Special Selection

The revolution in wear identification
Die Revolution in der Einsatzerkennung

ZCC Cutting Tools Europe GmbH

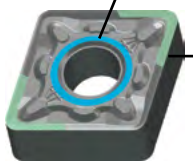
your Partner \ your Value

Advantage *Vorteil* 1 — Easy assignment of inserts for the application field

Sehr leichte Zuordnung der Wendeschneidplatten nach ihrem Anwendungsbereich

Which insert for finishing (P15), what insert for roughing (P25) ?
Which insert for steel (P), what insert for stainless steel (M) ?

Welche Platte ist zum Schlichten (P15), welche zum Schruppen (P25)?
Welche Platte ist für Stahl (P), welche ist für rostfreien Stahl (M) ?



The colour of the inner ring indicates the application range (P/M/K).
Die Farbe des Mittelrings gibt den Anwendungsbereich (P/M/K) an.

The colour of the cutting edge indicates the grade, such as P15.
Die Farbe der Schneidkanten gibt den Sortenbereich z.B. P15 an.

Conventional insert
Konventionelle Platte

ZCC-CT

Easy choice on the basis of the table without any further knowledge and without looking at the insert box. / *Einfache Auswahl anhand der Tabelle ohne große Kenntnisse über die Sorten und ohne Verpackung möglich.*

YBC052F		
YBC152F	YBM153F	
YBC252F	YBM253F	
YBC352F		

For wet condition recommended / *Für Nassbearbeitung empfohlen*

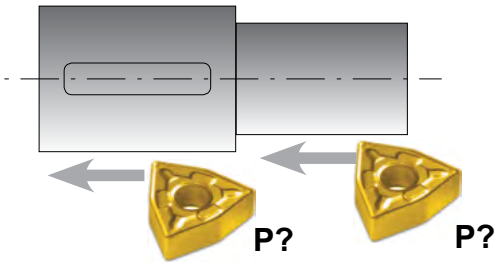
Advantage *Vorteil* 2 — Using same inserts size and chip breaker but different grades (P15/P25)

Einsatz von gleichen Plattengrößen und Spanbrechern, aber unterschiedlichen Sorten (P15 / P25)

Interrupted cut: Tougher grade, production security → using P25 grade
Continous cut: More wear resistant grade, higher tool life, productivity → using P15 grade

Schnittunterbrechung: Zähere Sorte, Prozesssicherheit → Verwendung einer P25 Sorte
Glattschnitt: Verschleißfestere Sorte, höhere Standzeit, Produktivität → Verwendung einer P15 Sorte

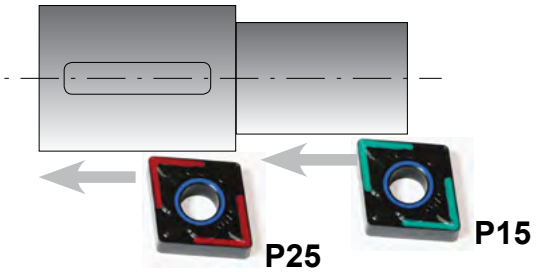
Conventional insert
Konventionelle Platte



Conventional inserts look the same
Konventionelle Platte sehen absolut gleich aus

Confusion possible!
Verwechslungsgefahr !

ZCC-CT



No confusion
eindeutige Zuordnung

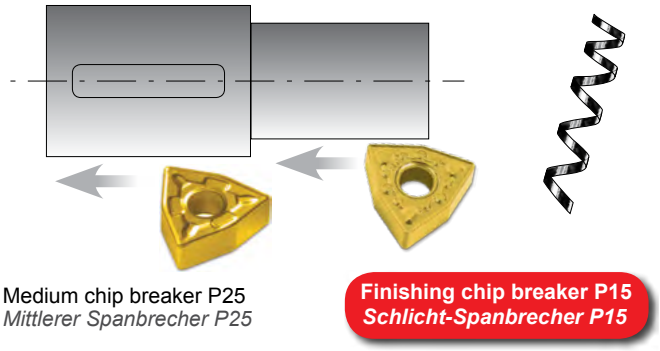
Advantage *Vorteil* 3

High productivity by using optimal grade and chip breaker combination
Hohe Produktivität durch den Einsatz der optimalen Sorte und Spanbrecher-Kombination

Condition: For both operations medium feed rate and depth of cut
Solution competitor: Different chip breaker as distinguishing feature

Bedingungen: Für beide Operationen mittlere Vorschubswerte und Schnitttiefen
Lösung Wettbewerb: Unterschiedliche Spanbrecher als Unterscheidungsmerkmal

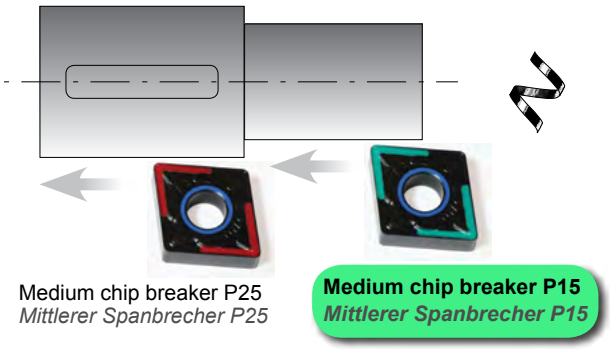
Conventional insert: Room for improvement
Konventionelle Platte: *Verbesserungspotential*



Long chips = Problems with chip evacuation for measuring, danger for operator

Lange Späne = Probleme bei der Spanabfuhr für die Messeinrichtung und Gefahr für den Bediener

ZCC-CT: Best solution!
Optimale Lösung!



Best chip control, no problems
Optimaler Spankontrolle, keine Probleme

Advantage *Vorteil* 4

100% utilisation of all edges
100% Ausnutzung aller Schneidecken

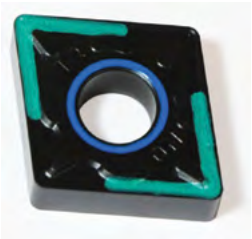
Conventional insert:
Konventionelle Platte:

After using some edges of insert it is not possible to recognise which edge is used and which not

Nach dem Einsatz einiger Scheidecken ist bei herkömmlichen Platten nicht mehr eindeutig zu erkennen, welche Schneide schon im Einsatz war und welche nicht.

Result: ~ 30% of edges not used and thrown away
Ergebnis: ca 30% der Schneidecken an einer Platte werden nicht genutzt.

ZCC-CT:



Insert before operation
Platte vor der Bearbeitung

Insert after operation with one edge
Platte nach der Bearbeitung mit einer Schneidecke

Because of ZCC-CT colour coating it is easy to recognise which edge is used.

Durch die Farbbeschichtung ist eindeutig zu erkennen, welche Schneidecke schon im Einsatz war.

Result: 100% of the edges of an insert are used.
Ergebnis: 100% der Schneidecken an einer Platte werden genutzt.

