02	108	76	D3800L40-03	146	114	D3800L40-04	184	152
39	41.0		D3900L40-02	110	78	D3900L40-03	149	117	D3900L40-04	188	156
40	41.8		D4000L40-02	113	80	D4000L40-03	153	120	D4000L40-04	193	160
41	42.5		D4100L40-02	117	82	D4100L40-03	157	123	D4100L40-04	198	164
42	43.3		40	880-D4200L40-02	119	84	880-D4200L40-03	160	126	880-D4200L50-04	202
43	44.0	D4300L40-02		122	86	D4300L40-03	164	129	D4300L50-04	207	172
44	47.0	$2 \times D_c, 3 \times D_c \rightarrow dm_m = 40$ $4 \times D_c, 5 \times D_c \rightarrow dm_m = 50$	880-D4400L40-02	124	88	880-D4400L40-03	167	132	880-D4400L50-04	211	176
45	47.8		D4500L40-02	127	90	D4500L40-03	172	135	D4500L50-04	217	180
46	48.6		D4600L40-02	130	92	D4600L40-03	176	138	D4600L50-04	222	184
47	49.2		D4700L40-02	132	94	D4700L40-03	179	141	D4700L50-04	226	188
48	50.0		D4800L40-02	135	96	D4800L40-03	183	144	D4800L50-04	231	192
49	50.8		D4900L40-02	137	98	D4900L40-03	186	147	D4900L50-04	235	196
50	51.6		D5000L40-02	140	100	D5000L40-03	190	150	D5000L50-04	240	200
51	52.2		D5100L40-02	144	102	D5100L40-03	194	153	D5100L50-04	245	204
52	53.0		D5200L40-02	146	104	D5200L40-03	197	156	D5200L50-04	249	208
53	57.0		40	880-D5300L40-02	149	106	880-D5300L40-03	201	159	880-D5300L50-04	254
54	57.8	D5400L40-02		151	108	D5400L40-03	204	162	D5400L50-04	258	216
55	58.4	D5500L40-02		154	110	D5500L40-03	209	165	D5500L50-04	264	220
56	59.2	D5600L40-02		157	112	D5600L40-03	213	168	D5600L50-04	269	224
57	60.0	D5700L40-02		159	114	D5700L40-03	216	171	D5700L50-04	273	228
58	60.8	D5800L40-02		162	116	D5800L40-03	220	174	D5800L50-04	278	232
59	61.4	D5900L40-02		164	118	D5900L40-03	223	177	-	-	-
60	62.2	D6000L40-02		167	120	D6000L40-03	227	180	-	-	-
61	63.0	D6100L40-02		171	122	D6100L40-03	232	183	-	-	-
62	63.6	D6200L40-02		173	124	D6200L40-03	235	186	-	-	-
63	64.4	D6300L40-02	176	126	D6300L40-03	239	189	-	-	-	

¹⁾ Maks. dubina rupe

²⁾ Vrednost posle max radijalnog podešavanja.
5 x D_c , videti glavni katalog.



CoroDrill® 880

Režimi obrade (polazne vrednosti)

Zadebljanim tekstom su označeni preporučeni kvalitet, geometrija i režimi rezanja



