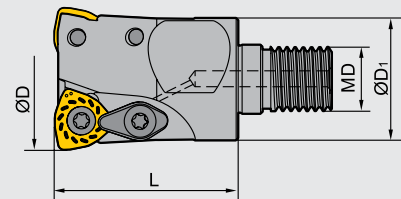
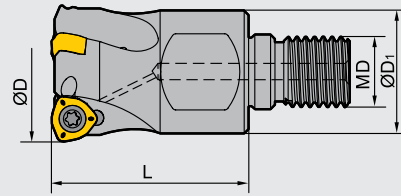





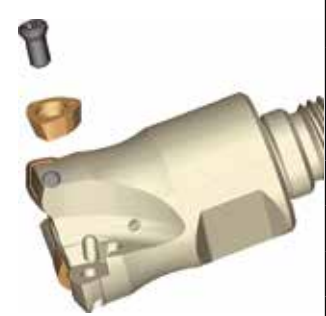
### QCH - WPGT



	Type Typ	Type Lager	Dimensions (mm) Abmessungen				Insert WSP	No. of teeth Zähne (Z)	Weight Gewicht (kg)
			ØD	ØD <sub>1</sub>	L	MD			
<b>QCH</b>	<b>-20-WPGT05-M10-02</b>	●	20	18	30	10	WPGT050315ZSR	2	0.056
	<b>-25-WPGT06-M12-02</b>	●	25	21	35	12	WPGT060415ZSR	2	0.097
	<b>-32-WPGT06-M16-03</b>	●	32	29	43	16	WPGT060415ZSR	3	0.185
	<b>-35-WPGT08-M16-02</b>	●	35	30	45	16	WPGT080615ZSR	2	0.196
	<b>-35-WPGT08-M16-03</b>	●	35	30	45	16	WPGT080615ZSR	3	0.201
	<b>-42-WPGT06-M16-04</b>	●	42	29	43	16	WPGT060415ZSR	4	-

### Spare parts · Ersatzteile

Diameter Durchmesser Ø D	No. of teeth Zähne (Z)	Clamp screw Schraube	Clamp Pratze	Wrench Schlüssel
Ø20	2	 I60M3.5×7	 --	 WT15
Ø25	2	I60M4×8.4	--	WT15P
Ø32	3	I60M4×8.4	--	WT15P
Ø35	2	I60M5×13	WD-208	WT20IT
Ø35	3	I60M4×8.4	--	WT15P



Applicable tool  
Werkzeug **B11-B18**

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

Grade selection guide  
Sortenauswahl **B19-B23**

Technical data  
Technische Daten **B215-B220**

# Milling · Fräsen

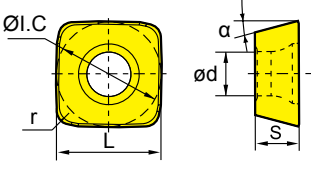
## Indexable Milling Tools · Wendepplattenfräser



B

Milling Tools  
Fräser

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
● Normal Machining Condition / Normale Bearbeitungsbedingungen  
● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

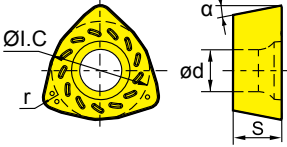
■ Applicable inserts · Wendeschneidplatten





Insert WSP	Type Typ	Dimensions (mm) Abmessungen						CVD Coating CVD Beschicht.						PVD Coating PVD Beschicht.					Cermet Cermet	Carbide uncoat. unbe. Hartmetall							
		ØI.C	L	ød	S	r	α	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205		YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
	SDMT09T312-DM	9.525	9.525	4.0	3.97	1.2	15°	●						○		●		●									
	SDMT120412-DM	12.7	12.7	4.4	4.76	2.0	15°						●		○		●		●								
	SDMT09T312-PM	9.525	9.525	1.2	3.97	4.0	15°	○				●				●		○									
	SDMT120412-PM	12.7	12.7	2.0	4.76	4.4	15°	○				●				●		○									

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
● Normal Machining Condition / Normale Bearbeitungsbedingungen  
● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

■ Applicable inserts · Wendeschneidplatten



Insert WSP	Type Typ	Dimensions (mm) Abmessungen						CVD Coating CVD Beschicht.						PVD Coating PVD Beschicht.					Cermet Cermet	Carbide uncoat. unbe. Hartmetall						
		ØI.C	r	S	ød	α	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302		YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
	WPGT050315ZSR	7.94	1.5	3.5	4.0	11°	●																			
	WPGT060415ZSR	9.525	1.5	4.2	4.4	11°	●											●								
	WPGT080615ZSR	12.85	1.5	6.35	5.5	11°	●												●							
	WPGT090725ZSR	15	2.5	7	5.5	11°	●																			
	WPGT050315ZSR-PM	7.94	1.5	3.5	4.0	11°	●					○						●								
	WPGT060415ZSR-PM	9.525	1.5	4.2	4.4	11°	●					○						●								
	WPGT080615ZSR-PM	12.85	1.5	6.35	5.5	11°	●					○							●							
	WPGT090725ZSR-PM	15.00	2.5	7.00	5.5	11°	●					○							●							

● 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)
<b>P</b> 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	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	YBC302/YBM351	120(80-160)	0.4~0.8	0.6~1.0	0.6~1.0	0.8~1.2
<b>M</b> 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)				
<b>K</b> 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	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

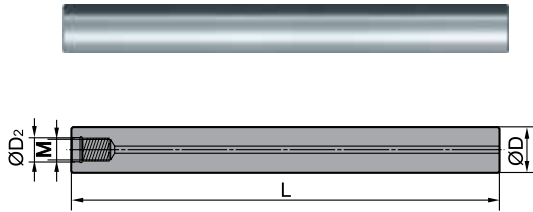


Fig 1

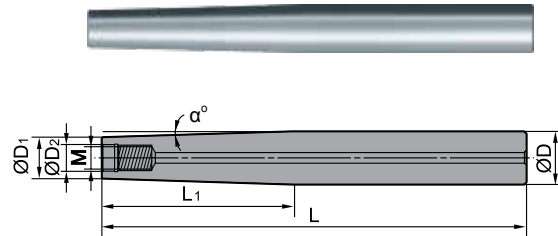


Fig 2

Type Typ	Stock Large	Flg	Dimensions (mm) Abmessungen						
			L	M	ØD <sub>2</sub>	ØD	ØD <sub>1</sub>	L <sub>1</sub>	α°
G16-QCH-M8-100C	○	1	100	M8	8.5	16	--	--	--
G16-QCH-M8-150C	○		150			16	--	--	--
G20-QCH-M8-200C-ZJ90	○	2	200	M8	8.5	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	○	2	200	M10	10.5	20	20	--	--
G25-QCH-M10-200C-ZJ90	○		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	○	2	200	M12	12.5	25	--	--	--
G25-QCH-M12-200C-ZJ90	○		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	○	2	250	M16	17	32	--	--	--
G32-QCH-M16-300C	○		300			32	--	--	--
G32-QCH-M16-200C-ZJ90	○		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

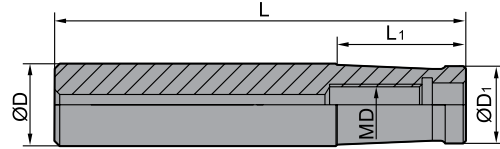
Grade selection guide B19-B23  
Sortenauswahl

Technical data B215-B220  
Technische Daten

# Milling · Fräsen

Indexable Milling Tools · Wendeplattenfräser

## Steel toolholder · Stahl Verlängerung



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



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