

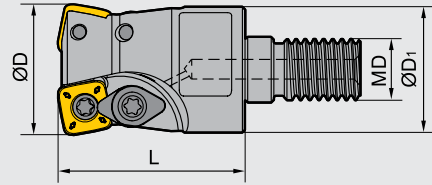
Milling · Fräsen

Indexable Milling Tools · Wendeplattenfräser

QCH - SDMT



P M K



Type Typ	Type Lager	Dimensions (mm) Abmessungen				Insert WSP	No. of teeth Zähne (Z)	Weight Gewicht (kg)	
		ØD	ØD ₁	L	MD				
QCH	●	-25-SDMT09-M12-02	25	24	35	12	SDMT09T312-DM	2	0.088
	●	-30-SDMT09-M16-03	30	29	45	16		3	0.176
	●	-32-SDMT12-M16-02	32	30	45	16	SDMT120412-DM	2	0.175
	●	-35-SDMT12-M16-02	35	30	45	16		2	0.200
	●	-35-SDMT09-M16-03	35	30	45	16	SDMT09T312-DM	3	0.216

■ Spare parts · Ersatzteile

Diameter Durchmesser Ø D	No. of teeth Zähne (Z)	Clamp screw Schraube	Clamp Pratze	Insert Screw WSPSchraube	Wrench Schlüssel
Ø25	2	I60M3.5×08TT	WD-204	I60M4×8.4	WT10IP
Ø30	3				
Ø32	2	I60M4×8.4	WD-204	I60M4×8.4	WT15IP
Ø35	2				
Ø35	3	I60M3.5×08TT	WD-204	I60M4×8.4	WT10IP



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

Recommended cutting data · Empfohlene Schnittdaten

	Workpiece material Werkstück Material	Hardness HB Härte	Grade Sorte	V(m/min)	Ø25		Ø30/32/35	
					Axial cutting depth	f (mm/z)	Axial cutting depth	f (mm/z)
P	Low-carbon steel Soft steel Niedrig legierter Kohlenstoffstahl Baustahl	≤HB180 HB180-280	YBC302/YBM351	170(120-220) 150(100-200)	0.6~1.0	0.8~1.2	0.8~1.2	1.0~1.4
	Hoch-carbon steel; Alloysteel Hoch Leg. Kohlenstoffstahl; Leg. Stah	HB280-350 ≤HB350	YBC302/YBM351	130(80-180)	0.4~0.8	0.8~1.2	0.6~1.0	1.0~1.4
	Alloy tool steel Leg. Stahl	≤HRC35	YBC302/YBM351	120(80-160)	0.4~0.8	0.6~1.0	0.6~1.0	0.8~1.2
M	Stainless steel Rostfreier Stahl	≤HB270	YBM351	120(80-160)	0.6~1.0	0.6~1.0	0.8~1.2	0.8~1.2
			YBG205	120(80-190)				
K	Cast iron Gusseisen	Tensile strength Zugfestigkeit ≤350MPa	YBG302	150(100-200)	0.6~1.0	1.0~1.4	0.8~1.2	1.2~1.6
	Nodular cast iron Kugelgrafitguss Temperguss	Tensile strength Zugfestigkeit ≤800MPa	YBG302	120(80-160)	0.4~0.8	0.8~1.2	0.6~1.0	1.0~1.4

