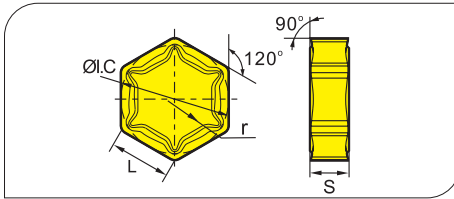


# Milling · Fräsen

## Indexable Milling · Fräswendeplatten

### 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-ferrous material / Ne Metalle				●	●
Heat-resistant steel / Warmfester Stahl				●	●

Insert shape / Plattenform	Type · Typ	Dimension (mm) / Abmessung				CVD Coating / CVD Beschicht.					PVD Coating / PVD Beschicht.					Cermet	Carbide uncoat. / unbe. Hartmetall							
		L	I.C.	S	r	YBC301	YBC401	YBM251	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302		YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	<b>HNEX090512-DF</b>	9.16	15.875	5.56	1.2					○														
	<b>HNEX090512-DM</b>	9.16	15.875	5.56	1.2					○														
	<b>HNEX090512-DR</b>	9.16	15.875	5.56	1.2					● ●														

### Chipbreaker Selection FMD02 · Spanbrecher Auswahl FMD02

Application / Anwendung	Finishing / Schlichten	Semi-Finishing / Mittlere Bearbeitung	Roughing / Schruppen
<b>K</b>	-DF	-DM	-DR

### Recommended cutting data · Empfohlene Schnittdaten

Workpiece material / Werkstückstoff	Hardness HB / Härte	Grade / Sorte	Cutting data · Schnittdaten			
			V (m/min)	f (mm/z)		
				-DF	-DM	-DR
<b>K</b> Cast iron / Gusseisen	180-250	YBD152	180 (110-250)	0.15 (0.1-0.2)	0.2 (0.1-0.3)	0.3 (0.2-0.5)
		YBD252	130 (110-200)	0.2 (0.1-0.2)	0.25 (0.1-0.3)	0.3 (0.2-0.5)

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