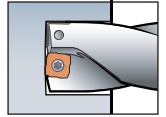
ISO/ANSI	CMC	HB	Prečnik burgije D_c mm	Kvalitet - centralna pločica	Kvalitet - periferne pločice	Brzina rezanja v_c m/min	Geometrija / pomak mm/ob														
							Dužina burgije 2-3 x D_c														
							-LM f_n	-MS f_n	-GM f_n	-GT f_n	-GR f_n										
P	02.1	180	12.00-13.99	1044	4014*	175-320	0.04-0.10		0.04-0.10	0.04-0.20	0.04-0.15										
			14.00-16.49				0.04-0.10					0.06-0.14	0.06-0.22								
			16.50-19.99				0.06-0.14							0.06-0.18	0.06-0.26						
			20.00-23.99				0.06-0.18									0.08-0.18	0.08-0.30				
			24.00-29.99				0.06-0.18											0.08-0.24	0.08-0.32		
			30.00-35.99				0.06-0.24													0.08-0.24	0.08-0.34
			36.00-43.99				0.10-0.24														
44.00-52.99	0.10-0.24	0.10-0.24	0.10-0.34																		
53.00-63.50	0.10-0.24																				
M	05.21			180	12.00-13.99	1144	4024	120-250	0.04-0.12	0.04-0.14	0.04-0.08	0.04-0.14	0.04-0.08								
					14.00-16.49				0.04-0.14					0.06-0.14	0.06-0.14						
					16.50-19.99				0.06-0.14							0.06-0.12	0.06-0.16				
					20.00-23.99				0.06-0.16									0.06-0.12	0.06-0.12		
					24.00-29.99				0.06-0.16											0.06-0.16	0.06-0.16
		30.00-35.99	0.06-0.18		0.06-0.16				0.06-0.16												
		36.00-43.99	0.06-0.18																		
44.00-52.99	0.10-0.20	0.10-0.16	0.10-0.16																		
53.00-63.50	0.10-0.20																				
K	08.2			220		12.00-13.99	1044	4014*		110-250	0.06-0.10		0.06-0.12	0.06-0.16	0.06-0.15						
						14.00-16.49					0.06-0.10					0.06-0.12	0.06-0.16				
						16.50-19.99					0.06-0.12							0.08-0.14	0.08-0.18		
					20.00-23.99	0.08-0.14			0.10-0.16		0.10-0.24										
					24.00-29.99	0.08-0.14														0.10-0.18	0.10-0.28
		30.00-35.99	0.10-0.16		0.10-0.20	0.10-0.30															
		36.00-43.99	0.10-0.16																		
44.00-52.99	0.10-0.16	0.10-0.20	0.10-0.32																		
53.00-63.50	0.10-0.16																				
N	30.21			75			12.00-13.99	1044		4044		300-385	0.04-0.12		0.04-0.14	0.04-0.12	0.04-0.12				
							14.00-16.49		0.04-0.12		0.04-0.16		0.04-0.14								
							16.50-19.99		0.04-0.14									0.06-0.18	0.06-0.16		
					20.00-23.99	0.06-0.16	0.10-0.20		0.10-0.18												
					24.00-29.99	0.10-0.18														0.10-0.22	0.10-0.18
		30.00-35.99	0.10-0.20		0.10-0.24	0.10-0.20															
		36.00-43.99	0.12-0.22																		
44.00-52.99	0.12-0.22	0.12-0.26	0.12-0.22																		
53.00-63.50	0.12-0.22																				
S	20.22			350				12.00-13.99		1044	4044	20-90	0.04-0.08	0.04-0.08	0.04-0.10	0.04-0.08	0.04-0.08				
							14.00-16.49	0.04-0.08	0.05-0.08				0.05-0.08								
							16.50-19.99	0.05-0.08										0.05-0.10	0.05-0.08		
					20.00-23.99	0.05-0.08	0.06-0.12	0.05-0.08													
					24.00-29.99	0.06-0.10														0.06-0.12	0.06-0.12
		30.00-35.99	0.06-0.12		0.06-0.12	0.06-0.12															
		36.00-43.99	0.06-0.12																		
44.00-52.99	0.06-0.12	0.08-0.14	0.08-0.12																		
53.00-63.50	0.08-0.14																				
H	04.1			HRC60					12.00-13.99	1044	4014*	40-100	0.04-0.08		0.04-0.12	0.04-0.08	0.04-0.10				
							14.00-16.49	0.04-0.08	0.06-0.14				0.05-0.12								
							16.50-19.99	0.05-0.12										0.06-0.18	0.05-0.14		
					20.00-23.99	0.05-0.14	0.06-0.18	0.05-0.14													
					24.00-29.99	0.05-0.14														0.06-0.20	0.06-0.16
		30.00-35.99	0.06-0.16		0.06-0.20	0.06-0.16															
		36.00-43.99	0.06-0.16																		
44.00-52.99	0.10-0.16	0.10-0.20	0.10-0.16																		
53.00-63.50	0.10-0.16																				

* Samo u - GM i LM geometriji.

CoroDrill® 880

Režimi obrade (polazne vrednosti)

Zadebljanim tekstom su označeni preporučeni kvalitet, geometrija i režimi rezanja



