

B Empfohlene Schnitttiefe und Vorschub, metrisch

T-Max® P Wendeschneidplatten zum Drehen

| Wendeplatte | Empf. Schnitttiefe | | | Empfohlener Vorschub | | |
|---------------|--------------------|---------------|-------|----------------------|---------------|-------|
| | P | | | | | |
| | Min. | a_p Max. | Empf. | Min. | f_n Max. | Empf. |
| CNMG 12 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| CNMG 12 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| CNMG 12 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| CNMG 16 06 08 | 0.25 | 4 | 3 | 0.15 | 0.4 | 0.3 |
| CNMG 16 06 12 | 0.5 | 4 | 3 | 0.15 | 0.5 | 0.35 |
| CNMG 16 06 16 | 1 | 4 | 3 | 0.2 | 0.55 | 0.4 |
| DNMG 11 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| DNMG 11 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| DNMG 15 04 04 | 0.25 | 4 | 2.5 | 0.1 | 0.4 | 0.25 |
| DNMG 15 04 08 | 0.25 | 4 | 2.5 | 0.15 | 0.4 | 0.3 |
| DNMG 15 04 12 | 0.4 | 4 | 2.5 | 0.15 | 0.5 | 0.35 |
| DNMG 15 06 04 | 0.25 | 4 | 2.5 | 0.1 | 0.4 | 0.25 |
| DNMG 15 06 08 | 0.25 | 4 | 2.5 | 0.15 | 0.4 | 0.3 |
| DNMG 15 06 12 | 0.4 | 4 | 2.5 | 0.15 | 0.5 | 0.35 |
| SNMG 12 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| SNMG 12 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| SNMG 12 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| TNMG 16 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| TNMG 16 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| TNMG 16 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| WNMG 08 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| WNMG 08 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| WNMG 08 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| VNMG 16 04 04 | 0.25 | 3 | 2 | 0.1 | 0.25 | 0.17 |
| VNMG 16 04 08 | 0.25 | 3 | 2 | 0.1 | 0.25 | 0.17 |
| VNMG 16 04 12 | 0.4 | 3 | 2 | 0.1 | 0.3 | 0.2 |

| Wendeplatte | Empf. Schnitttiefe | | | Empfohlener Vorschub | | |
|---------------|--------------------|---------------|-------|----------------------|---------------|-------|
| | M | | | | | |
| | Min. | a_p Max. | Empf. | Min. | f_n Max. | Empf. |
| CNMG 12 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| CNMG 12 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| CNMG 12 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| CNMG 16 06 08 | 0.25 | 4 | 3 | 0.15 | 0.4 | 0.3 |
| CNMG 16 06 12 | 0.5 | 4 | 3 | 0.15 | 0.5 | 0.35 |
| CNMG 16 06 16 | 1 | 4 | 3 | 0.2 | 0.55 | 0.4 |
| DNMG 11 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| DNMG 11 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| DNMG 15 04 04 | 0.25 | 4 | 2.5 | 0.1 | 0.4 | 0.25 |
| DNMG 15 04 08 | 0.25 | 4 | 2.5 | 0.15 | 0.4 | 0.3 |
| DNMG 15 04 12 | 0.4 | 4 | 2.5 | 0.15 | 0.5 | 0.35 |
| DNMG 15 06 04 | 0.25 | 4 | 2.5 | 0.1 | 0.4 | 0.25 |
| DNMG 15 06 08 | 0.25 | 4 | 2.5 | 0.15 | 0.4 | 0.3 |
| DNMG 15 06 12 | 0.4 | 4 | 2.5 | 0.15 | 0.5 | 0.35 |
| SNMG 12 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| SNMG 12 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| SNMG 12 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| TNMG 16 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| TNMG 16 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| TNMG 16 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| WNMG 08 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| WNMG 08 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| WNMG 08 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| VNMG 16 04 04 | 0.25 | 3 | 2 | 0.1 | 0.25 | 0.17 |
| VNMG 16 04 08 | 0.25 | 3 | 2 | 0.1 | 0.25 | 0.17 |
| VNMG 16 04 12 | 0.4 | 3 | 2 | 0.1 | 0.3 | 0.2 |