Applicable tool
Werkzeug **B11-B18**

Tools code key
Werkzeug ISO **B26-B27**

Grade selection guide
Sortenauswahl **B19-B23**

Technical data
Technische Daten **B215-B220**

Hard alloy toolholder · Hartmetal Verlängerung

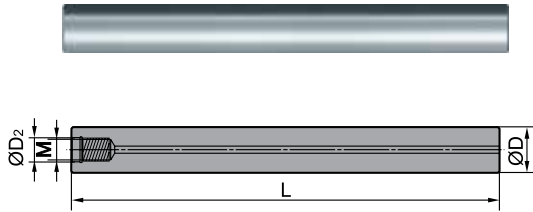


Fig 1

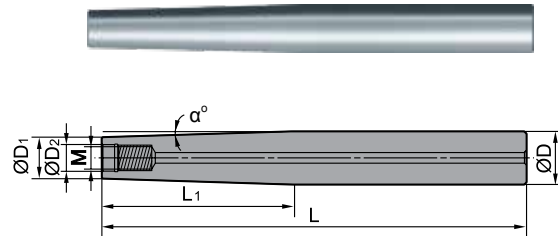


Fig 2

Type Typ	Stock Large	Flg	Dimensions (mm) Abmessungen								
			L	M	ØD ₂	ØD	ØD ₁	L ₁	α°		
G16-QCH-M8-100C	○	1	100	M8	8.5	16	--	--	--		
G16-QCH-M8-150C	○		150			16	--	--	--		
G20-QCH-M8-200C-ZJ90	○	2	200			20	15.5	90	1.3°		
G20-QCH-M8-250C-ZJ115	○		250			20	15.5	115	1°		
G20-QCH-M8-300C-ZJ135	○		300			20	15.5	135	0.85°		
G20-QCH-M10-100C	○	1	100			M10	10.5	20	--	--	--
G20-QCH-M10-150C	○		150					20	--	--	--
G20-QCH-M10-200C	○	200	20					20	--	--	
G25-QCH-M10-200C-ZJ90	○	2	200					25	19.8	90	1.6°
G25-QCH-M10-250C-ZJ115	○		250					25	19.8	115	1.25°
G25-QCH-M10-300C-ZJ135	○		300	25	19.8			135	1.1°		
G25-QCH-M12-100C	○	1	100	M12	12.5			25	--	--	--
G25-QCH-M12-150C	○		150					25	--	--	--
G25-QCH-M12-200C	○	200	25					--	--	--	
G25-QCH-M12-200C-ZJ90	○	2	200					32	24.5	90	2.3°
G25-QCH-M12-250C-ZJ115	○		250			32	24.5	115	1.75°		
G25-QCH-M12-300C-ZJ135	○		300			32	24.5	135	1.5°		
G32-QCH-M16-150C	○	1	150			M16	17	32	--	--	--
G32-QCH-M16-200C	○		200					32	--	--	--
G32-QCH-M16-250C	○	250	32					--	--	--	
G32-QCH-M16-300C	○	300	32					--	--	--	
G32-QCH-M16-200C-ZJ90	○	2	200	32	30			90	0.64°		
G32-QCH-M16-250C-ZJ115	○		250	32	30			115	0.5°		
G32-QCH-M16-300C-ZJ135	○		300	32	30			135	0.4°		

Applicable tool B11-B18
Werkzeug

Tools code key B26-B27
Werkzeug ISO

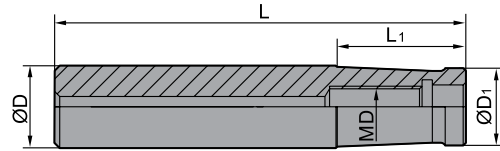
Grade selection guide B19-B23
Sortenauswahl

Technical data B215-B220
Technische Daten

Milling · Fräsen

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Steel toolholder · Stahl Verlängerung



Type Typ	Stock Large	Dimensions (mm) Abmessungen				
		ØD	L	L ₁	ØD ₁	MD
G16-QCH-M8-80	○	16	80	25	15	M8
G16-QCH-M8-100	○	16	100	45	15	M8
G20-QCH-M10-90	○	20	90	35	18.5	M10
G20-QCH-M10-105	○	20	105	50	18.5	M10
G25-QCH-M12-90	○	25	90	30	24	M12
G25-QCH-M12-110	○	25	110	50	24	M12
G32-QCH-M16-100	○	32	100	35	28.5	M16
G32-QCH-M16-120	○	32	120	55	28.5	M16
G32-QCH-M16-115	○	32	115	40	30	M16
G32-QCH-M16-135	○	32	135	60	30	M16



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