ISO/ANSI	CMC	HB	Prečnik burgije D_c mm	Kvalitet - centralna pločica	Kvalitet - periferia pločica	Brzina rezanja v_c m/min	Geometrija / pomak mm/ob				
							Dužina burgije $4 \times D_c$				
							-LM f_n	-MS f_n	-GM f_n	-GT f_n	-GR f_n
P	02.1	180	12.00-13.99	1044	4014*	175-320	0.04-0.10				0.04-0.12
			14.00-16.49				0.04-0.10			0.04-0.14	
			16.50-19.99				0.06-0.14		0.04-0.10	0.06-0.16	
			20.00-23.99				0.06-0.18		0.06-0.18	0.06-0.20	
			24.00-29.99				0.06-0.18		0.08-0.18	0.08-0.22	
			30.00-35.99				0.06-0.20		0.08-0.20	0.08-0.24	
			36.00-43.99				0.06-0.24		0.08-0.24	0.08-0.24	
			53.00-63.50				0.10-0.20		0.10-0.24	0.10-0.24	
M	05.21	180	12.00-13.99	1144	4024	120-250	0.04-0.10				0.04-0.08
			14.00-16.49				0.04-0.12	0.04-0.12	0.04-0.08	0.04-0.12	0.04-0.08
			16.50-19.99				0.06-0.12	0.06-0.12	0.04-0.08	0.06-0.12	0.04-0.08
			20.00-23.99				0.06-0.14	0.06-0.14	0.06-0.12	0.06-0.14	0.06-0.12
			24.00-29.99				0.06-0.14	0.06-0.14	0.06-0.12	0.06-0.14	0.06-0.12
			30.00-35.99				0.06-0.16	0.06-0.16	0.06-0.16	0.06-0.16	0.06-0.16
			36.00-43.99				0.06-0.16	0.06-0.16	0.10-0.16	0.10-0.16	0.10-0.16
			53.00-63.50				0.10-0.16	0.10-0.16	0.10-0.16	0.10-0.16	0.10-0.16
K	08.2	220	12.00-13.99	1044	4014*	110-250	0.06-0.10				0.06-0.12
			14.00-16.49				0.06-0.10		0.06-0.12	0.06-0.12	0.06-0.12
			16.50-19.99				0.06-0.12		0.08-0.14	0.08-0.14	0.08-0.14
			20.00-23.99				0.08-0.14		0.10-0.16	0.10-0.19	0.10-0.19
			24.00-29.99				0.08-0.14		0.10-0.18	0.10-0.22	0.10-0.22
			30.00-35.99				0.10-0.16		0.10-0.20	0.10-0.24	0.10-0.24
			36.00-43.99				0.10-0.16		0.10-0.20	0.10-0.26	0.10-0.26
			53.00-63.50				0.10-0.16		0.10-0.20	0.10-0.26	0.10-0.26
N	30.21	75	12.00-13.99	1044	4044	300-385	0.04-0.10				0.04-0.10
			14.00-16.49				0.04-0.10		0.04-0.12	0.04-0.10	0.04-0.10
			16.50-19.99				0.04-0.12		0.04-0.14	0.04-0.12	0.04-0.12
			20.00-23.99				0.06-0.14		0.06-0.16	0.06-0.16	0.06-0.14
			24.00-29.99				0.10-0.16		0.10-0.18	0.10-0.16	0.10-0.16
			30.00-35.99				0.10-0.18		0.10-0.20	0.10-0.18	0.10-0.18
			36.00-43.99				0.10-0.18		0.10-0.22	0.10-0.18	0.10-0.18
			53.00-63.50				0.12-0.20		0.12-0.24	0.12-0.20	0.12-0.20
S	20.22	350	12.00-13.99	1044	4044	20-90	0.04-0.08				0.04-0.08
			14.00-16.49				0.04-0.08	0.04-0.08	0.04-0.08	0.04-0.08	0.04-0.08
			16.50-19.99				0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
			20.00-23.99				0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
			24.00-29.99				0.05-0.10	0.05-0.10	0.06-0.10	0.06-0.08	0.06-0.08
			30.00-35.99				0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
			36.00-43.99				0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
			53.00-63.50				0.08-0.14	0.08-0.14	0.08-0.14	0.08-0.12	0.08-0.12
H	04.1	HRC60	12.00-13.99	1044	4014*	40-100	0.04-0.08				0.04-0.10
			14.00-16.49				0.04-0.08		0.05-0.10	0.04-0.08	0.04-0.08
			16.50-19.99				0.05-0.10		0.06-0.12	0.05-0.10	0.05-0.10
			20.00-23.99				0.05-0.12		0.06-0.15	0.05-0.12	0.05-0.12
			24.00-29.99				0.05-0.12		0.06-0.15	0.05-0.12	0.05-0.12
			30.00-35.99				0.06-0.16		0.06-0.18	0.06-0.16	0.06-0.16
			36.00-43.99				0.06-0.16		0.06-0.18	0.06-0.16	0.06-0.16
			53.00-63.50				0.10-0.16		0.10-0.18	0.10-0.16	0.10-0.16

* Samo u - GM i LM geometriji.



Modularni sistem alata

Coromant Capto®
Standard ISO 26623

Isti prihvati odgovaraju svim vašim mašinama ...

Coromant Capto® je otvoren sistem alata koji vam omogućava da imate samo jedan sistem alata u potpunom pogonu. Uvek se koristi potpuno isti osnovni prihvat.

U širokom potencijalu za standardizaciju Coromant Capto-a nalaze se velike uštede u troškovima alata.

Izbegavajte poručivanje skupih specijalnih alata. Često se alat koji vam je potreban može sklopiti korišćenjem modularnosti Coromant Capto® sistema..

Coromant Capto® – jedini izbor

Coromant Capto je mnogo puta dokazao da ispunjava zahteve raznovrsnih vrsta obrade od starih mašina pa do najmodernijih "multi-task" mašina.

Coromant Capto je jedini pravi univerzalni sistem alata koji pokriva sve operacije obrade metala rezanjem - nezavisno od tipa mašine i vretena. Ipak, sa Coromant Capto-m integrisanim u vretenu, dobijate još nekoliko stvari više.

Isti prihvat podjednako efikasan za ...



GLODANJE

BUŠENJE

Genijalan prihvat - konusni poligon

Obrtni moment je pravilno raspoređen na poligon, bez skokova nezvezano za rotaciju, dodajući alatu samocentrirajući efekat.

Struganje



Modularni sistem alata

Coromant Capto®
Standard ISO 26623

Coromant Capto® – mogućnosti opremanja

Širok dijapazon alata je veoma važan za kompletan Coromant Capto koncept. Svi razvojni potencijali i stečeno znanje koje postoji u Sandvik Coromant-u, kao vodećem svetskom proizvođaču alata, je usmereno ka razvoju i proizvodnji najboljih alata za sve vrste mašina.

Alati za struganje

Za opšte struganje koristite T-Max P sistem sa negativnim pločicama i CoroTurn® 107 sa pozitivnim pločicama kao osnovu za visoko produktivno struganje.

Za postizanje visoke produktivnosti u odsecanju i ukopavanju prvi izbor je CoroCut sistem, a ukoliko vam je potreban savremeni sistem rezanja navoja jasan izbor je CoroThread sistem.



Alati za obradu otvora

Sandvik Coromant-ov program alata za bušenje, CoroDrill® i CoroBore®, nudi širok dijapazon alata visokih performansi. Bez obzira na tip otvora - mi vam možemo ponuditi pravi alat za najbolju produktivnost u širokom dijapazonu prečnika. Dostupne su burgije od tvrdog metala i burgije sa izmenljivim pločicama.