F Empfohlene Schnitttiefe und Vorschub, Zoll

T-Max® P Wendeschneidplatten zum Drehen

| Wendeplatte | Empf. Schnitttiefe | | | Empfohlener Vorschub | | |
|-------------|--------------------|---------------|-------|----------------------|---------------|-------|
| | P | | | | | |
| | Min. | a_p Max. | Empf. | Min. | f_n Max. | Empf. |
| CNMG431 | .0098 | .1181 | .0787 | .0039 | .0157 | .0098 |
| CNMG432 | .0098 | .1181 | .0787 | .0059 | .0157 | .0118 |
| CNMG433 | .0157 | .1181 | .0787 | .0059 | .0197 | .0138 |
| CNMG542 | .0098 | .1575 | .1181 | .0059 | .0157 | .0118 |
| CNMG543 | .0197 | .1575 | .1181 | .0059 | .0197 | .0138 |
| CNMG544 | .0394 | .1575 | .1181 | .0079 | .0217 | .0157 |
| DNMG331 | .0098 | .1181 | .0787 | .0039 | .0157 | .0098 |
| DNMG332 | .0098 | .1181 | .0787 | .0059 | .0157 | .0118 |
| DNMG431 | .0098 | .1575 | .0984 | .0039 | .0157 | .0098 |
| DNMG432 | .0098 | .1575 | .0984 | .0059 | .0157 | .0118 |
| DNMG433 | .0157 | .1575 | .0984 | .0059 | .0197 | .0138 |
| DNMG441 | .0098 | .1575 | .0984 | .0039 | .0157 | .0098 |
| DNMG442 | .0098 | .1575 | .0984 | .0059 | .0157 | .0118 |
| DNMG443 | .0157 | .1575 | .0984 | .0059 | .0197 | .0138 |
| SNMG431 | .0098 | .1181 | .0787 | .0039 | .0157 | .0098 |
| SNMG432 | .0098 | .1181 | .0787 | .0059 | .0157 | .0118 |
| SNMG433 | .0157 | .1181 | .0787 | .0059 | .0197 | .0138 |
| TNMG331 | .0098 | .1181 | .0787 | .0039 | .0157 | .0098 |
| TNMG332 | .0098 | .1181 | .0787 | .0059 | .0157 | .0118 |
| TNMG333 | .0157 | .1181 | .0787 | .0059 | .0197 | .0138 |
| WNMG431 | .0098 | .1181 | .0787 | .0039 | .0157 | .0098 |
| WNMG432 | .0098 | .1181 | .0787 | .0059 | .0157 | .0118 |
| WNMG433 | .0157 | .1181 | .0787 | .0059 | .0197 | .0138 |
| VNMG331 | .0098 | .1181 | .0787 | .0039 | .0098 | .0067 |
| VNMG332 | .0098 | .1181 | .0787 | .0039 | .0098 | .0067 |
| VNMG333 | .0157 | .1181 | .0787 | .0039 | .0118 | .0079 |

| Wendeplatte | Empf. Schnitttiefe | | | Empfohlener Vorschub | | |
|---------------|--------------------|---------------|-------|----------------------|---------------|-------|
| | M | | | | | |
| | Min. | a_p Max. | Empf. | Min. | f_n Max. | Empf. |
| CNMG 12 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| CNMG 12 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| CNMG 12 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| CNMG 16 06 08 | 0.25 | 4 | 3 | 0.15 | 0.4 | 0.3 |
| CNMG 16 06 12 | 0.5 | 4 | 3 | 0.15 | 0.5 | 0.35 |
| CNMG 16 06 16 | 1 | 4 | 3 | 0.2 | 0.55 | 0.4 |
| DNMG 11 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| DNMG 11 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| DNMG 15 04 04 | 0.25 | 4 | 2.5 | 0.1 | 0.4 | 0.25 |
| DNMG 15 04 08 | 0.25 | 4 | 2.5 | 0.15 | 0.4 | 0.3 |
| DNMG 15 04 12 | 0.4 | 4 | 2.5 | 0.15 | 0.5 | 0.35 |
| DNMG 15 06 04 | 0.25 | 4 | 2.5 | 0.1 | 0.4 | 0.25 |
| DNMG 15 06 08 | 0.25 | 4 | 2.5 | 0.15 | 0.4 | 0.3 |
| DNMG 15 06 12 | 0.4 | 4 | 2.5 | 0.15 | 0.5 | 0.35 |
| SNMG 12 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| SNMG 12 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| SNMG 12 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| TNMG 16 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| TNMG 16 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| TNMG 16 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| WNMG 08 04 04 | 0.25 | 3 | 2 | 0.1 | 0.4 | 0.25 |
| WNMG 08 04 08 | 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| WNMG 08 04 12 | 0.4 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| VNMG 16 04 04 | 0.25 | 3 | 2 | 0.1 | 0.25 | 0.17 |
| VNMG 16 04 08 | 0.25 | 3 | 2 | 0.1 | 0.25 | 0.17 |
| VNMG 16 04 12 | 0.4 | 3 | 2 | 0.1 | 0.3 | 0.2 |