Change now to ZCC-CT
Wechseln Sie jetzt auf ZCC-CT

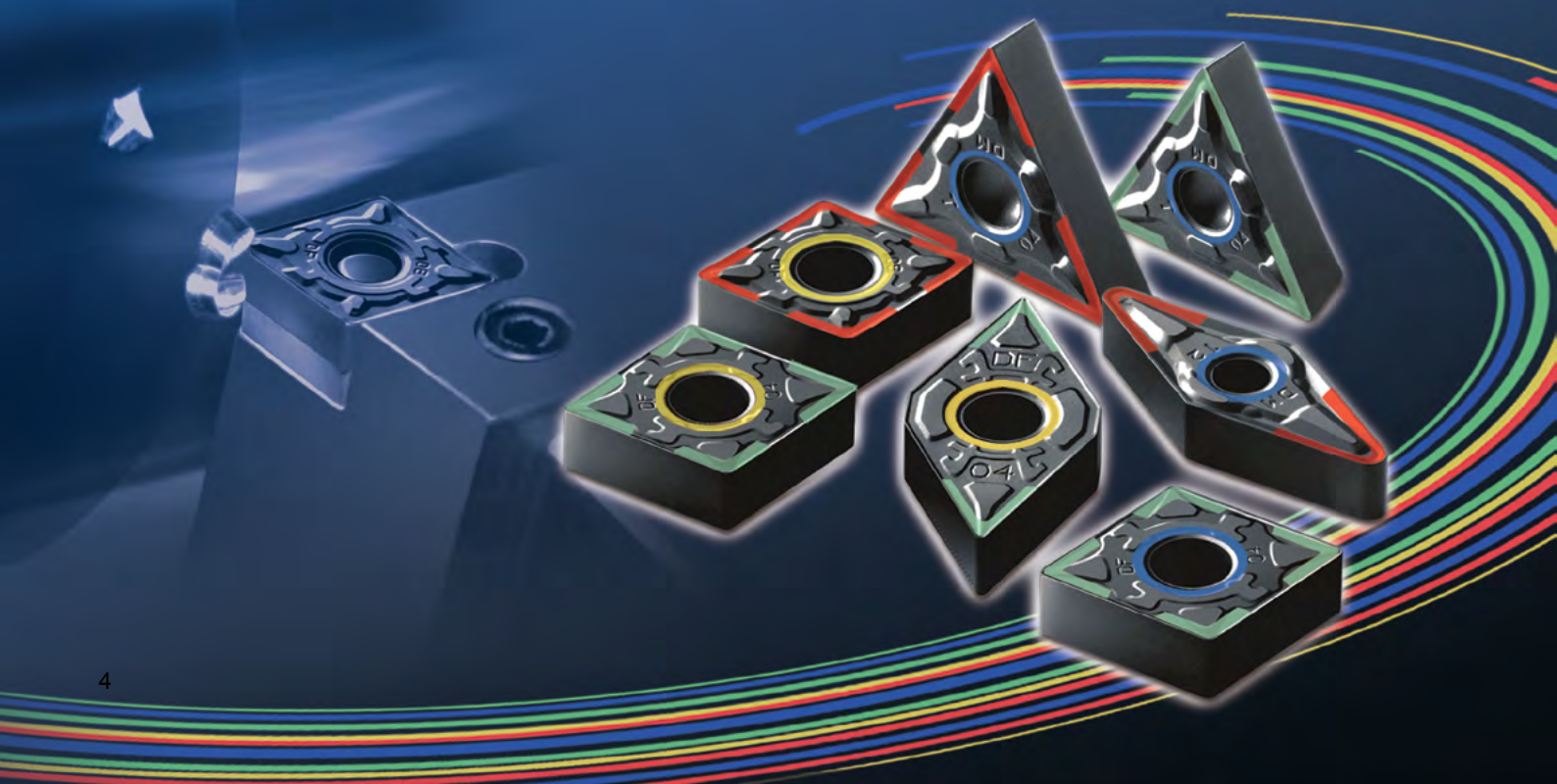
Simply coloured

Easy handling
Einfache Bedienung

Higher production security
Höhere Prozesssicherheit

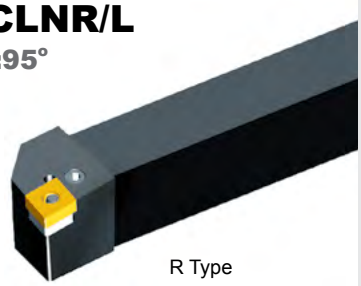
Higher Productivity
Höhere Produktivität

Optimal usage of tools
Optimaler Einsatz der Produkte

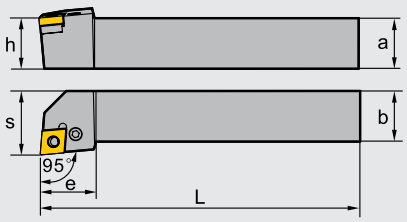


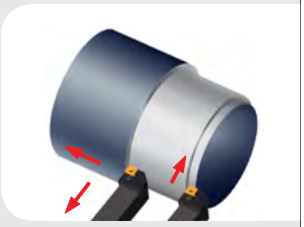
PCLNR/L

Kr:95°

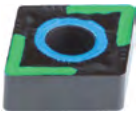


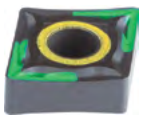
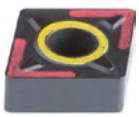
R Type
Rechtsausführung





Type		Stock		Dimension (mm)						Screw	Shim	Wrench	Lever	Shim pin
		R	L	a	b	L	h	s	e					
PCLNR/L	2020K12	●	●	20	20	125	20	25	28	LEM8×21	C12AP	WH30L	L4	SP4
	2525M12	●	●	25	25	150	25	32	28					

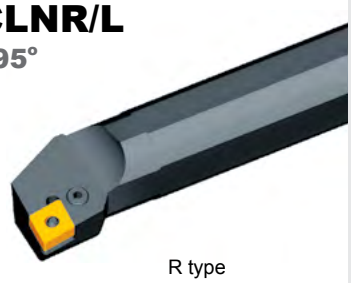
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**CNMG 120408-DF YBC152F** 	230m/min (160-300)	**CNMG 120408-DM YBC252F**
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 1.5mm *Schnitttiefe (ap) 0,2 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.5 - 3.5mm *Schnitttiefe (ap) 0,5 - 3,5mm* Feed rate (F) = 0.2 - 0.5 mm/rev *Vorschub (F) = 0,2 - 0,5 mm/U*

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**CNMG 120408-EF YBM153F** 	160m/min (140-200)	**CNMG 120408-EM YBM253F** 
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 1.5mm *Schnitttiefe (ap) 0,2 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.5 - 3.0mm *Schnitttiefe (ap) 0,5 - 3,0mm* Feed rate (F) = 0.12 - 0.28 mm/rev *Vorschub (F) = 0,12 - 0,28 mm/U*