Alati za glodanje

Sandvik Coromant nudi pun asortiman alata za glodanje. U CoroMill® familiji uvek postoji CoroMill® glodalo koje savršeno odgovara vašim potrebama. CoroMill® familija je višenamenski sistem alata za glodanje za aplikacije kao što su plansko-, ugaono-, profilno glodanje i glodanje žljebova.

Nosači alata i adapteri

Moderne mašine postavljaju stroge zahteve pred nosače alata. Posebno u slučajevima kada se koriste glodala i burgije od punog tvrdog metala na velikim brojevima obrtaja, gde su neophodna minimalna bacanja kao predušlov dugom veku alata. HydroGrip ispunjava sve ove zahteve. Različiti tipovi adaptera su dostupni, koji omogućavaju sastavljanje sklopa potrebne dužine.



Za više informacija o našem širokom Coromant Capto programu, kontaktirajte najbližeg predstavnika Sandvik Coromanta, pročitajte u našem brojnim štampanim materijalima ili posetite našu web stranu www.sandvik.coromant.com



Praktični saveti

Održavanje alata

Sedište pločice i podložne pločice

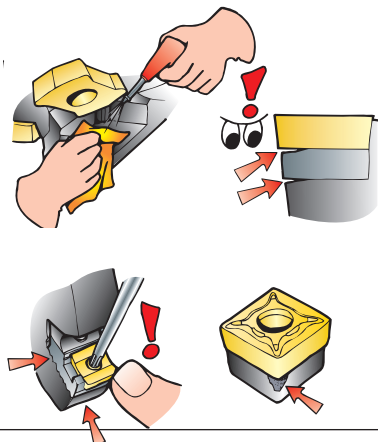
Proverite podložnu pločicu na oštećenja.

Očistite sedišta i oslona mesta pločica.

Ukoliko je potrebno, okrenite ili zamenite podložnu pločicu.

Osigurajte pravilnu lokaciju pločice u odnosu na oslone tačke.

Važno je osigurati da krajevi podložnih pločica nisu odlomljeni prilikom obrade ili rukovanja.



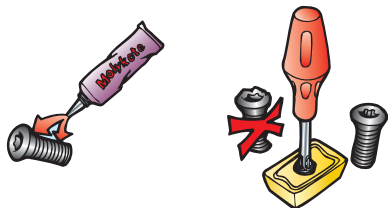
Vijci za stezanje pločica

Obezbedite korektan moment pritezanja vijaka.

Stavite dovoljno sredstva za podmazivanje na vijak, kako bi sprečili njegovo zaglavlivanje. Sredstvo staviti na navoj i sedište glave vijka.

Zamenite pohabane i oštećene vijke.

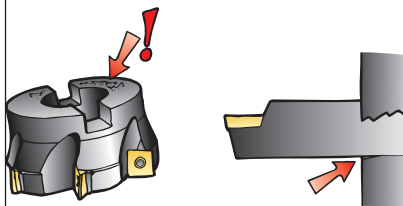
Koristite predviđene ključeve.



Kontaktne površine

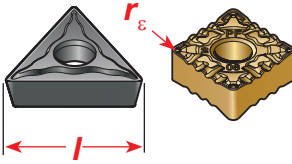
Uvek proverite oslone površine na nosačima, glodalima i burgijama, pogotovo na postojanje oštećenja i prljavštine.

Pri operacijama razbušivanja je veoma važno imati najbolje moguće stezanje. Ako drška alata nije stegnuta do kraja nosača, prepust će biti povećan i dolazi do pojave vibracija.





Praktični saveti



Sigurnost proizvodnje

Veoma je važno izabrati pravu veličinu pločice, oblik, geometriju i radijus da bi ostvarili pravilan tok strugotine.

— Izaberite pločicu sa najvećim mogućim uglom vrha pločice radi maksimalne snage i ekonomičnosti..

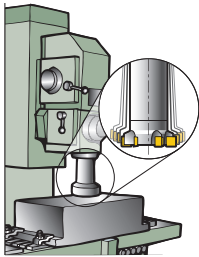
— Izaberite najveći mogući radijus zbog sigurnosti pločice.

— Izaberite manji radijus ako postoje tendencije ka vibracijama.

l = dužina rezne ivice (veličina pločice)

l_a = efektivna dužina rezne ivice

r_ϵ = radijus vrha alata



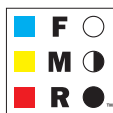
Stabilnost

Stabilnost je ključni faktor za uspešno rezanje metala, sa velikim uticajem na troškove i produktivnost.

Uverite se da je otklonjen svaki zazor, prepust, slabost koji nije bio neizbežan i da se koriste prave vrste i veličine alata.

Bitne tačke održavanja:

- Proverite habanje alata i podložnu pločicu na oštećenje.
- Uverite se da je sedište pločice čisto
- Uverite se u korektnu lokaciju pločice.
- Uverite se da se koriste pravi ključevi.
- Vijci za stezanje pločica treba da su pritegnuti pravilno.
- Podmažite vijak pre sklapanja alata.
- Uverite se da su kontaktne površine čiste i neoštećene na alatima, nosačima i vretenima mašina.
- Uverite se da su drške nosača za unutrašnju obradu dobro stegnute i neoštećene.
- Dobro organizovano, održavano i dokumentovano skladište alata je izvor ušteda u proizvodnji.
- Stabilnost je uvek kritičan faktor u svakoj operaciji rezanja metala.



