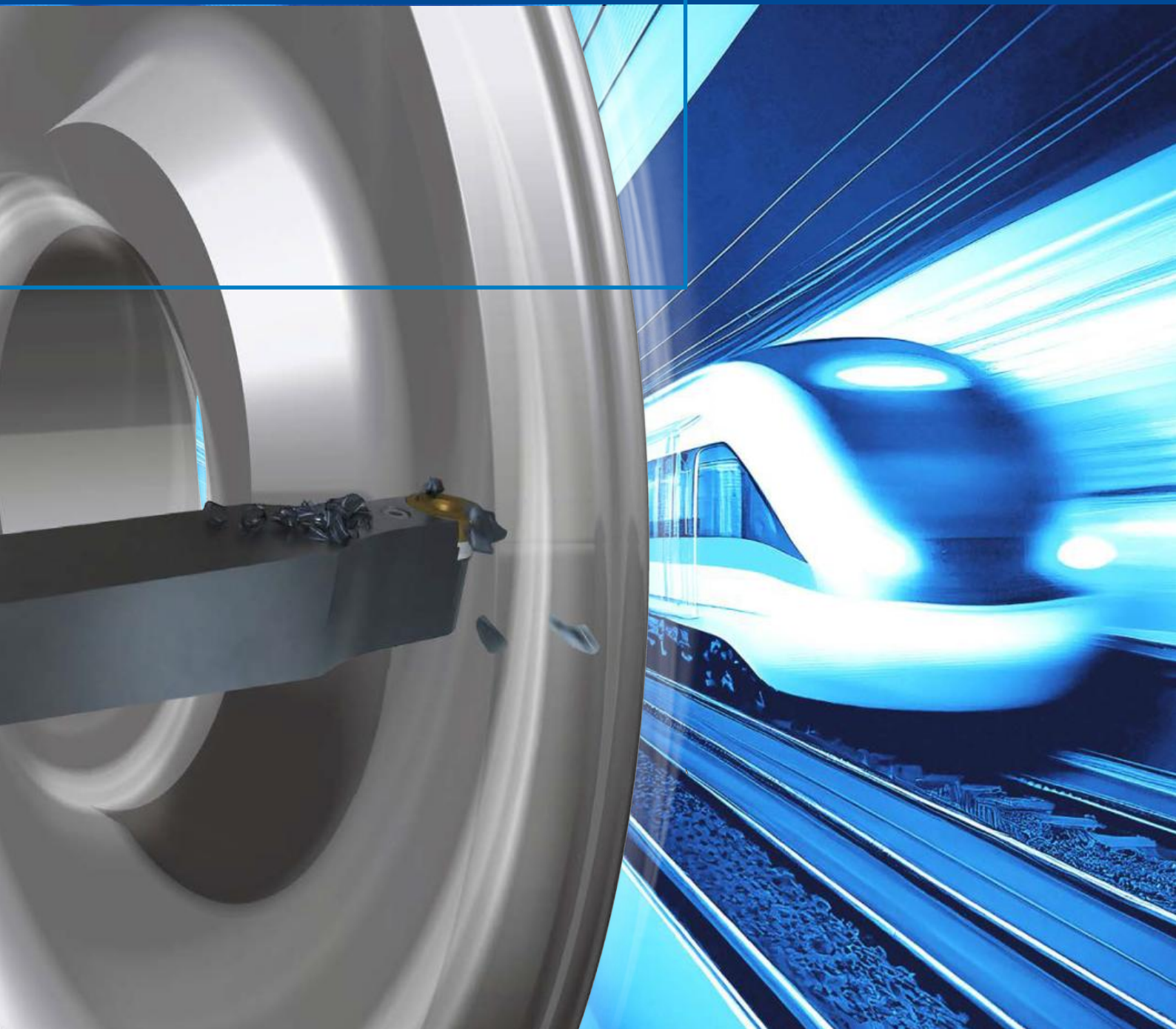


boehlerit

火車輪加工

Railway wheel machining



Boehlerit – 硬質合金開發先驅

Boehlerit是一家家族企業，隸屬於Brucklacher集團（Leitz、Bilz和Boehlerit），總部位於奧地利小鎮卡芬貝格，為金屬、木材、塑膠和複合材料加工的硬質合金和刀具制定了全球標準。

憑藉用於銑削、車削、鑽孔和成型的切削材料、半成品、精密刀具和刀具系統，Boehlerit確保了全球範圍內的工藝安全和效率。該公司廣泛的產品組合包括用於曲軸加工以及採礦業、棒材剝皮、管材和板材加工以及重型加工的高度專業化工具。Boehlerit產品系列還具有用於建築部件和磨損保護的碳化物。

在塗層技術方面，Boehlerit在全球範圍內佔據著獨特的地位，從有史以來第一個奈米CVD黏合層到全球最硬的鑽石層。憑藉在冶金、塗層技術和最先進的沖壓技術方面的多年經驗，Boehlerit成為刀具製造商的高素質開發合作夥伴。