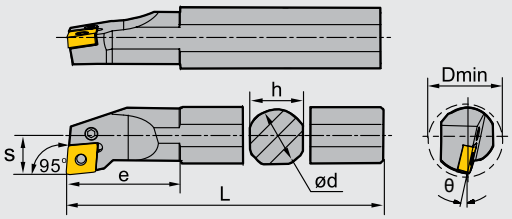
● Ex Stock / ab Lager ○ On demand / auf Anfrage

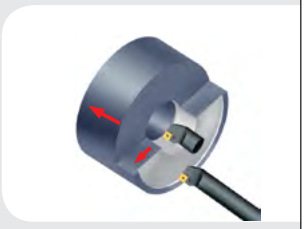
PCLNR/L

Kr:95°

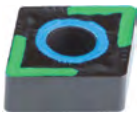
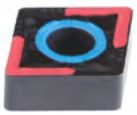


R type
Rechtsausführung





Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Lever Kniehebel	Shim Unterlage	Shim pin Rohrstift
	R	L	Dmin	ød	h	L	S	θ	e					
S25T- PCLNR/L12	●	●	32	25	23	300	17	-12°	40	LEM6×13.4A	WH25L	L4A	——	——
S32U-PCLNR/L12	●	●	44	32	30	350	22	-10°	50	LEM8×21	WH30L	L4	C12APB	SP4

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**CNMG 120408-DF YBC152F** 	230m/min (160-300)	**CNMG 120408-DM YBC252F** 
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
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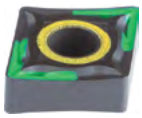
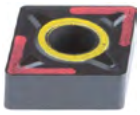
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**CNMG 120408-EF YBM153F** 	160m/min (140-200)	**CNMG 120408-EM YBM253F** 
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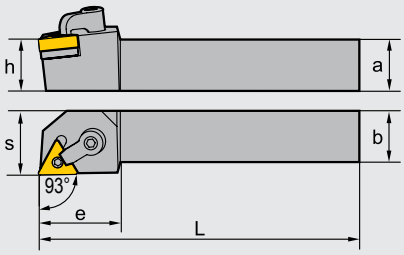
● Ex Stock / ab Lager ○ On demand / auf Anfrage

MTJNR/L

Kr:93°

R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passstift
		R	L	a	b	L	h	s	e					
MTJNR/L	2020K16	●	○	20	20	125	20	25	32	DM6×25	T16BM	WH20L WH30L	C1RD	TM5×13
	2525M16	●	●	25	25	150	25	32	32	DM6×30				

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**TNMG 160408-DF YBC152F**	230m/min (160-300)	**TNMG 160408-DM YBC252F**
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 1.5mm *Schnittiefe (ap) 0,2 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.5 - 3.0mm *Schnittiefe (ap) 0,5 - 3,0mm* Feed rate (F) = 0.2 - 0.5 mm/rev *Vorschub (F) = 0,2 - 0,5 mm/U*

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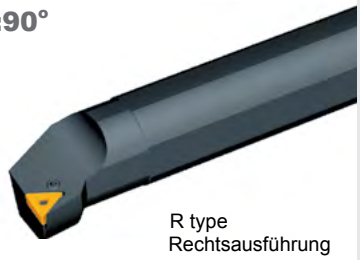
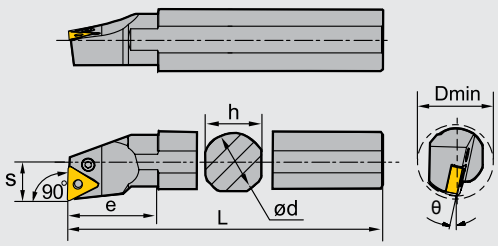
● Ex Stock / ab Lager ○ On demand / auf Anfrage

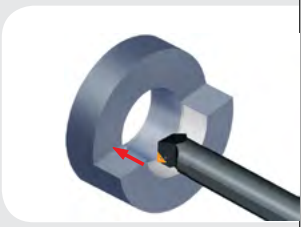
PTFNR/L

Kr:90°



R type
Rechtsausführung





Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Lever Kniehebel	Shim Unterlage	Shim pin Rohrstift
	R	L	Dmin	ød	h	L	S	θ	e					
S25T-PTFNR/L16	●	●	32	25	23	300	17	-12°	42	LEM5×12B	WH20L	L3B	——	——
S32U-PTFNR/L16	●	●	44	32	30	350	22	-10°	50	LEM6×17	WH25L	L3	T16APB	SP3

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
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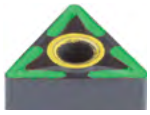
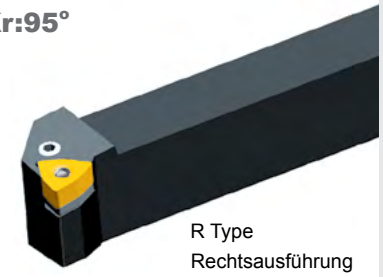
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 1.5mm *Schnittiefe (ap) 0,2 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.5 - 3.0mm *Schnittiefe (ap) 0,5 - 3,0mm* Feed rate (F) = 0.2 - 0.5 mm/rev *Vorschub (F) = 0,2 - 0,5 mm/U*

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**TNMG 160408-EF YBM153F** 	160m/min (140-200)	**TNMG 160408-EM YBM253F**
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 1.5mm *Schnittiefe (ap) 0,2 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.5 - 3.0mm *Schnittiefe (ap) 0,5 - 3,0mm* Feed rate (F) = 0.12 - 0.28 mm/rev *Vorschub (F) = 0,12 - 0,28 mm/U*

● Ex Stock / ab Lager ○ On demand / auf Anfrage

PWLNR/L

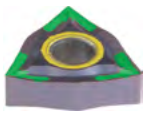
Kr:95°



R Type
Rechtsausführung

Type Typ		Stock Lager R	Stock Lager L	Dimension (mm) Abmessung a	b	L	h	s	e	Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift
PWLNR/L	2020K08	●	●	20	20	125	20	25	26	LEM8×21	W08AP	WH30L	L4	SP4
	2525M08	●	●	25	25	150	25	32	26					

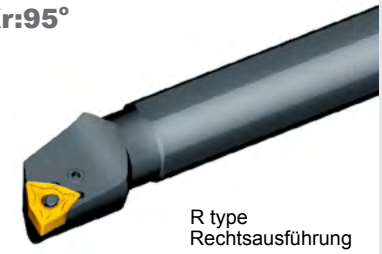
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**WNMG 080408-DF YBC152F**	230m/min (160-300)	**WNMG 080408-DM YBC252F**
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 1.5mm *Schnitttiefe (ap) 0,2 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.5 - 3.0mm *Schnitttiefe (ap) 0,5 - 3,0mm* Feed rate (F) = 0.2 - 0.5 mm/rev *Vorschub (F) = 0,2 - 0,5 mm/U*

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**WNMG 080408-EF YBM153F** 	160m/min (140-200)	**WNMG 080408-EM YBM253F**
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 1.5mm *Schnitttiefe (ap) 0,2 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.5 - 3.0mm *Schnitttiefe (ap) 0,5 - 3,0mm* Feed rate (F) = 0.12 - 0.28 mm/rev *Vorschub (F) = 0,12 - 0,28 mm/U*