Empfohlene Schnitttiefe und Vorschub, metrisch

T-Max® P Wendeschneidplatten zum Drehen

| Empf. Schnitttiefe | | | Empfohlener Vorschub | | |
|--------------------|---------------|-------|----------------------|---------------|-------|
| S | | | | | |
| Min. | a_p Max. | Empf. | Min. | f_n Max. | Empf. |
| 0.25 | 3 | 0.5 | 0.1 | 0.3 | 0.2 |
| 0.25 | 3 | 1 | 0.15 | 0.35 | 0.25 |
| 0.4 | 3 | 1.5 | 0.15 | 0.4 | 0.3 |
| 0.25 | 3 | 2 | 0.15 | 0.4 | 0.3 |
| 0.25 | 3 | 2 | 0.15 | 0.5 | 0.35 |
| 0.5 | 3 | 2 | 0.2 | 0.55 | 0.4 |
| 0.25 | 3 | 0.5 | 0.1 | 0.3 | 0.2 |
| 0.25 | 3 | 1 | 0.15 | 0.35 | 0.25 |
| 0.25 | 3 | 0.5 | 0.1 | 0.3 | 0.2 |
| 0.25 | 3 | 1 | 0.15 | 0.35 | 0.25 |
| 0.4 | 3 | 1.5 | 0.15 | 0.4 | 0.3 |
| 0.25 | 3 | 0.5 | 0.1 | 0.3 | 0.2 |
| 0.25 | 3 | 1 | 0.15 | 0.35 | 0.25 |
| 0.4 | 3 | 1.5 | 0.15 | 0.4 | 0.3 |
| 0.25 | 3 | 0.5 | 0.1 | 0.3 | 0.2 |
| 0.25 | 3 | 1 | 0.15 | 0.35 | 0.25 |
| 0.4 | 3 | 1.5 | 0.15 | 0.4 | 0.3 |
| 0.25 | 3 | 0.5 | 0.1 | 0.3 | 0.2 |
| 0.25 | 3 | 1 | 0.15 | 0.35 | 0.25 |
| 0.4 | 3 | 1.5 | 0.15 | 0.4 | 0.3 |
| 0.25 | 3 | 0.5 | 0.1 | 0.3 | 0.2 |
| 0.25 | 3 | 1 | 0.15 | 0.35 | 0.25 |
| 0.4 | 3 | 1.5 | 0.15 | 0.4 | 0.3 |
| 0.25 | 3 | 0.5 | 0.1 | 0.25 | 0.17 |
| 0.25 | 3 | 0.8 | 0.1 | 0.25 | 0.17 |
| 0.4 | 3 | 1.5 | 0.1 | 0.3 | 0.2 |