Boehlerit – Pioneer in carbide development www.boehlerit.com

Boehlerit, a family business that is part of the Brucklacher group (Leitz, Bilz and Boehlerit) and headquartered in the Austrian town of Kapfenberg, sets global standards with carbides and tools for the processing of metal, wood, plastics and composites. With cutting materials, semi-finished products, precision tools and tool systems for milling, turning, drilling and forming, Boehlerit ensures process safety and efficiency on a global scale. The company's extensive product portfolio includes highly specialised tools for the machining of crankshafts as well as for the mining industry, for bar peeling, tube and sheet metal processing and heavy-duty machining. The Boehlerit product range also features carbides for construction components and wear protection. When it comes to coating technology, Boehlerit occupies a unique position worldwide, ranging from the first-ever nano-CVD bonding layer to the hardest diamond layer worldwide. With its many years' experience in metallurgy, coating technology and state-of-the-art press technology, Boehlerit is a highly competent development partner for toolmakers.



hard facts for best results

生產基地

Boehlerit集團制定了國際品質標準。每年，公司都會投資新的生產技術並擴大其先進生產基地的產能。奧地利、德國和土耳其製造的高品質產品融合了最新的研發成果。

Production sites

The Boehlerit Group sets international quality standards. Every year, the company invests in new production technologies and in the expansion of capacities at its advanced production sites. High-quality products made in Austria, Germany and Turkey incorporate the latest research and development findings.



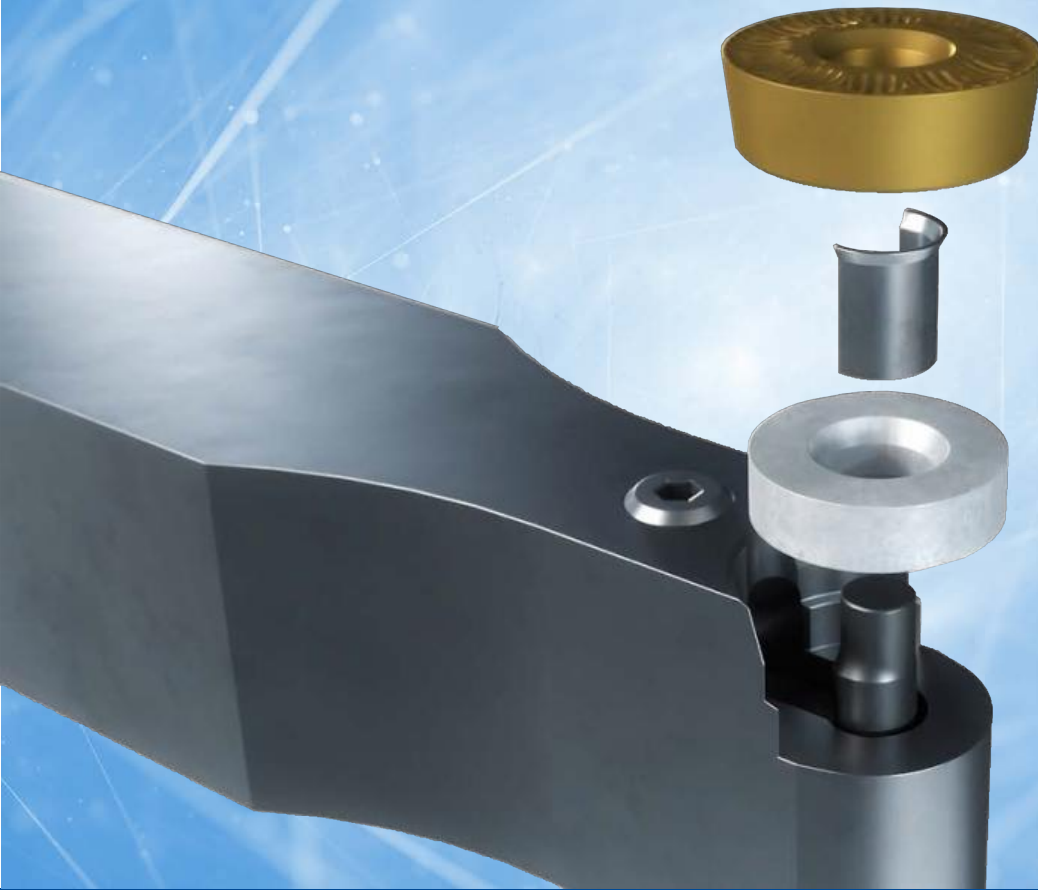
Boehlerit Kapfenberg (Headquarter)
in der Steiermark/Österreich Styria/Austria



Boehlerit Sert Metal
in Istanbul/Türkei Turkey



Boehlerit Deutschland
in Oberkochen Deutschland/Germany



火車輪加工

鐵路車輪的輪面和輪緣對於確保車輛的安全運行和舒適運行至關重要。Boehlerit 提供專門改造的刀具解決方案，用於翻轉磨損的輪對。一般來說，鐵路車輪加工分為新輪車削和修輪。

Railway wheel machining

The tread and flange of railroad wheels are crucial for the matter when it comes to ensuring safe operation and comfortable running of the vehicle. Boehlerit offers specially adapted tool solutions for overturning worn wheelsets. In general, railway wheel machining is divided into new wheel turning and wheel repairing.



