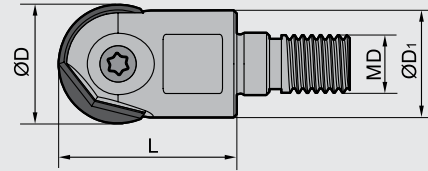


QCH - ZOHX



P M K N S



Type Typ	Stock Lager	Dimensions (mm) Abmessungen				Insert WSP	Weight Gewicht (kg)
		ØD	ØD ₁	L	MD		
QCH -16-ZOHX16-M8	●	16	15	28	8	ZOHX1604- **	0.029
-20-ZOHX20-M10	●	20	19	30	10	ZOHX2005- **	0.048
-25-ZOHX25-M12	●	25	24	35	12	ZOHX2506- **	0.087
-30-ZOHX30-M16	●	30	29	45	16	ZOHX3007- **	0.170
-32-ZOHX32-M16	●	32	30	45	16	ZOHX3207- **	0.180

B

Milling Tools
Fräser

■ Spare parts · Ersatzteile

Diameter Durchmesser Ø D	Insert Screw Schraube	Wrench Schlüssel	
Ø16	I70M5×12TT	WT20IP	--
Ø20	I70M5×16TT	WT20IP	--
Ø25	I70M6×20TT	WT20IP	--
Ø30	I70M8×25TT	--	WT30IT
Ø32	I70M8×25TT	--	WT30IT



Applicable tool
Werkzeug **B11-B18**

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

Grade selection guide
Sortenauswahl **B19-B23**

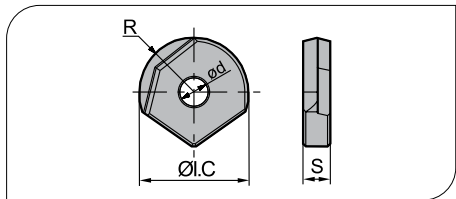
Technical data
Technische Daten **B215-B220**

Milling · Fräsen

Indexable Milling Tools · Wendepplattenfräser

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

Applicable inserts · Wendeschneidplatten



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●	●	●	●	●
Stainless Steel / Rostfreier Stahl	●	●	●	●	●
Cast iron / Gusseisen	●	●	●	●	●
Non-ferrous material / Ne 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							
		ØI.C	Ød	S	R	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202		YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101
	ZOHX1604-GF	16	5	4	8														●					
	ZOHX2005-GF	20	5	5	10														●					
	ZOHX2506-GF	25	6	6	12.5														○					
	ZOHX3007-GF	30	8	7	15														●					
	ZOHX3207-GF	32	8	7	16														●					
	ZOHX1604-GM	16	5	4	8														●					
	ZOHX2005-GM	20	5	5	10														●					
	ZOHX2506-GM	25	6	6	12.5														○					
	ZOHX3007-GM	30	8	7	15														●					
	ZOHX3207-GM	32	8	7	16														●					

Recommended cutting data · Empfohlene Schnittdaten

Workpiece material / Werkstück Material	Hardness HB / Härte	Cutting data / Sorte	Diameter (mm) / Durchmesser ØD			Grade / Sorte
			Ø16, Ø20	Ø25	Ø30, Ø32	
P Carbon steel / Niedrig legierter Kohlenstoffstahl / Baustahl	HB≤180	V _c (m/min)	100~200	100~200	100~200	YBG252
		f _z (mm/z)	0.15~0.25	0.2~0.3	0.2~0.3	
		a _{pmax} (mm)	0.8	1	1.25	
		a _{emax} (mm)	0.8	1	1.25	
	HB180~280	V _c (m/min)	80~180	80~180	80~180	
		f _z (mm/z)	0.15~0.25	0.2~0.3	0.2~0.3	
		a _{pmax} (mm)	0.8	1	1.25	
		a _{emax} (mm)	0.8	1	1.25	
HRC55~65	V _c (m/min)	60~100	60~100	60~100		
	f _z (mm/z)	0.15~0.25	0.2~0.3	0.2~0.3		
	a _{pmax} (mm)	0.4	0.5	0.6		
	a _{emax} (mm)	0.4	0.5	0.6		
M Stainless steel / Rostfreier Stahl	HB≤270	V _c (m/min)	70~150	70~150	70~150	
		f _z (mm/z)	0.1~0.2	0.1~0.25	0.1~0.25	
		a _{pmax} (mm)	0.6	0.8	1	
		a _{emax} (mm)	0.6	0.8	1	
K Cast iron / Gusseisen	HB180-250	V _c (m/min)	160~300	160~300	160~300	
		f _z (mm/z)	0.2~0.3	0.25~0.35	0.25~0.35	
		a _{pmax} (mm)	1	1.5	1.8	
		a _{emax} (mm)	1	1.5	1.8	

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

Hard alloy toolholder · Hartmetal Verlängerung

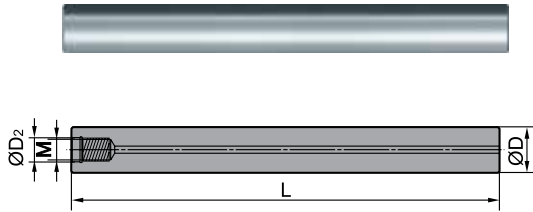


Fig 1

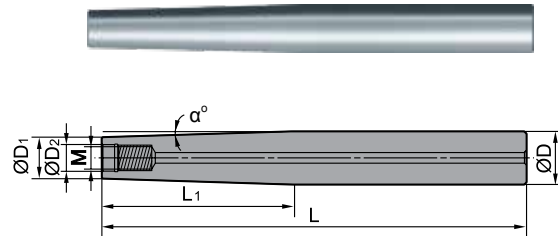


Fig 2

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

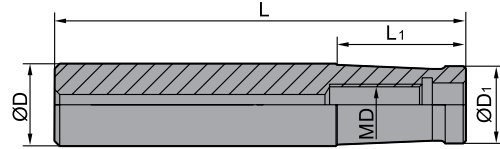
Grade selection guide B19-B23
Sortenauswahl

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