Empfohlene Schnitttiefe und Vorschub, Zoll

T-Max® P Wendeschneidplatten zum Drehen

| Empf. Schnitttiefe | | | Empfohlener Vorschub | | |
|--------------------|---------------|-------|----------------------|---------------|-------|
| S | | | | | |
| Min. | a_p Max. | Empf. | Min. | f_n Max. | Empf. |
| .0098 | .1181 | .0197 | .0039 | .0118 | .0079 |
| .0098 | .1181 | .0394 | .0059 | .0138 | .0098 |
| .0157 | .1181 | .0591 | .0059 | .0157 | .0118 |
| .0098 | .1181 | .0787 | .0059 | .0157 | .0118 |
| .0098 | .1181 | .0787 | .0059 | .0197 | .0138 |
| .0197 | .1181 | .0787 | .0079 | .0217 | .0157 |
| .0098 | .1181 | .0197 | .0039 | .0118 | .0079 |
| .0098 | .1181 | .0394 | .0059 | .0138 | .0098 |
| .0098 | .1181 | .0197 | .0039 | .0118 | .0079 |
| .0098 | .1181 | .0394 | .0059 | .0138 | .0098 |
| .0157 | .1181 | .0591 | .0059 | .0157 | .0118 |
| .0098 | .1181 | .0197 | .0039 | .0118 | .0079 |
| .0098 | .1181 | .0394 | .0059 | .0138 | .0098 |
| .0157 | .1181 | .0591 | .0059 | .0157 | .0118 |
| .0098 | .1181 | .0197 | .0039 | .0118 | .0079 |
| .0098 | .1181 | .0394 | .0059 | .0138 | .0098 |
| .0157 | .1181 | .0591 | .0059 | .0157 | .0118 |
| .0098 | .1181 | .0197 | .0039 | .0118 | .0079 |
| .0098 | .1181 | .0394 | .0059 | .0138 | .0098 |
| .0157 | .1181 | .0591 | .0059 | .0157 | .0118 |
| .0098 | .1181 | .0197 | .0039 | .0118 | .0079 |
| .0098 | .1181 | .0394 | .0059 | .0138 | .0098 |
| .0157 | .1181 | .0591 | .0059 | .0157 | .0118 |
| .0098 | .1181 | .0197 | .0039 | .0098 | .0067 |
| .0098 | .1181 | .0315 | .0039 | .0098 | .0067 |
| .0157 | .1181 | .0591 | .0039 | .0118 | .0079 |

Schnittgeschwindigkeitsempfehlungen, metrische Werte

Die angegebenen Schnittdaten gelten für Anwendungen mit Kühlschmierstoff.

