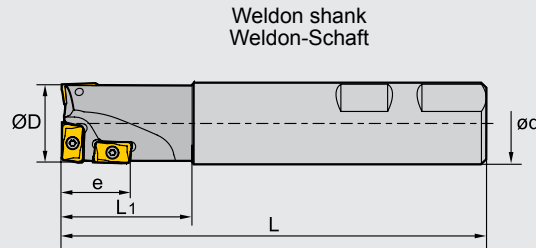


Square shoulder milling tools · Eckfräser

Kr:90°



EMP05 P M K



Specification of tools · Werkzeug Beschreibung

Type Typ	Stock Lager	Dimensions (mm) Abmessungen					No. of inserts WSP Anzahl		Weight Gewicht (kg)	
		R	Ø D	Ø d	L	L1	e	APMT11		APMT16
EMP05	-025-XP25	●	25	25	130	40	20	3	--	0.5
	-025-XP25C	●	25	25	130	40	20	3	--	0.5
	-032-XP32	●	32	32	140	50	30	--	3	0.8
	-032-XP32C	●	32	32	140	50	30	--	3	0.8
	-040-XP32	●	40	32	150	60	40	--	4	1.0
	-040-XP32C	●	40	32	150	60	40	--	4	1.0

Spare Parts · Ersatzteile

Diameter Durchmesser Ø D	Insert WSP	Screw Schraube	Wrench Schlüssel	
Ø25-Ø40	APMT11	I60M2.5×6.5T	WT08IP	
	APMT16	I60M4×10	WT15IP	

Applicable tool
Werkzeug **B11-B18**

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

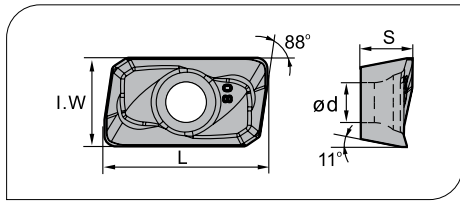
Grade selection guide
Sortenauswahl **B19-B23**

Technical data
Technische Daten **B215-B220**

Milling · Fräsen

Indexable Milling Tools · Wendeplattenfräser

Applicable inserts · Wendeschneidplatten



Workpiece Material Werkstoff	Ideal Machining Condition Gute Bearbeitungsbedingungen		Normal Machining Condition Normale Bearbeitungsbedingungen		Unfavorable Machining Condition Ungünstige Bearbeitungsbedingungen	
	●	●	●	●	●	●
P Steel Stahl	●	●	●	●	●	●
M Stainless Steel Rostfreier Stahl	●	●	●	●	●	●
K Cast iron Gusseisen					●	●
N Non-ferrite material Ne Metalle						●
S Heat-resistant steel Warmfester Stahl					●	●

Insert shape Plattenform	Type Typ	Dimensions (mm) Abmessungen					CVD Coating CVD Beschicht.						PVD Coating PVD Beschicht.				Cermets Cermets		Carbide uncoat. unbe. Hartmetall						
		L	I.W	S	d	r	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
	APMT1135PDR	11.25	6.2	3.5	2.8	0.8				○					○	○	●								
	APMT160408PDER	17.25	9.25	4.76	4.4	0.8				○	○				○	●									

1 Drilling Bohren



Recommended cutting data · Empfohlene Schnittdaten

	Workpiece material Werkstück Material	Hardness HB Härte	Grade Sorte	Cutting data · Schnittdaten	
				V(m/min)	f(mm/z)
P	Low-carbon steel Soft steel Niedrig legierter Kohlenstoffstahl Baustahl	≤180	YBG202 YBG205	180 (150-220)	0.2 (0.08-0.25)
	High-carbon steel Alloy steel Hoch Leg. Kohlenstoffstahl	180-280	YBG202 YBG205	160 (130-200)	0.15 (0.08-0.2)
	Alloy tool steel Leg. Werkzeugstahl	280-350	YBG202 YBG205	140 (120-180)	0.12 (0.05-0.2)
M	Stainless steel Rostfreier Stahl	≤270	YBG202 YBG205	80 (50-150)	0.08 (0.03-0.15)
K	Cast iron Gusseisen	180-250	YBG202 YBG205	150 (100-220)	0.15 (0.08-0.2)

2 Milling Fräsen

Recommended cutting data · Empfohlene Schnittdaten

	Workpiece material Werkstück Material	Hardness HB Härte	Grade Sorte	Cutting data · Schnittdaten	
				V(m/min)	f(mm/z)
P	Low-carbon steel Soft steel Niedrig legierter Kohlenstoffstahl Baustahl	≤180	YBG202 YBG205	190 (140-250)	0.08 (0.04-0.15)
	High-carbon steel Alloy steel Hoch leg. Kohlenstoffstahl	180-280	YBG202 YBG205	170 (130-250)	0.08 (0.04-0.15)
	Alloy tool steel Leg. Werkzeugstahl	280-350	YBG202 YBG205	150 (110-240)	0.08 (0.04-0.15)
M	Stainless steel Rostfreier Stahl	≤270	YBG202 YBG205	120 (80-190)	0.08 (0.04-0.15)
K	Cast iron Gusseisen	180-250	YBG202 YBG205	120 (80-210)	0.08 (0.04-0.15)

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