Spare Parts · Ersatzteile

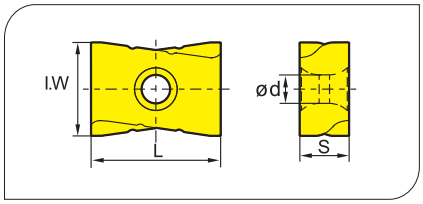
Diameter Durchmesser Ø D	Insert Platte	shim Unterlage	Screw Schraube	Shim Screw Unterlage Schraube	Wrench Schlüssel	Wrench Schlüssel
Ø125 ~ Ø315	LN15	LLN15-ZR	I60M3×7	I60M4×15	WT15IS	WT10IS
Ø125 ~ Ø315	LN20	LLN20R-ZR	I60M3×7	I60M4×15	WT15IS	WT10IS
Ø125 ~ Ø315	LN25	LLN25R-ZR	I60M3.5×10.4	I60M5×17	WT20IT	WT15IS

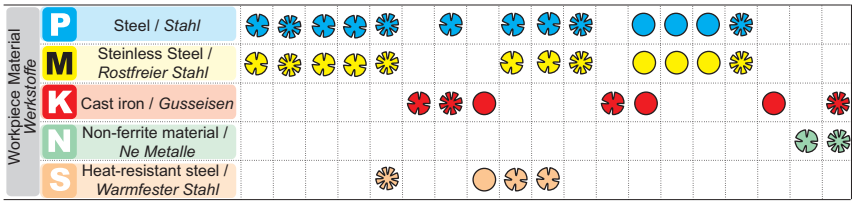
Applicable inserts · Wendeschneidplatten

Ideal Machining Condition
Gute Bearbeitungsbedingungen

Normal Machining Condition
Normale Bearbeitungsbedingungen

Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen





Insert shape Plattenform	Type · Typ	Dimension (mm) Abmessung				CVD Coating CVD Beschicht.							PVD Coating PVD Beschicht.						Cermet		Carbide uncoat. unbe. Hartmetall			
		L	I.W	S	d	YBC301	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD051	YD101	YD201
	LNKT1506EN-ZR	15.875	14	6.35	4.6	●		●		●	●	●				●								
	LNKT2007DN-ZR	20	17	7.94	4.6					●		●				●								
	LNKT2510-ZR	25	18	9.525	5.5					●		○				●								

Recommended cutting data · Empfohlene Schnittdaten

Workpiece material Werkstückstoff		Hardness HB Härte	Grade Sorte	Cutting data · Schnittdaten V (m/min)	Cutting data · Schnittdaten f (mm/z)
P	Low-carbon steel Soft steel Niedrig legierter Kohlenstoffstahl Baustahl	≤180	YBG302	180 (150-300)	0.5 (0.2-0.8)
			YBM351	180 (150-300)	0.5 (0.2-0.8)
	High-carbon steel Alloy steel Hoch Leg. Kohlenstoffstahl Leg. Stahl	180-280	YBG302	150 (120-280)	0.5 (0.2-0.8)
			YBM351	140 (120-280)	0.5 (0.2-0.8)
	Alloy tool steel Leg. Werkzeugstahl	280-350	YBG302	120 (80-250)	0.45 (0.2-0.6)
			YBM351	100 (80-250)	0.45 (0.2-0.6)
M	Stainless steel Rostfreier Stahl	≤270	YBG302	120 (80-200)	0.45 (0.2-0.6)
			YBM351	100 (80-200)	0.45 (0.2-0.6)
K	Cast iron Gusseisen	180-250	YBD152	150 (120-200)	0.3 (0.2-0.5)
			YBD252	130 (110-200)	0.3 (0.2-0.5)

Applicable tool B9-B15
Werkzeug

Tools code key B22-B23
Werkzeug ISO

Grade selection guide B16-B20
Sortenauswahl

Technical data B183-B188
Technische Daten