| ISO P | CMC-Nr. | Stahl | Spezifische Schnittkraft k_{c1} | Härte Brinell | <<<< VERSCHLEISSFESTIGKEIT | | | |
|-----------|---------|--|-----------------------------------|---------------|---|----------------|----------------|-------------|
| | | | | | CT5015 | GC1525 | GC15 | GC1115 |
| | | | | | h_{ex} , mm \approx Vorschub f_n , mm/U | | | |
| | | | | | 0.05-0.1-0.2 | 0.05-0.1-0.2 | 0.1-0.2-0.3 | 0.1-0.2-0.3 |
| MC-Nr. | CMC-Nr. | Werkstückstoff | N/mm ² | HB | Schnittgeschwindigkeit (V_c), m/min | | | |
| P1.1.Z.AN | 01.1 | Unlegierter Stahl C = 0,1-0,25% | 1500 | 125 | 650-540-440 | 560-465-380 | 300-250-215 | 300-250-215 |
| P1.2.Z.AN | 01.2 | | 1600 | 150 | 570-480-385 | 495-415-335 | 275-225-195 | 275-225-195 |
| P1.3.Z.AN | 01.3 | | 1700 | 170 | 510-425-340 | 430-365-295 | 260-215-185 | 260-215-185 |
| P2.1.Z.AN | 02.1 | Niedrig legierter Stahl (Legierungsbestandteile <5%) Nicht gehärtet | 1700 | 180 | 480-400-320 | 375-320-255 | 220-175-150 | 220-175-150 |
| P2.1.Z.AN | 02.12 | | 1800 | 210 | - | - | 190-155-135 | - |
| P2.5.Z.HT | 02.2 | | 1850 | 275 | 285-235-190 | 200-165-135 | 140-115-100 | 140-115-100 |
| P2.5.Z.HT | 02.2 | | 2050 | 350 | 230-190-150 | 160-135-110 | 110-95-80 | 110-95-80 |
| P3.0.Z.AN | 03.11 | Hochlegierter Stahl (Legierungsbestandteile >5%) Geglüht | 1950 | 200 | 395-330-250 | 260-215-175 | - | - |
| P3.0.Z.HT | 03.21 | | 3000 | 325 | 195-165-130 | 145-115-90 | - | - |
| P1.5.C.UT | 06.1 | Stahlguss Unlegiert | 1550 | 180 | 260-215-175 | 225-185-145 | - | - |
| P2.6.C.UT | 06.2 | | 1600 | 200 | 270-225-170 | 175-145-105 | - | - |
| P3.0.C.UT | 06.3 | | 2050 | 225 | 200-165-125 | 140-115-85 | - | - |
| P5.0.Z.AN | 05.11 | Rostfreier Stahl Ferritisch/martensitisch Stangen/geschmiedet Nicht gehärtet | 1800 | 200 | 290-240 | 380-305-245 | 335-255-200 | 250-190-150 |
| P5.0.Z.PH | 05.12 | | 2850 | 330 | 170-150 | 350-280-225 | 185-150-120 | 145-115-95 |
| P5.0.Z.HT | 05.13 | | 2350 | 330 | 170-150 | 245-195-160 | 200-160-140 | 145-120-105 |
| M1.0.Z.AQ | 05.21 | Austenitisch Stangen/geschmiedet Austenitisch | 1800 | 180 | 220-195 | 410-330-265 | 265-215-165 | 205-165-130 |
| M1.0.Z.PH | 05.22 | | 2850 | 330 | 195-170 | 220-175-145 | 185-150-120 | 145-115-90 |
| M2.0.Z.AQ | 05.23 | | 2250 | 200 | 145-130 | 245-200-160 | 220-190-155 | 170-145-120 |
| M3.1.Z.AQ | 05.51 | Austenitisch-ferritisch (Duplex) Stangen/geschmiedet Nicht schweißbar $\geq 0,05\%C$ | 2000 | 230 | - | 315-255-205 | 250-205-155 | 195-160-120 |
| M3.2.Z.AQ | 05.52 | | 2450 | 260 | - | 280-225-185 | 230-170-130 | 175-130-100 |
| P5.0.C.UT | 15.11 | Ferritisch/martensitisch Gegossen Nicht gehärtet | 1700 | 200 | - | - | 320-265-205 | 240-200-155 |
| P5.0.C.HT | 15.12 | | 2450 | 330 | - | - | 160-130-95 | 135-110-80 |
| P5.0.C.HT | 15.13 | | 2150 | 330 | - | - | 175-145-110 | 140-115-85 |
| M1.0.C.UT | 15.21 | Austenitisch Gegossen Austenitisch | 1700 | 180 | - | - | 280-225-170 | 215-175-135 |
| M2.0.C.AQ | 15.22 | | 2450 | 330 | - | - | 160-130-95 | 135-110-80 |
| M2.0.C.AQ | 15.23 | | 2150 | 200 | - | - | 210-180-150 | 160-135-115 |
| M3.1.C.AQ | 15.51 | Austenitisch-ferritisch (Duplex) Gegossen Nicht schweißbar $\geq 0,05\%C$ | 1800 | 230 | - | - | 230-170-120 | 185-135-95 |
| M3.2.C.AQ | 15.52 | | 2250 | 260 | - | - | 205-155-110 | 170-130-90 |
| K1.1.C.NS | 07.1 | ISO K Temperguss Ferritisch (kurzspanend) | 790 | 130 | - | - | - | 800-700-600 |
| K1.1.C.NS | 07.2 | | 900 | 230 | - | - | - | 700-590-500 |
| K2.1.C.UT | 08.1 | Grauguss Niedrige Festigkeit | 890 | 180 | 1700-1450-1200 | 1700-1450-1200 | 1450-1200-1050 | 800-700-600 |
| K2.2.C.UT | 08.2 | | 970 | 220 | 1450-1250-1050 | 1450-1250-1050 | 1250-1050-890 | 760-650-540 |
| K3.1.C.UT | 09.1 | Kugelgraphitguss Ferritisch | 900 | 160 | - | - | - | - |
| K3.3.C.UT | 09.2 | | 1350 | 250 | - | - | - | - |
| K3.4.C.UT | 09.3 | | 2100 | 380 | - | - | - | - |