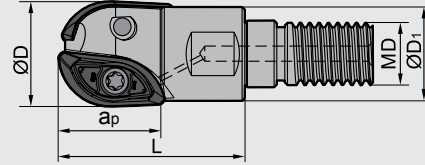


QCH - XPHT

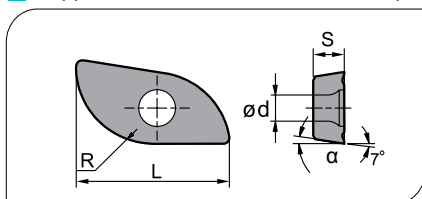


Type Typ	Stock Lager	Dimensions (mm) Abmessungen					Insert WSP	No. of teeth Zähne	Weight Gewicht (kg)
		ØD	ØD1	L	ap	MD			
QCH -16-XPHT16-M10	●	16	17	28	16	10	XPHT16R0803-GM	2	0.036
-20-XPHT20-M12	●	20	19	30	20	12	XPHT20R10T3-GM	2	0.051
-25-XPHT25-M12	●	25	24	35	25	12	XPHT25R1204-GM	2	0.071
-30-XPHT30-M16	●	30	29	45	30	16	XPHT30R1506-GM	2	0.140
-32-XPHT32-M16	●	32	30	45	32	16	XPHT32R1606-GM	2	0.162

Spare parts · Ersatzteile

Diameter Durchmesser Ø D	Screw Schraube	Wrench Schlüssel			
	Ø16	I60M2.5×6.5	WT07P	--	--
Ø20	I60M3.5×08TT	WT10IP	--	--	
Ø25	I60M4×10	--	WT15S	--	
Ø30	I60M5×13.2	--	--	WT20IT	
Ø32	I60M5×13.2	--	--	--	

Applicable inserts · Wendschneidplatten



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

Workpiece Material Werkstoffe	P Steel Stahl	M Stainless Steel Rostfreier Stahl	K Cast iron Gusseisen	N Non-ferrous material Nichte Metalle	S Heat-resistant steel Warmfester Stahl
Steel (Stahl)	●	●	●	●	●
Stainless Steel (Rostfreier Stahl)	●	●	●	●	●
Cast Iron (Gusseisen)	●	●	●	●	●
Non-ferrous (Nichte Metalle)	●	●	●	●	●
Heat-resistant steel (Warmfester Stahl)	●	●	●	●	●

Insert WSP	Type Typ	Dimensions (mm) Abmessungen					CVD Coating CVD Beschicht.				PVD Coating PVD Beschicht.				Cermet Cermet	Carbide uncoat. unbe. Hartmetall											
		L	ød	R	S	α	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252		YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201	
	XPHT16R0803-GM	16	3.1	8	3.18	9°																					
	XPHT20R10T3-GM	20	4.0	10	3.97	9°																					
	XPHT25R1204-GM	25	4.7	12.5	4.76	9°																					
	XPHT30R1506-GM	30	5.8	15	6.35	11°																					
	XPHT32R1606-GM	32	5.8	16	6.35	9°																					

Applicable tool
Werkzeug **B11-B18**

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

Grade selection guide
Sortenauswahl **B19-B23**

Technical data
Technische Daten **B215-B220**

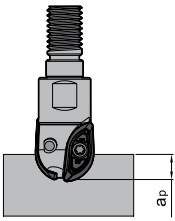
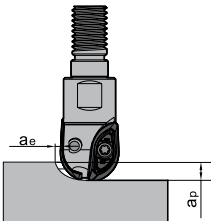
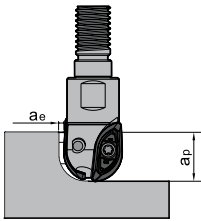
Milling · Fräsen