Praktični saveti

Klasifikacije tipova habanja alata

"Flank" i "notch" - habanje leđne površine i pojava zarezna na dubini rezanja



Brz razvoj habanja leđne površine proizvodi lošu obradu ili komad van tolerancije



Pojava zarezna (notch) proizvodi lošu obradu i rizik od loma ivice.

Termalne pukotine



Male pukotine upravno na reznju ivicu izazivaju krzanje i lošu površinu rezne ivice.

Pojava kratera



Oslabljuje reznju ivicu

Lom pločice



Oštećuje ne samo pločicu, već i podložnu pločicu i obradak.

Naslage (Built-up-edge=BUE) (B.U.E)



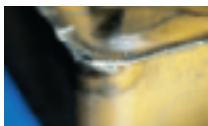
Izaziva loš kvalitet obrade i krzanje rezne ivice kada se naslage (B.U.E) otkinu sa grudne površine.

Plastična deformacija



Depresija rezne ivice proizvodi lošu kontrolu nad strugotinom. Preterano habanje po leđnoj površini može dovesti i do loma pločice.

Krzanje (Frittering)



Mali lomovi rezne ivice izazivaju loš kvalitet obrađene površine i intenzivno habanje na leđnoj površini.

Praktični saveti



Ako se pojave problemi!

Nekoliko rešenja za previlaženje najčešćih problema tokom:

Struganje

Problemi i rešenja

Problemi

Habanje na leđnoj površini

X

Pojava zareza (notch) na dubini rezanja

X

Pojava kratera

X

X

X

X

Plastična deformacija

X

X

X

Naslage (Built-up-edge=BUE) (BUE)

X

X

Male pukotine upravno na reznu ivicu

X

Mali lomovi rezne ivice (Krzanje - Frittering)

X

X

X

Lom pločice

X

X

X

Uvijanje duge strugotine

X

X

X

Vibracije

X

X

X

X

X

**Praktični saveti**

Ako se pojave problemi!

Nekoliko rešenja za prevlaženje najčešćih problema tokom:

Glodanje

Problemi i rešenja

Problemi	Smanjite brzinu rezanja	Povećaj brzinu rezanja	Smanjite pomak/zubu	Povećajte pomak/zubu	Izaberite kvalitet otporniji na habanje	Izaberite žilaviji kvalitet	Koristite glodala sa širokom podelom	Promenite položaj glodala	Ne koristite rashladno sredstvo
Habanje na leđnoj površini	X			X	X				
Pojava zareza (notch) na dubini rezanja	X			X	X				X
Pojava kratera	X				X				
Plastična deformacija	X		X		X				
Naslage (Built-up-edge=BUE) (BUE)		X		X					X
Male pukotine upravno na reznu ivicu	X					X			X
Mali lomovi rezne ivice (Krzanje - Frittering)		X				X			X
Lom pločice			X			X		X	
Vibracije				X			X	X	
Loša obrađena površina		X	X		X				

Praktični saveti



Ako se pojave problemi!

Nekoliko rešenja za previlaženje najčešćih problema tokom:

Bušenje

Problemi i rešenja

Problemi

	Ponovo dovedite burgiju u saosnost	Povećajte protok tečnosti, očistite filter i otvore za rashladnu tečnost na burgiji.	Izaberite žilaviji kvalitet	Smanjite pomak	Improve the Stabilnost, reclamp component, shorten drill overhang	Proverite dno otvora	Proverite preporuke za brzinu/pomak	Proverite kvalitet tvrdog metala	Povećajte brzinu rezanja
Slomljena prednja površina burgije	X		X		X		X		
Habanje na spoljašnjem prečniku burgije	X				X		X	X	
Prevelika / premala rupa	X			X		X	X		
Zaglavljivanje strugotine u spirali burgije		X		X	X		X		X
Vibracije				X	X		X		
Mali lomovi rezne ivice (Krzanje - Frittering)	X		X			X		X	X
Otvor nije simetričan				X	X		X		
Loš vek alata		X			X		X	X	



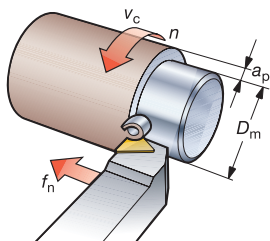
Najvažnije formule i definicije

Struganje, odsecanje i ukopavanje, rezanje navoja

Brzina rezanja (v_c)

(m/min)

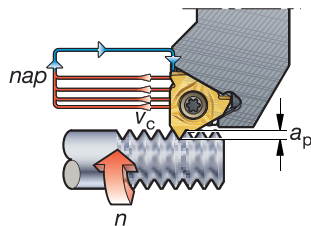
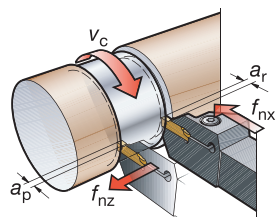
$$v_c = \frac{D_m \times \pi \times n}{1000}$$



Broj obrtaja (n)

(o/min)

$$n = \frac{v_c \times 1000}{\pi \times D_m}$$



a_p = aksijalna dubina rezanja (mm)

a_r = Dubina rezanja (mm). Od spoljašnjeg prečnika do dna žljeba

D_m = Prečnik obrade (mm)

f_n = pomak po obrtaju (mm/obr)

f_{nx} = radijalni pomak po obrtaju (mm/obr)

f_{nz} = aksijalni pomak po obrtaju (mm/obr)

n = broj obrtaja vretena (obr u minuti)

nap = broj prolaza

v_c = brzina rezanja (m/min)



