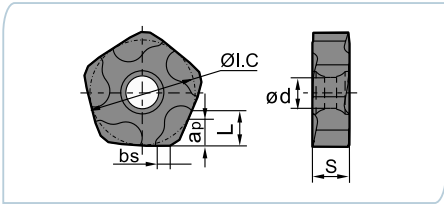


Applicable inserts
Wendeschneidplatten

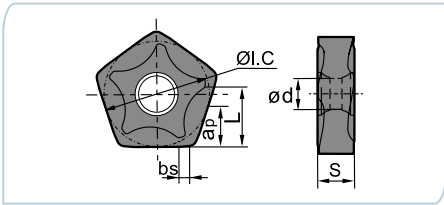


- Ideal Machining Condition / Gute Bearbeitungsbedingungen
- Normal Machining Condition / Normale Bearbeitungsbedingungen
- Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●	●	●	●	●
Stainless Steel / Rostfreier Stahl	●	●	●	●	●
Cast iron / Gusseisen	●	●	●	●	●
Non-ferrite material / Ne Metalle	●	●	●	●	●
Heat-resistant steel / Warmfester Stahl	●	●	●	●	●

Insert WSP	Type Typ	Dimension Abmessung (mm)						CVD Coating CVD Beschicht.						PVD Coating PVD Beschicht.				Cermet Cermet	Carbide uncoat. unb.Hartmetall								
		L	ØI.C	S	ød	bs	ap max	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202		YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
	PNEG110512R-CF	5.4	15.875	5.56	4.64	1.6	5																				
	PNEG110512L-CF	5.4	15.875	5.56	4.64	1.6	5																				
	PNEG110512R-CM	5.4	15.875	5.56	4.64	1.6	5																				
	PNEG110512L-CM	5.4	15.875	5.56	4.64	1.6	5																				
	PNEG110512R-CR	5.4	15.875	5.56	4.64	1.6	5																				
	PNEG110512L-CR	5.4	15.875	5.56	4.64	1.6	5																				

Applicable inserts
Wendeschneidplatten



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

Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●	●	●	●	●
Stainless Steel / Rostfreier Stahl	●	●	●	●	●
Cast iron / Gusseisen	●	●	●	●	●
Non-ferrite material / Ne Metalle	●	●	●	●	●
Heat-resistant steel / Warmfester Stahl	●	●	●	●	●

Insert WSP	Type Typ	Dimension Abmessung (mm)						CVD Coating CVD Beschicht.						PVD Coating PVD Beschicht.				Cermet Cermet	Carbide uncoat. unb.Hartmetall								
		L	ØI.C	S	ød	bs	ap max	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202		YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
	PNEG110512R-PF	7.5	15.875	5.56	4.64	1.6	7.5		●																		
	PNEG110512L-PF	7.5	15.875	5.56	4.64	1.6	7.5		○																		
	PNEG110512R-PM	7.5	15.875	5.56	4.64	1.6	7.5		●																		
	PNEG110512L-PM	7.5	15.875	5.56	4.64	1.6	7.5		○																		
	PNEG110512R-PR	7.5	15.875	5.56	4.64	1.6	7.5		●																		
	PNEG110512L-PR	7.5	15.875	5.56	4.64	1.6	7.5		○																		

Cutting Data / Schnittdaten

Workpiece material / Werkstück Material	Hardness HB / Härte	Grade / Sorte	Cutting data / Schnittdaten				
			Vc(m/min)	fz(mm/z)			apmax(mm)
				PF	PM	PR	
P Low-carbon steel / Soft steel / Niedriglegierter Kohlenstoffstahl / Baustahl	≤180	YBM253 / YBC302	270 (220-350)	0.15 (0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	7.5
	180-280	YBM253 / YBC302	260 (200-320)	0.15 (0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	7.5
	280-350	YBM253 / YBC302	240 (180-300)	0.15 (0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	7.5
K Cast iron / Gusseisen	180-250	YBD152	270 (150-300)	CF	CM	CR	5
				0.15 (0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.4)	