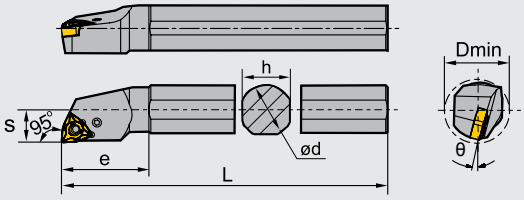
● Ex Stock / ab Lager ○ On demand / auf Anfrage

PWLNR/L

Kr:95°

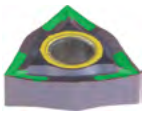


R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Lever Kniehebel	Shim Unterlage	Shim pin Rohrstift
	R	L	Dmin	ød	h	L	S	θ	e					
S25T-PWLNR/L08	●	○	32	25	23	300	17	-13°	45	LEM6X13.4A	WH25L	L4A	——	——
S32U-PWLNR/L08	●	●	40	32	30	350	22	-15°	50	LEM8X21	WH30L	L4	W08AP	SP4

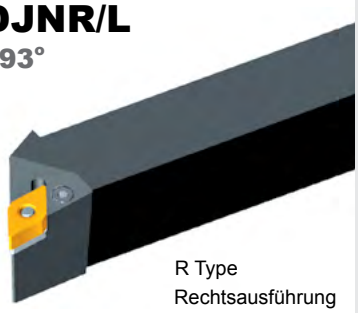
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**WNMG 080408-DF YBC152F**	230m/min (160-300)	**WNMG 080408-DM YBC252F**
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 1.5mm *Schnittiefe (ap) 0,2 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.5 - 3.0mm *Schnittiefe (ap) 0,5 - 3,0mm* Feed rate (F) = 0.2 - 0.5 mm/rev *Vorschub (F) = 0,2 - 0,5 mm/U*

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**WNMG 080408-EF YBM153F** 	160m/min (140-200)	**WNMG 080408-EM YBM253F**
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 1.5mm *Schnittiefe (ap) 0,2 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.5 - 3.0mm *Schnittiefe (ap) 0,5 - 3,0mm* Feed rate (F) = 0.12 - 0.28 mm/rev *Vorschub (F) = 0,12 - 0,28 mm/U*

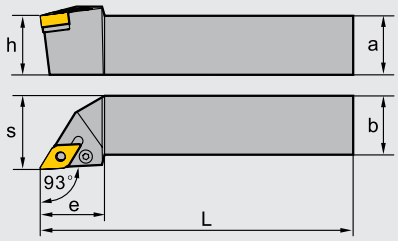
● Ex Stock / ab Lager ○ On demand / auf Anfrage

PDJNR/L

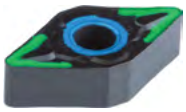
Kr:93°

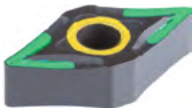


R Type
Rechtsausführung



Type Typ		Stock Lager R	Stock Lager L	Dimension (mm) Abmessung a	b	L	h	s	e	Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift
PDJNR/ L	**2020K15**	●	●	20	20	125	20	25	35	LEM8×21	D15AP	WH30L	L4B	SP4
	2525M15	●	●	25	25	150	25	32	35					

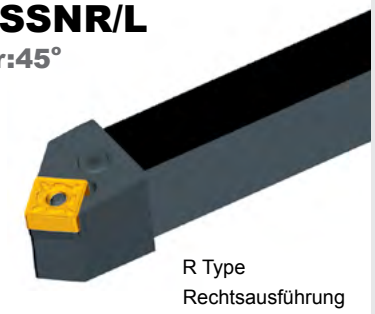
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**DNMG 150608-DF YBC152F** 	230m/min (160-300)	**DNMG 150608-DM YBC252F**
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 1.5mm *Schnitttiefe (ap) 0,2 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.5 - 3.0mm *Schnitttiefe (ap) 0,5 - 3,0mm* Feed rate (F) = 0.2 - 0.5 mm/rev *Vorschub (F) = 0,2 - 0,5 mm/U*

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**DNMG 150608-EF YBM153F** 	160m/min (140-200)	**DNMG 150608-EM YBM253F**
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 1.5mm *Schnitttiefe (ap) 0,2 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.5 - 3.0mm *Schnitttiefe (ap) 0,5 - 3,0mm* Feed rate (F) = 0.12 - 0.28 mm/rev *Vorschub (F) = 0,12 - 0,28 mm/U*

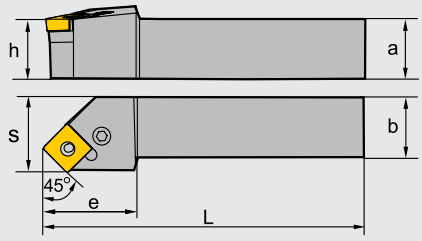
● Ex Stock / ab Lager ○ On demand / auf Anfrage

PSSNR/L

Kr:45°

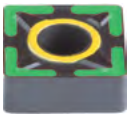


R Type
Rechtsausführung



Type Typ		Stock Lager R	Stock Lager L	Dimension (mm) Abmessung a	b	L	h	s	e	Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift
PSSNR/L	**2020K12**	●	●	20	20	125	20	25	30	LEM8×21	S12AP	WH30L	L4	SP4
	2525M12	●	●	25	25	150	25	32	30					

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**SNMG 120408-DF YBC152F**	230m/min (160-300)	**SNMG 120408-DM YBC252F**
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.5 - 2.0mm *Schnitttiefe (ap) 0,5 - 2,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 1.0 - 4.5mm *Schnitttiefe (ap) 1,0 - 4,5mm* Feed rate (F) = 0.2 - 0.5 mm/rev *Vorschub (F) = 0,2 - 0,5 mm/U*

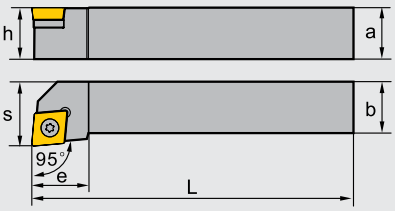
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**SNMG 120408-EF YBM153F** 	160m/min (140-200)	**SNMG 120408-EM YBM253F**
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.4 - 1.5mm *Schnitttiefe (ap) 0,4 - 1,5mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.5 - 3.0mm *Schnitttiefe (ap) 0,5 - 3,0mm* Feed rate (F) = 0.12 - 0.28 mm/rev *Vorschub (F) = 0,12 - 0,28 mm/U*

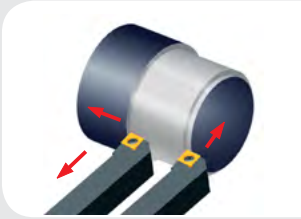
● Ex Stock / ab Lager ○ On demand / auf Anfrage

SCLCR/L

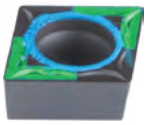
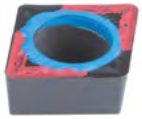
Kr:95°