Najvažnije formule i definicije

Bušenje i glodanje

Brzina rezanja (v_c)
(m/min)

$$v_c = \frac{D_{\text{cap}} \times \pi \times n}{1000}$$

Pomak po obrtaju (f_n)
(mm/obrtaju)

$$f_n = \frac{v_f}{n}$$

Pomak po zubu (f_z)
(mm/zubu)

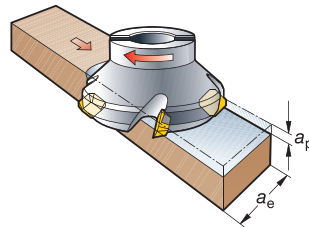
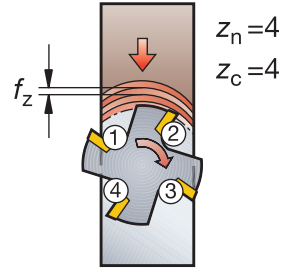
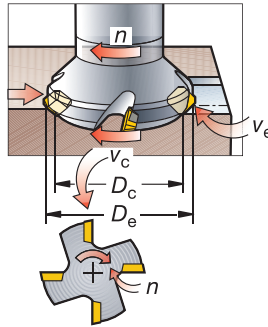
$$f_z = \frac{v_f}{n \times z_c}$$

Broj obrtaja (n)
(obrtaja u minuti)

$$n = \frac{v_c \times 1000}{\pi \times D_{\text{cap}}}$$

Pomak stola (v_f)
(mm/min)

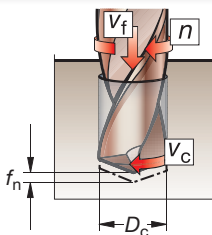
$$v_f = f_z \times n \times z_c$$



Faktor prodiranja (v_f)
(mm/min)

Pri bušenju $v_f = \text{mm/obrtaju}$

$$v_f = f_n \times n$$



a_e = širina glodanja (mm) (radni zahvat)

a_p = dubina rezanja (mm)

D_{cap} = Prečnik glodala na aktualnoj dubini rezanja, a_p (mm)

D_e = D_{cap} = prečnik glodala (mm) (na dubini rezanja)

f_n = pomak po obrtaju (mm/obrtaju)

n = broj obrtaja (obr. u min.)

v_c = brzina rezanja (m/min)

v_f = pomak stola (mm/min)

z_c = efektivni broj zuba u zahvatu (komada)



Sigurnost procesa rezanja

Informacije u vezi oštrenja/brušenja tvrdog metala

Sastav materijala

Proizvodi od tvrdog metala sadrže volfram karbid (WC) i kobalt. Druge supstance koje mogu biti u sastavu tvrdog metala su titanijum karbid, tantal karbid, niobijum karbid, hrom karbid, molibden karbid ili vanadijum karbid. Neki kvaliteti sadrže titanijum karbo nitrid ili nikl.

Rute izlaganja

Brušenje ili grejanje blankova od tvrdog metala stvara prašinu ili isparenja koja sadrže opasne materije koje se mogu udahnuti, progutati ili dospeti u oči ili na kožu.

Akutna zatrovanost

Prašina je otrovna ako se udiše. Udisanje može izazvati iritaciju i upalu disajnih puteva. Značajno veće upale disajnih puteva se javljaju pri istovremenom udisanju kobalta i WC-a, nego kada se udiše samo kobalt. U dodiru sa kožom ove materije mogu izazvati iritaciju ili svrab. Kod osetljivih osoba se može pojaviti alergijska reakcija.

Hronično otrovno

Prašina je otrovna ako se udiše. Udisanje može izazvati iritaciju i upalu disajnih puteva. Značajno veće upale disajnih puteva se javljaju pri istovremenom udisanju kobalta i WC-a, nego kada se udiše samo kobalt. U dodiru sa kožom ove materije mogu izazvati iritaciju ili svrab. Kod osetljivih osoba se može pojaviti alergijska reakcija.

Riskantne fraze

Otrovno: opasnost od ozbiljnog narušavanja zdravlja usled dugotrajnog udisanja otrova.

Ograničen dokaz o kancerogenom efektu.

Može izazvati iritaciju usled udisanja ili kontakta sa kožom.

Preventivne mere

- Izbegavajte stvaranje i udisanje prašine. Koristite pravilan sistem usisavanja i ventilacije kako bi izlaganje ljudstva držali značajno ispod propisanih granica.
- U slučaju nedovoljne ventilacije, koristite nacionalno odobrene aspiratore.
- Koristite sigurnosne naočare kada je potrebno.
- Izbegavajte uzastopne kontakte sa kožom. Nosite odgovarajuće rukavice. Pažljivo operite ruke nakon rukovanja.
- Koristite adekvatnu zaštitnu odeću.
- Ne jedite, pijte ili pušite u radnoj zoni. Operite kožu pažljivo pre jela.