Indexable Milling Tools · Wendepplattenfräser

Diameter range

Durchmesser Bereich Ø16- Ø20

■ Recommended Cutting data · Schnittdaten

Operations Anwendung						
Workpiece material Werkstückstoff	Cutting data Schnittdaten	Machining of slot Nutenfräsen	Side milling (slight) Schulterfräsen		Side milling (deep) Schulterfräsen	Grade Sorte
Medium carbon steel Kohlenstoffstahl Hardness Härte 150~250HB	V(m/min)	150~220	150~220	150~220	150~220	YBG302
	Fz(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a _p (mm)	4	4	8	16	
	a _e (mm)	--	3	4	1.5	
Alloy steel Leg. Stahl Hardness Härte 150~280HB	V(m/min)	100~150	100~150	100~150	100~150	
	Fz(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	a _p (mm)	4	4	8	16	
	a _e (mm)	--	3	4	1.5	
Die steel Gesenkstahl Hardness Härte 150~255HB	V(m/min)	80~120	80~120	80~120	80~120	
	Fz(mm/z)	0.1~0.3	0.1~0.3	0.1~0.3	0.1~0.3	
	a _p (mm)	4	4	8	16	
	a _e (mm)	--	3	4	1.5	
Hardened steel gehärteter Stahl Hardness Härte 40~50HRC	V(m/min)	80~100	80~100	80~100	--	
	Fz(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	--	
	a _p (mm)	4	4	8	--	
	a _e (mm)	--	2	3	--	
Grey Cast iron Grauguss Hardness Härte 160~260HB	V(m/min)	250~300	250~300	250~300	250~300	
	Fz(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a _p (mm)	4	4	8	16	
	a _e (mm)	--	3	4	1.5	
Nodular Cast iron Kugelgraphitguss Hardness Härte 170~300HB	V(m/min)	200~250	200~250	200~250	200~250	
	Fz(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	a _p (mm)	4	4	8	16	
	a _e (mm)	--	3	4	1.5	

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

Diameter range

Durchmesser Bereich Ø25, Ø30, Ø32

Recommended Cutting data · Schnittdaten

Operations Anwendung						
Workpiece material Werkstückstoff	Cutting data Schnittdaten	Machining of slot Nutenfräsen	Side milling (slight) Schulterfräsen		Side milling (deep) Schulterfräsen	Grade Sorte
Medium carbon steel Kohlenstoffstahl Hardness Härte 150~250HB	V(m/min)	150~220	150~220	150~220	150~220	YBG302
	Fz(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	ap(mm)	6	6	12.5	25	
	ae(mm)	--	5	6.5	3	
Alloy steel leg. Stahl Hardness Härte 150~280HB	V(m/min)	100~150	100~150	100~150	100~150	
	Fz(mm/z)	0.1~0.4	0.1~0.4	0.1~0.4	0.1~0.4	
	ap(mm)	6	6	12.5	25	
	ae(mm)	--	5	6.5	3	
Die steel Gesenkstahl Hardness Härte 150~255HB	V(m/min)	80~120	80~120	80~120	80~120	
	Fz(mm/z)	0.1~0.3	0.1~0.3	0.1~0.3	0.1~0.3	
	ap(mm)	6	6	12.5	25	
	ae(mm)	--	5	6.5	3	
Hardened steel gehärteter Stahl Hardness Härte 40~50HRC	V(m/min)	80~100	80~100	80~100	--	
	Fz(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	--	
	ap(mm)	6	6	12.5	--	
	ae(mm)	--	5	6.5	--	
Grey Cast iron Grauguss Hardness Härte 160~260HB	V(m/min)	250~300	250~300	250~300	250~300	
	Fz(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	ap(mm)	6	6	12.5	25	
	ae(mm)	--	5	6.5	3	
Nodular Cast iron Kugelgrafitguss Hardness Härte 170~300HB	V(m/min)	200~250	200~250	200~250	200~250	
	Fz(mm/z)	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15	
	ap(mm)	6	6	12.5	25	
	ae(mm)	--	5	6.5	3	

B

Milling Tools
Fräser

Applicable tool B11-B18
Werkzeug

Tools code key B26-B27
Werkzeug ISO

Grade selection guide B19-B23
Sortenauswahl

Technical data B215-B220
Technische Daten

Hard alloy toolholder · Hartmetal Verlängerung

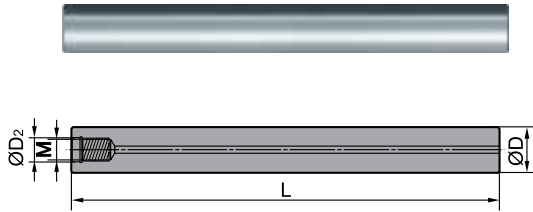


Fig 1

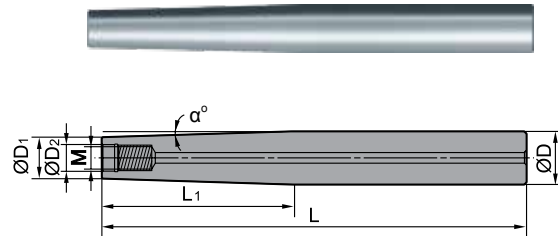


Fig 2

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

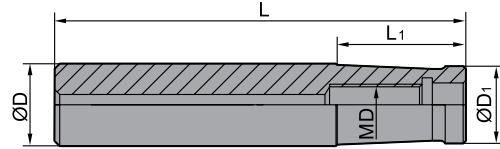
Grade selection guide B19-B23
Sortenauswahl

Technical data B215-B220
Technische Daten

Milling · Fräsen

Indexable Milling Tools · Wendeplattenfräser

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



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