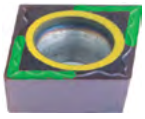
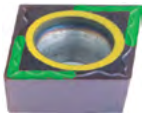
R Type
Rechtsausführung





Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
SCLCR/L	**0808D06**	●	●	08	08	60	08	10	10	I60M2.5×6.5	—	—	WT07IP
	1010E06	●	●	10	10	70	10	12	10				

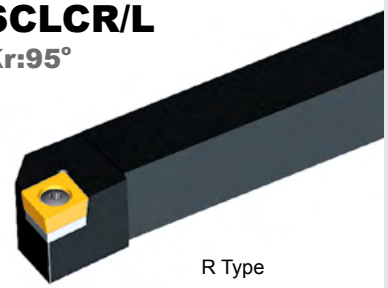
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**CCMT 060204-HF YBC152F** 	230m/min (160-300)	**CCMT 060208-HM YBC252F** 
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 1.0mm *Schnitttiefe (ap) 0,2 - 1,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.4 - 2.0mm *Schnitttiefe (ap) 0,4 - 2,0mm* Feed rate (F) = 0.2 - 0.3 mm/rev *Vorschub (F) = 0,2 - 0,3 mm/U*

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**CCMT 060204-EF YBM153F** 	160m/min (140-200)	**CCMT 060208-EM YBM153F** 
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 1.0mm *Schnitttiefe (ap) 0,2 - 1,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.4 - 1.5mm *Schnitttiefe (ap) 0,4 - 1,5mm* Feed rate (F) = 0.1 - 0.25 mm/rev *Vorschub (F) = 0,1 - 0,25 mm/U*

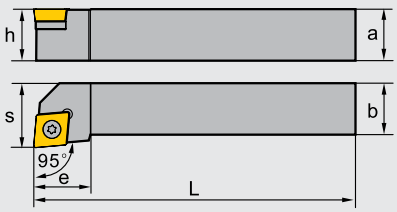
● Ex Stock / ab Lager ○ On demand / auf Anfrage

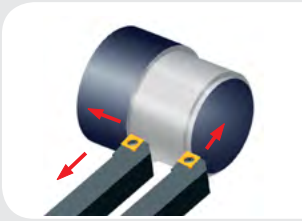
SCLCR/L

Kr:95°

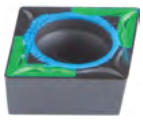


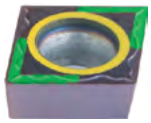
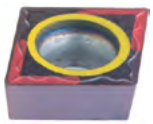
R Type
Rechtsausführung





Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
SCLCR/L	**1212F09**	●	●	12	12	80	12	16	16	I60M3.5×8	—	—	WT15IP
	1616H09	●	●	16	16	100	16	20	16				
	2020K09	●	●	20	20	125	20	25	25	I60M4×11X	C12BS	SM6×10XA	WT15IP WH40L

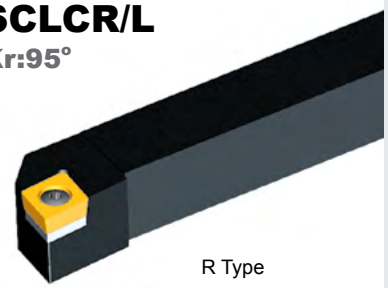
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** ***Schlichten - Mittlere Bearbeitung***	Vc m/min	**Mittlere Bearbeitung - Roughing** ***Mittlere Bearbeitung - Schruppen***
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**CCMT 09T308-HF YBC152F** 	230m/min (160-300)	**CCMT 09T308-HM YBC252F**
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 2.0mm *Schnitttiefe (ap) 0,2 - 2,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.4 - 3.0mm *Schnitttiefe (ap) 0,4 - 3,0mm* Feed rate (F) = 0.2 - 0.5 mm/rev *Vorschub (F) = 0,2 - 0,5 mm/U*

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** ***Schlichten - Mittlere Bearbeitung***	Vc m/min	**Mittlere Bearbeitung - Roughing** ***Mittlere Bearbeitung - Schruppen***
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**CCMT 09T308-EF YBM153F** 	160m/min (140-200)	**CCMT 09T308-EM YBM253F** 
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 2.0mm *Schnitttiefe (ap) 0,2 - 2,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.4 - 2.5mm *Schnitttiefe (ap) 0,4 - 2,5mm* Feed rate (F) = 0.1 - 0.25 mm/rev *Vorschub (F) = 0,1 - 0,25 mm/U*

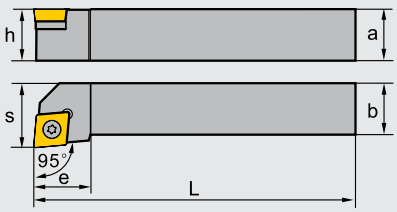
● Ex Stock / ab Lager ○ On demand / auf Anfrage

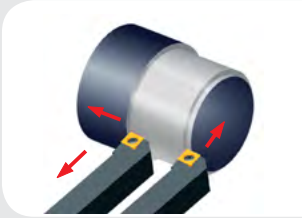
SCLCR/L

Kr:95°

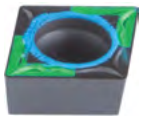
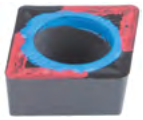


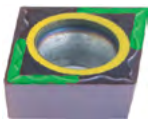
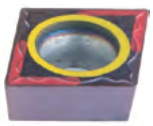
R Type
Rechtsausführung





Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
SCLCR/L	**2020K12**	●	●	20	20	125	20	25	25	I60M4×11X	C12BS	SM6×10XA	WT15IP WH40L
	2525M12	●	●	25	25	150	25	32	26				

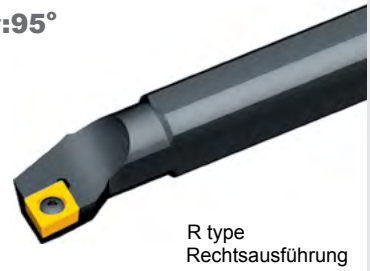
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** ***Schlichten - Mittlere Bearbeitung***	Vc m/min	**Mittlere Bearbeitung - Roughing** ***Mittlere Bearbeitung - Schruppen***
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**CCMT 120408-HF YBC152F** 	230m/min (160-300)	**CCMT 120408-HM YBC252F** 
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 2.0mm *Schnittiefe (ap) 0,2 - 2,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.4 - 3.0mm *Schnittiefe (ap) 0,4 - 3,0mm* Feed rate (F) = 0.2 - 0.3 mm/rev *Vorschub (F) = 0,2 - 0,3 mm/U*

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** ***Schlichten - Mittlere Bearbeitung***	Vc m/min	**Mittlere Bearbeitung - Roughing** ***Mittlere Bearbeitung - Schruppen***
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**CCMT 120408-EF YBM153F** 	160m/min (140-200)	**CCMT 120408-EM YBM253F** 
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 2.0mm *Schnittiefe (ap) 0,2 - 2,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.4 - 2.5mm *Schnittiefe (ap) 0,4 - 2,5mm* Feed rate (F) = 0.1 - 0.25 mm/rev *Vorschub (F) = 0,1 - 0,25 mm/U*