Indeks



A		CNMG -MM	35	DCGX -AL	89
A...DCLNR/L	64, 68	CNMG -MR	37	DCLNR/L	58
A...DDUNR/L	64, 68	CNMG -PF	25	DCMT -KF	83
A...DSKNR/L	64, 68	CNMG -PM	27	DCMT -KM	85
A...DTFNR/L	64, 68	CNMG -PR	29	DCMT -KR	87
A...DVUNR/L	64	CNMG -QM	55	DCMT -MF	77, 91
A...DWLNR/L	64	CNMG -WF	25, 33, 41	DCMT -MM	79, 93
A...MWLNR/L	68	CNMG -WMX	27, 35, 43, 45	DCMT -MR	81
A...SCLCR/L	102	CNMM -MR	39	DCMT -PF	71
A...SDUCR/L	102	CNMM -PR	31	DCMT -PM	73
A...SSKCR/L	102	CNMM -WR	31	DCMT -PR	75
A...STFCR/L	104	Cx-DCLNR/L	59, 65	DCMW...FP	89
A...SVQBR/L	104	Cx-DDJNR/L	59, 65	DCMX -WF	71
A...SVUBR/L	104	Cx-DSKNR/L	61	DCMX -WF	71, 77, 83, 91
		Cx-DSRNR/L	61	DCMX - WM	73, 79, 85, 93
C		Cx-DSSNR/L	61	DDJNR/L	58
CCGT -UM	91, 93	Cx-DTFNR/L	59, 65	DNGA S...	57
CCGW...S	95	Cx-DTJNR/L	59	DNGP	51
CCGW...S...FWH	95	Cx-DVJNR/L	63	DNMA -KR	47
CCGW...T...FWH	95	Cx-DWLNR/L	63, 65	DNMG -23	53
CCGX -AL	89	Cx-MTJNR/L	63	DNMG -KF	41
CCMT -KF	83	Cx-MWLNR/L	69	DNMG -KM	43, 45
CCMT -KM	85	Cx-PCLNR/L	67	DNMG -KR	49
CCMT -KR	87	Cx-PDUNR/L	67	DNMG -MF	33, 51
CCMT -MF	77, 91	Cx-PSKNR/L	67	DNMG -MM	35
CCMT -MM	79, 93	Cx-PTFNR/L	69	DNMG -MR	37
CCMT -MR	81	Cx-266R/LFG	135	DNMG -PF	25
CCMT -PF	71	Cx-266R/LKF	137	DNMG -PM	27
CCMT -PM	73	Cx-R/L123	122, 126	DNMG -PR	29
CCMT -PR	75	Cx-SCLCR/L	97, 103	DNMG -QM	55
CCMT -WF	71, 77, 83, 91	Cx-SDJCR/L	97, 103	DNMM -MR	39
CCMT -WM	79, 85, 93	Cx-SRDCN	97	DNMM -PR	31
CCMW...FP	89	Cx-SRSCR/L	97	DNMX -WF	25, 33, 41
CNGA S...	57	Cx-SSKCR/L	103	DNMX -WMX	27, 35, 43, 45
CNGA T...	41, 43, 45	Cx-STFCR/L	105	DSBNR/L	60
CNGA T...AWH	57	Cx-STGCR/L	99	DSKNR/L	60
CNGP	51	Cx-SVHBR/L	101	DSSNR/L	60
CNMA -KR	47	Cx-SVJBR/L	101	DTFNR/L	58
CNMG -23	53	Cx-SVQBR/L	105	DTJNR/L	58
CNMG -KF	41	Cx-391.EH	175	DVJNR/L	62
CNMG -KM	43, 45	D		DWLNR/L	62
CNMG -KR	49	DCGT -UM	91, 93		
CNMG -MF	33, 51	DCGW...S	95		

E		R245 -KM	150	S	
E10	176	R245 -ML	150	SCGX -AL	89
E12	176	R245 -MM	150	SCLCR/L	96
E16	176	R245 -PH	150	SCMT -KF	83
E20	176	R245 -PL	150	SCMT -KM	85
E25	176	R245 -PM	150	SCMT -KR	87
M		R300	167	SCMT -MF	77, 91
MTJNR/L	62	R300 -KH	168	SCMT -MM	79, 93
N		R300 -MH	168	SCMT -MR	81
N123	124	R300 -MM	168	SCMT -PF	71
N123 -AM	119	R300 -PH	168	SCMT -PM	73
N123 -CF	111	R300 -PM	168	SCMT -PR	75
N123 -CM	109, 111	R390	156-158	SDJCR/L	96
N123 -CR	111	R390 -KH	159	SNGA S...	57
N123 -CS	109	R390 -KL	159, 162	SNGA T...	41, 43, 45
N123 -GF	115	R390 -KM	159, 162	SNMA -KR	47
N123 -GM	115	R390 -ML	162	SNMG - MF	33
N123 -RM	117	R390 -MM	159, 162	SNMG - MM	35
N123 -RO	117	R390 -NL	162	SNMG -23	53
N123 -RS	119	R390 -PH	162	SNMG -KM	43, 45
N123 -TF	121	R390 -PL	159, 162	SNMG -KM	45
N123 -TM	121	R390 -PM	159, 162	SNMG -KR	49
N123...S	115, 117	R590	170	SNMG -MR	37
N151.2 -4E	113	R590 -KL	169	SNMG -PF	25
N151.2 -5E	113	R590 -KW	170	SNMG -PM	27
N151.2 -5F	113	R590 -NL	169	SNMG -PR	29
N151.3 -4G	131	R590 -NW	170	SNMG -QM	55
R		R840	183-186	SNMM -MR	39
R/L123 -CF	111	R842	187-188	SNMM -PR	31
R/L123 -CM	111	R846	189	SRDCN	96
R/L123 -CR	111	R850	190-191	SRSCR/L	96
R/L151.2 -4E	113	RCGX -AL	89	SSBCR/L	98
R/L151.2 -5E	113	RCHT -KL	165	SSDCR/L	98
R/L151.2 -5F	113	RCHT -PL	165	STFCR/L	98
R/LAG123	130	RCKT -KH	165	STGCR/L	98
R/LAG151.32	131	RCKT -KM	165	SVHBR/L	100
R/LF123	123, 124, 127-129	RCKT -ML	165	SVJBR/L	100
R200	164	RCKT -MM	165	S...PCLNR/L	66
R245	149, 150	RCKT -PH	165	S...PDUNR/L	66
R245 -AL	150	RCKT -PM	165	S...PSKNR/L	66
R245 -KH	150	RCKT -WM	165	S...PTFNR/L	68
R245 -KL	150	RCMT	73, 79, 83, 85		
		RCMT -SM	91, 93		



