

LSE445

GÜVENİLİR VE VERİMLİ İŞLEME İÇİN 20° POZİTİF KESİCİ
UÇLU GENEL YÜZEY FREZELEME SERİSİ



*M*plus...

LSE445

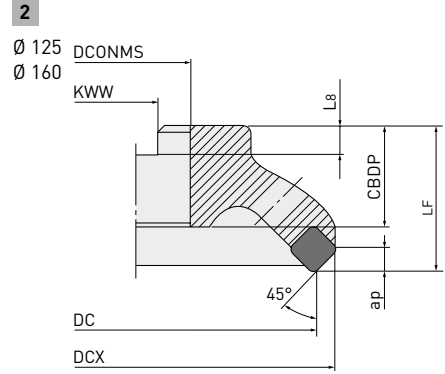
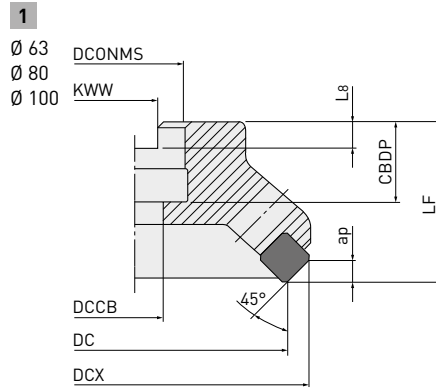


45° YÜZEY FREZELEME - GENEL KESME

P M K N



C H: 45°
A.R: +19° T: +13°
RR: -2° I: +15°



MALAFİ TİPİ

Sipariş No.	Stok		ZEFP	DC	DCX	LF	DCONMS	CBDP	DCCB	KWW	L8	WT	APMX		Tip
	R	L													
LSE445-063A05R/L-E	●	□	5	63	76.5	40	22	20	11	10.4	6.4	0.8	5.5	—	1
LSE445-080A06R/L-E	●	□	6	80	93.5	50	27	22	13.5	12.4	7.0	1.0	5.5	—	1
LSE445-100A07R/L-E	●	□	7	100	113.5	50	32	25	17.5	14.4	8.0	1.4	5.5	—	1
LSE445-125B09R/L-E	□	□	9	125	138.5	50	40	32	—	16.4	9.0	2.0	5.5	—	2
LSE445-160B11R/L-E	□	□	11	160	173.5	50	40	32	—	16.4	9.0	3.0	5.5	—	2

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YEDEK PARÇALAR

Takım Tutucu Numarası	*1					
LSE445 -063A05R/L-E				LS10T		
LSE445 -080A04R/L-E						
LSE445-100A07R/L-E	STBE445NF	CS300890T	CWSE445TR	LS15T	TKY25T	TKY08F
LSE445-125B09R/L-E						
LSE445 -160B11R/L-E						

Sıkma Torku (N • m): LS10T= 8.5. LS15T= 8.5. CS300890T= 1.0

Kırıcılı kesici uçlar

LSE445

ÖNERİLEN KESME KOŞULLARI

Malzeme	Sertlik	Kalite	Vc	fz
P	Yumuşak Çelik	F7030	300 (200 – 360)	0.2 (0.1 – 0.3)
		NX4545		
		UTi20T	240 (170 – 300)	
		UP20M		
	Karbon Çeliği Alaşımlı Çelik	F7030	250 (170 – 300)	0.2 (0.1 – 0.3)
		NX4545	200 (140 – 240)	
		UTi20T		
		UP20M	140 (100 – 170)	0.15 (0.1 – 0.2)
280 – 350HB		UTi20T		
M	Paslanmaz Çelik	UP20M	200 (140 – 240)	0.2 (0.1 – 0.3)
		UTi20T		
K	Dökme Demir	Kopma	200 (130 – 240)	0.2 (0.1 – 0.3)
		Mukavemeti		
		<450MPa		
		MC5020		
		F5010		
F5020	160 (110 – 190)			
HTi10				
UTi20T				
N	Alüminyum Alaşımı	MD220	1000 (200 – 1500)	0.15 (0.05 – 0.25)
		HTi10	1000 (700 – 1200)	0.12 (0.05 – 0.2)

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Devir (dk⁻¹) = (1000 x Kesme Hızı) ÷ (3.14 x veD1).

Tabla İlerlemesi (mm/dk) = Diş Başına İlerleme x Diş Sayısı x Kesici Devri.



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MITSUBISHI MATERIALS'IN AVRUPA SATIŞ ŞİRKETLERİ

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