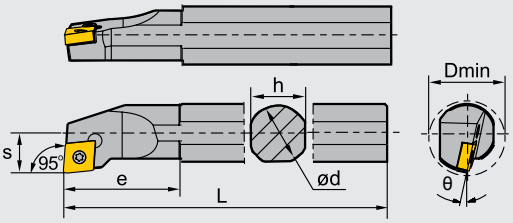
● Ex Stock / ab Lager ○ On demand / auf Anfrage

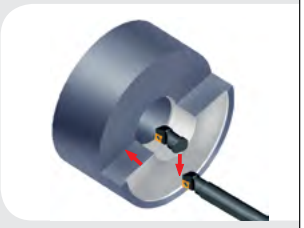
SCLCR/L

Kr:95°

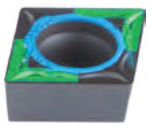
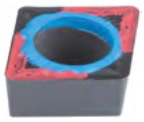


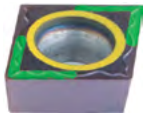
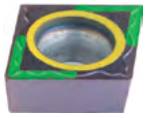
R type
Rechtsausführung





Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim Unterlage Schraube
	R	L	Dmin	ød	h	L	S	θ	e				
S08K-SCLCR/L06	●	●	10	8	7	125	5	-15°	14	I60M2.5×5.5	WT07IP	—	—
S10M-SCLCR/L06	●	●	12	10	9	150	6	-13°	14				
S12M-SCLCR/L06	●	●	16	12	11	150	9	-10°	25				

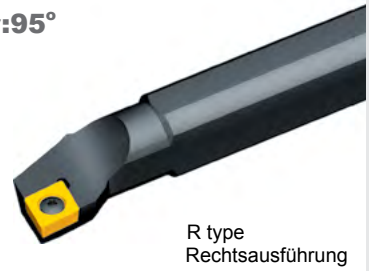
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**CCMT 060204-HF YBC152F** 	230m/min (160-300)	**CCMT 060208-HM YBC252F** 
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 1.0mm *Schnitttiefe (ap) 0,2 - 1,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.4 - 2.0mm *Schnitttiefe (ap) 0,4 - 2,0mm* Feed rate (F) = 0.2 - 0.3 mm/rev *Vorschub (F) = 0,2 - 0,3 mm/U*

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**CCMT 060204-EF YBM153F** 	160m/min (140-200)	**CCMT 060208-EM YBM153F** 
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 1.0mm *Schnitttiefe (ap) 0,2 - 1,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.4 - 1.5mm *Schnitttiefe (ap) 0,4 - 1,5mm* Feed rate (F) = 0.1 - 0.25 mm/rev *Vorschub (F) = 0,1 - 0,25 mm/U*

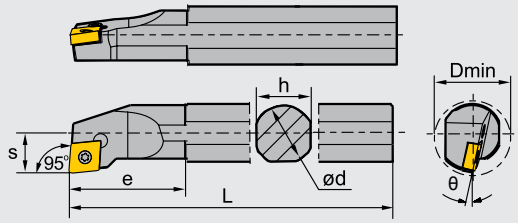
● Ex Stock / ab Lager ○ On demand / auf Anfrage

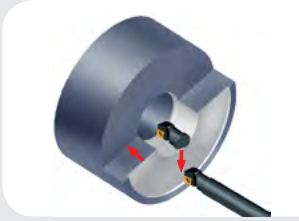
SCLCR/L

Kr:95°

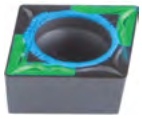
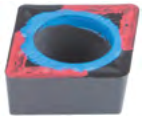


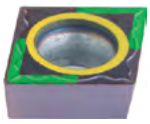
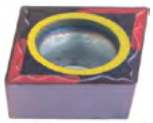
R type
Rechtsausführung





Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim Unterlage Schraube
	R	L	Dmin	ød	h	L	S	θ	e				
S12M-SCLCR/L09	●	●	16	12	11	150	9	-10°	25	I60M3.5×8	WT15IP	—	—
S16R-SCLCR/L09	●	●	20	16	15	200	11	-12°	32.5				
S20S-SCLCR/L09	●	●	25	20	18	250	13	-8°	38				
S25T-SCLCR/L09	●	●	32	25	23	300	17	-6°	45	I60M3.5×10	WT15IP	—	—

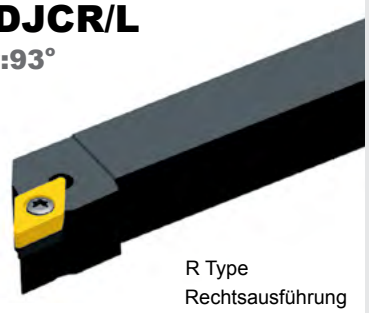
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**CCMT 09T308-HF YBC152F** 	230m/min (160-300)	**CCMT 09T308-HM YBC252F** 
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 2.0mm *Schnitttiefe (ap) 0,2 - 2,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.4 - 3.0mm *Schnitttiefe (ap) 0,4 - 3,0mm* Feed rate (F) = 0.2 - 0.5 mm/rev *Vorschub (F) = 0,2 - 0,5 mm/U*

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**CCMT 09T308-EF YBM153F** 	160m/min (140-200)	**CCMT 09T308-EM YBM253F** 
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 2.0mm *Schnitttiefe (ap) 0,2 - 2,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.4 - 2.5mm *Schnitttiefe (ap) 0,4 - 2,5mm* Feed rate (F) = 0.1 - 0.25 mm/rev *Vorschub (F) = 0,1 - 0,25 mm/U*

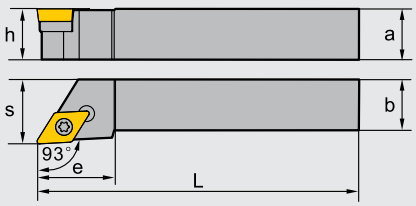
● Ex Stock / ab Lager ○ On demand / auf Anfrage

SDJCR/L

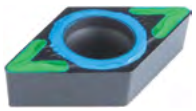
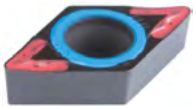
Kr:93°

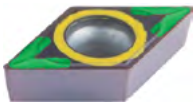
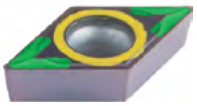


R Type
Rechtsausführung



Type Typ		Stock Lager R	Stock Lager L	Dimension (mm) Abmessung a	b	L	h	s	e	Screw Schraube	Shim Unterlage	Shim Screw,Unterlage Schraube	Wrench Schlüssel
SDJCR/L	**1010E07**	●	●	10	10	70	10	12	15	I60M2.5×6.5	—	—	WT07IP
	1212F07	●	●	12	12	80	12	16	15				
	1616H07	●	●	16	16	100	16	20	18				