Indeks

T		VBMT -KR	87	151.2	124, 125
TCGT -UM	93	VBMT -MF	77, 91	266R/LFG	135
TCGW...S	95	VBMT -MM	79, 93	266R/LG	134
TCGX -AL	89	VBMT -MR	81	266R/LKF	137
TCMT -KF	83	VBMT -PF	71	266R/LL	136
TCMT -KM	85	VBMT -PM	73	316	172-174
TCMT -KR	87	VBMT -PR	75	345	146
TCMT -MF	77, 91	VCGT -UM	91	345-KH	147
TCMT -MM	79, 93	VCGX -AL	89	345-KL	147
TCMT -MR	81	VCMW...FP	89	345-KM	147
TCMT -PF	71	VNGA S...	57	345-PH	147
TCMT -PM	73	VNGP	51	345-PL	147
TCMT -PR	75	VNMG -23	53	345-PM	147
TCMW...FLP	89	VNMG -KM	43, 45	490	152-154
TCMW...FP	89	VNMG -MF	33, 51	490-KH	155
TCMW...FRP	89	VNMG -MM	35	490-KM	155
TCMX -WF	71, 77, 83, 91	VNMG -PF	25	490-KL	155
TCMX -WM	73, 79, 85, 93	VNMG -PM	27	490-KL	155
TNGA S...	57	VNMG -QM	55	490-ML	155
TNGA T...	41, 43, 45	W		490-MM	155
TNMA -KR	47	WNGA S...	57	490-PH	155
TNMG -23	53	WNGA T...	43, 45	490-PL	155
TNMG -KF	41	WNGA T...AWH	57	490-PM	155
TNMG -KM	43, 45	WNGP	51	880	196, 198
TNMG -KR	49	WNMA -KR	47	880 -GM	197, 199
TNMG -MF	33	WNMG -23	53	880 -GR	197, 199
TNMG -MM	35	WNMG -KF	41	880-GT	197
TNMG -MR	37	WNMG -KM	43, 45	880 -LM	197, 199
TNMG -PF	25	WNMG -KR	49	880-MS	197, 199
TNMG -PM	27	WNMG -MF	33, 51		
TNMG -PR	29	WNMG -MM	35		
TNMG -QM	55	WNMG -MR	37		
TNMM -MR	39	WNMG -PF	25		
TNMM -PR	31	WNMG -PM	27		
TNMX -WF	25, 33, 41	WNMG -PR	29		
TNMX -WMX	27, 35, 43, 45	WNMG -QM	55		
TNMX -WR	31	WNMG -WF	25, 33, 41		
V		WNMG -WMX	27, 35, 43, 45		
VBGT -UM	91, 93	WNMM -MR	39		
VBGW...S	95				
VBMT -KF	83				
VBMT -KM	85				



Za dobrobit okoline, pridružite se Coromant-ovom konceptu reciklaže odmah.

„Coromant Recycling Concept (CRC)* - Coromant Koncept Reciklaže je servis za iskorišten tvrdi metal (uključujući i CBN i PCD ako je osnova tvrdi metal) i alate od integrisanog tvrdog metala koji nudimo svim svojim kupcima.

U svetlu povećane potrošnje neobnovljivih sirovina, ekonomsko upravljanje ovim resursima i reciklaža su obaveza svih proizvođača.

Sandvik Coromant ima važnu ulogu u otkupljivanju potrošenih pločica od tvrdog metala i alate od integrisanog tvrdog metala i reciklira ih po okolinu na najbezbedniji način.

Sve potrošene pločice od tvrdog metala se odlažu u kutiju za skupljanje na radnom mestu.

Napunjene kutije se šalju do najbliže kancelarije Sandvik Coromant-a ili vašem distributeru.

Popunjena kutija za transport se šalje u najbližu kancelariju Sandvik Coromant-a ili vašem dileru.

Dobiti pristupanjem CRC-u govore same za sebe

- Jedinstven svetski sistem reciklaže.
- Dostupan direktnim kupcima i kupcima dilera.
- Jednostavna procedura sa kutijama za prikupljanje i transport.
- Manji otpad, pomažući očuvanje čovekove okoline.
- Bolje iskorišćenje resursa.
- Prihvata se tvrdi metal i ostalih proizvođača.



Naručite kutiju za skupljanje za svaki strug, glodalicu, bušilicu ili vaš obradni centar. Preporučujemo vam posebno kutiju za skupljanje pločica, a posebno za skupljanje alata od integralnog tvrdog metala za svaki radni komad.