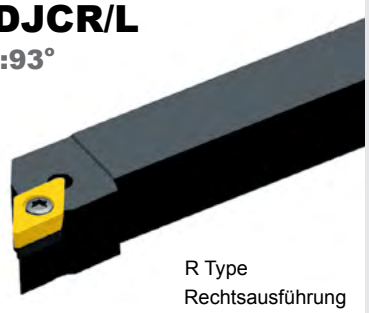
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**DCMT 070208-HF YBC152F**  depth of cut (ap) 0.2 - 1.0mm *Schnittiefe (ap) 0,2 - 1,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	230m/min (160-300)	**DCMT 070208-HM YBC252F**  depth of cut (ap) 0.4 - 2.0mm *Schnittiefe (ap) 0,4 - 2,0mm* Feed rate (F) = 0.2 - 0.3 mm/rev *Vorschub (F) = 0,2 - 0,3 mm/U*
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)		130m/min (110-150)	

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**DCMT 070204-EF YBM153F**  depth of cut (ap) 0.2 - 1.0mm *Schnittiefe (ap) 0,2 - 1,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	160m/min (140-200)	**DCMT 070208-EM YBM153F**  depth of cut (ap) 0.4 - 1.5mm *Schnittiefe (ap) 0,4 - 1,5mm* Feed rate (F) = 0.1 - 0.25 mm/rev *Vorschub (F) = 0,1 - 0,25 mm/U*
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	

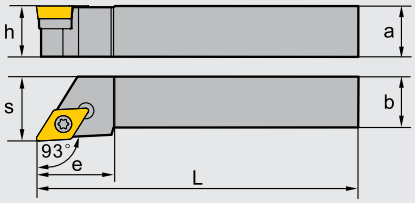
● Ex Stock / ab Lager ○ On demand / auf Anfrage

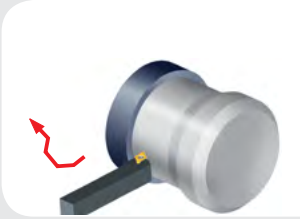
SDJCR/L

Kr:93°

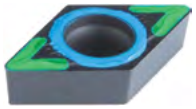
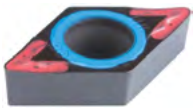


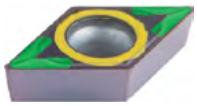
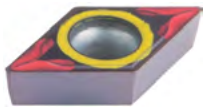
R Type
Rechtsausführung





Type Typ		Stock Lager R	Stock Lager L	Dimension (mm) Abmessung a	b	L	h	s	e	Screw Schraube	Shim Unterlage	Shim Screw,Unterlage Schraube	Wrench Schlüssel
SDJCR/L	**1616H11**	●	●	16	16	100	16	20	24	I60M3.5×12	D11BS	SM5×8.65XA	WT15IP WH35L
	2020K11	●	●	20	20	125	20	25	24				
	2525M11	●	●	25	25	150	25	32	29				

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**DCMT 11T308-HF YBC152F** 	230m/min (160-300)	**DCMT 11T308-HM YBC252F** 
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 2.0mm *Schnitttiefe (ap) 0,2 - 2,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.4 - 3.0mm *Schnitttiefe (ap) 0,4 - 3,0mm* Feed rate (F) = 0.2 - 0.3 mm/rev *Vorschub (F) = 0,2 - 0,3 mm/U*

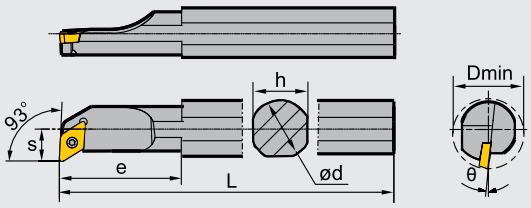
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**DCMT 11T308-EF YBM153F** 	160m/min (140-200)	**DCMT 11T308-EM YBM253F** 
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 2.0mm *Schnitttiefe (ap) 0,2 - 2,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.4 - 2.5mm *Schnitttiefe (ap) 0,4 - 2,5mm* Feed rate (F) = 0.1 - 0.25 mm/rev *Vorschub (F) = 0,1 - 0,25 mm/U*

● Ex Stock / ab Lager ○ On demand / auf Anfrage

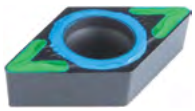
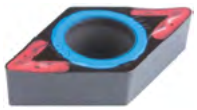
SDUCR/L

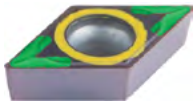
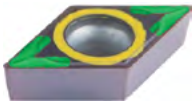
Kr:93°

R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	h	L	S	θ	e				
S10M-SDUCR/L07	●	●	13	10	9	150	7	-8°	0	I60M2.5×5.5	WT07IP		
S12M-SDUCR/L07	●	●	16	12	11	150	9	-8°	22	I60M2.5×6.5			
S16M-SDUCR/L07	●	●	20	16	15	150	11	-6°	27				

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**DCMT 070208-HF YBC152F** 	230m/min (160-300)	**DCMT 070208-HM YBC252F** 
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 1.0mm *Schnitttiefe (ap) 0,2 - 1,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.4 - 2.0mm *Schnitttiefe (ap) 0,4 - 2,0mm* Feed rate (F) = 0.2 - 0.3 mm/rev *Vorschub (F) = 0,2 - 0,3 mm/U*

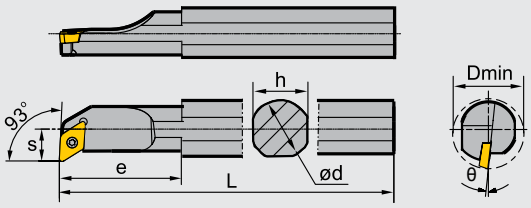
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**DCMT 070204-EF YBM153F** 	160m/min (140-200)	**DCMT 070208-EM YBM153F** 
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 1.0mm *Schnitttiefe (ap) 0,2 - 1,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.4 - 1.5mm *Schnitttiefe (ap) 0,4 - 1,5mm* Feed rate (F) = 0.1 - 0.25 mm/rev *Vorschub (F) = 0,1 - 0,25 mm/U*

● Ex Stock / ab Lager ○ On demand / auf Anfrage

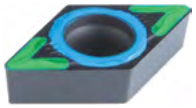
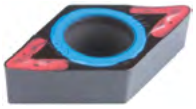
SDUCR/L

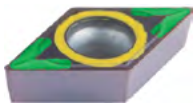
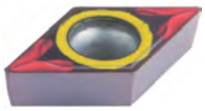
Kr:93°

R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	h	L	S	θ	e				
S20Q-SDUCR/L11	●	●	25	20	18	180	13	-6°	40	I60M3.5×8	WT15IP		
S25T-SDUCR/L11	●	●	32	25	23	300	17	-6°	46	I60M3.5×10			

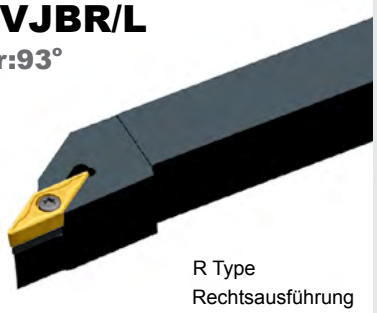
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**DCMT 11T308-HF YBC152F** 	230m/min (160-300)	**DCMT 11T308-HM YBC252F** 
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 2.0mm *Schnittiefe (ap) 0,2 - 2,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.4 - 3.0mm *Schnittiefe (ap) 0,4 - 3,0mm* Feed rate (F) = 0.2 - 0.3 mm/rev *Vorschub (F) = 0,2 - 0,3 mm/U*

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**DCMT 11T308-EF YBM153F** 	160m/min (140-200)	**DCMT 11T308-EM YBM253F** 
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 2.0mm *Schnittiefe (ap) 0,2 - 2,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.4 - 2.5mm *Schnittiefe (ap) 0,4 - 2,5mm* Feed rate (F) = 0.1 - 0.25 mm/rev *Vorschub (F) = 0,1 - 0,25 mm/U*

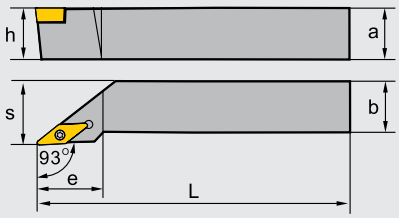
● Ex Stock / ab Lager ○ On demand / auf Anfrage

SVJBR/L

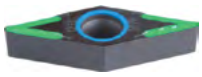
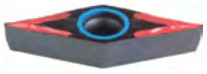
Kr:93°

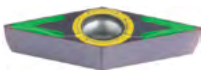
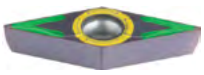


R Type
Rechtsausführung



Type Typ		Stock Lager R	Stock Lager L	Dimension (mm) Abmessung a	b	L	h	s	e	Screw Schraube	Shim Unterlage	Shim Screw,Unterlage Schraube	Wrench Schlüssel
SVJBR/L	**1616H16**	●	●	16	16	100	16	20	36	I60M3.5×12	V16BS	SM5×8.65XA	WT15IP WH35L
	2020K16	●	●	20	20	125	20	25	41				
	2525M16	●	●	25	25	150	25	32	41				

Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Steel Stahl	Carbon steel *Unlegierter Stahl* ST37 ST52/3	260m/min (180-320)	**VBMT 160404-HM YBC152F** 	230m/min (160-300)	**VBMT 160408-HM YBC252F** 
	Low alloy steel *Niedrig legierter Stahl* C45 C60	220m/min (180-260)		200m/min (170-230)	
	High alloy steel *Hochlegierter Stahl* 36CrNiMo4 42CrMo4	160m/min (140-180)	depth of cut (ap) 0.2 - 1.0mm *Schnitttiefe (ap) 0,2 - 1,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*	130m/min (110-150)	depth of cut (ap) 0.4 - 2.0mm *Schnitttiefe (ap) 0,4 - 2,0mm* Feed rate (F) = 0.2 - 0.3 mm/rev *Vorschub (F) = 0,2 - 0,3 mm/U*

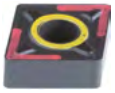
Material *Werkstoffe*		Vc m/min	**Finishing - Mittlere Bearbeitung** *Schlichten - Mittlere Bearbeitung*	Vc m/min	**Mittlere Bearbeitung - Roughing** *Mittlere Bearbeitung - Schruppen*
Stainless Steel Rostfreier Stahl	Stainless steel Martensite·Ferrite *Rostfreier Stahl Ferritisch / Martensitisch* X6Cr13 - X12CrS13 - X20Cr13	180m/min (160-240)	**VBMT 160404-EF YBM153F** 	160m/min (140-200)	**VBMT 160408-EM YBM153F** 
	Stainless steel Austenite *Rostfreier Stahl Austenitisch* X8CrNiS18-9 - X5CrNi18-10 - X5CrNiMo17-12-2	160m/min (140-200)		120m/min (100-140)	
			depth of cut (ap) 0.2 - 1.0mm *Schnitttiefe (ap) 0,2 - 1,0mm* Feed rate (F) = 0.05 - 0.2 mm/rev *Vorschub (F) = 0,05 - 0,2 mm/U*		depth of cut (ap) 0.4 - 1.5mm *Schnitttiefe (ap) 0,4 - 1,5mm* Feed rate (F) = 0.1 - 0.25 mm/rev *Vorschub (F) = 0,1 - 0,25 mm/U*

● Ex Stock / ab Lager ○ On demand / auf Anfrage

SET DCLNR/L 95°

Tool holder, 20 inserts and cutting data in case

Klemmhalter, 20 Wendeplatten und Schnittdaten im Koffer



Material Number Artikelnummer	Content Inhalt
SET DCLNR/L 2020 K12	1 x DCLNR/L 2020 K12 10 x CNMG 120408 DM YBC252F 10 x CNMG 120408 EM YBM253F
SET DCLNR/L 2525 M12	1 x DCLNR/L 2525 M12 10 x CNMG 120408 DM YBC252F 10 x CNMG 120408 EM YBM253F

SET DDJNR/L 93°

Tool holder, 20 inserts and cutting data in case

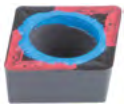
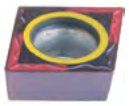
Klemmhalter, 20 Wendeplatten und Schnittdaten im Koffer

Material Number Artikelnummer	Content Inhalt
SET DDJNR/L 2020 K15	1 x DDJNR/L 2020 K15 10 x DNMG 150608 DM YBC252F 10 x DNMG 150608 EM YBM253F
SET DDJNR/L 2525 M15	1 x DDJNR/L 2525 M15 10 x DNMG 150608 DM YBC252F 10 x DNMG 150608 EM YBM253F

SET SCLCR/L 95°

Tool holder, 20 inserts and cutting data in case

Klemmhalter, 20 Wendeplatten und Schnittdaten im Koffer

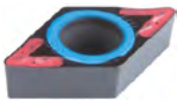
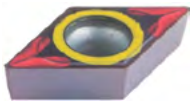



Material Number Artikelnummer	Content Inhalt
SET SCLCR/L 2020 K09	1 x SCLCR/L 2020 K09 10 x CCMT 09T308 HM YBC252F 10 x CCMT 09T308 EM YBM253F

SET SDJCR/L 93°

Tool holder, 20 inserts and cutting data in case

Klemmhalter, 20 Wendeplatten und Schnittdaten im Koffer

Material Number Artikelnummer	Content Inhalt
SET SDJCR/L 2020 K11	1 x SDJCR/L 2020 K11 10 x DCMT 11T308 HM YBC252F 10 x DCMT 11T308 EM YBM253F
SET SDJCR/L 2525 M11	1 x SDJCR/L 2525 M11 10 x DCMT 11T308 HM YBC252F 10 x DCMT 11T308 EM YBM253F

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