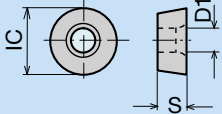








新車輪車削

在新的車輪車削中，所需的車輪（例如火車、貨車、地鐵）是使用複雜的刀具解決方案（圓形可轉位刀片）製造的。首先，透過鍛造和滾壓對車輪進行粗略預加工，然後使用Boehlerit專門改裝的刀具將其加工至最終輪廓。該工藝允許濕法和乾法生產。

New wheel turning

In new wheel turning the desired wheel (e.g. for trains, wagons, metro/subway) is manufactured using a sophisticated tooling solution (round indexable inserts). First, the wheels are roughly premachined by forging and rolling and afterwards they are machined to their final contour using specially adapted tools from Boehlerit. This process allows both wet and dry production.



	Bestellbezeichnung Item code	Schneidstoffsorte Cutting materials	Bestell-Nr. Order No.	Verfügbarkeit Availability	Vorschub Feed f [mm / U rev]	Schnitttiefe Cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm]		
							IC	S	D1
	Kniehebel Klemmung / Clamping via toggle lever								
	Feine Bearbeitung / Fine application								
	RCMX 2507M0-R25	LCP15T	5031805	●	0,50 - 1,50	2,0 - 7,0	25,00	7,90	7,20
	RCMX 2507M0-R25	LCP25T	5055953	●	0,50 - 1,50	2,0 - 7,0	25,00	7,90	7,20
	RCMX 3209M0-R25	LCP15T	5031806	●	0,50 - 1,50	3,0 - 10,0	32,00	9,52	9,50
	RCMX 3209M0-R25	LCP25T	5055956	○	0,50 - 1,50	3,0 - 10,0	32,00	9,52	9,50
	Grobe Bearbeitung / Rough application								
	RCMX 2006M0	LCP15T	5029236	●	0,25 - 0,55	2,0 - 8,0	20,00	6,35	6,50
	RCMX 2006M0	LCP25T	5055951	●	0,25 - 0,55	2,0 - 8,0	20,00	6,35	6,50
	RCMX 2507M0	LCP15T	5029240	●	0,30 - 0,65	2,5 - 13,0	25,00	7,90	7,20
	RCMX 2507M0	LCP25T	5055952	●	0,30 - 0,65	2,5 - 13,0	25,00	7,90	7,20
	RCMX 3209M0	LCP15T	5031800	●	0,50 - 1,50	3,0 - 13,0	32,00	9,52	9,50
	RCMX 3209M0	LCP25T	5055955	●	0,50 - 1,50	3,0 - 13,0	32,00	9,52	9,50
	RCMX 2006M0	BCP10T	5213667	○	0,25 - 0,55	2,0 - 8,0	20,00	6,35	6,50
	RCMX 2006M0	BCP20T	5213668	○	0,25 - 0,55	2,0 - 8,0	20,00	6,35	6,50
	RCMX 2507M0	BCP10T	5213671	○	0,30 - 0,65	2,5 - 13,0	25,00	7,90	7,20
	RCMX 2507M0	BCP20T	5213672	○	0,30 - 0,65	2,5 - 13,0	25,00	7,90	7,20
	RCMX 3209M0	BCP10T	5213675	○	0,50 - 1,50	3,0 - 13,0	32,00	9,52	9,50
	RCMX 3209M0	BCP20T	5213678	○	0,50 - 1,50	3,0 - 13,0	32,00	9,52	9,50
	RCMX 3009M0	BCP10T	5213673	○	0,50 - 1,50	3,0 - 13,0	30,00	9,52	10,00
	RCMX 3009M0	BCP20T	5213674	○	0,50 - 1,50	3,0 - 13,0	30,00	9,52	10,00
	RCMX 2507M0-R40	LCP25T	5055954	●	0,80 - 1,60	3,0 - 12,0	25,00	7,90	7,20
	RCMX 3209M0-R40	LCP15T	5031804	●	0,80 - 1,60	4,0 - 16,0	32,00	9,52	9,50
	RCMX 3209M0-R40	LCP25T	5055957	○	0,80 - 1,60	4,0 - 16,0	32,00	9,52	9,50
	Spezial Klemmung / Special fixation								
	RCMH 3209M0-R40	LCP15T	5031799	●	0,80 - 1,60	4,0 - 16,0	32,00	9,52	10,00
	RCMH 3209M0-R40	LCP25T	5055946	●	0,80 - 1,60	4,0 - 16,0	32,00	9,52	10,00
	RCMR 3209M0-R25	LCP15T	5031796	●	0,50 - 1,50	3,0 - 10,0	32,00	9,52	12,00
	RCMR 3209M0-R25	LCP25T	5055947	●	0,50 - 1,50	3,0 - 10,0	32,00	9,52	12,00
	Grobe Bearbeitung / Rough application								
	RCMR 3209M0-R40	LCP15T	5031798	●	0,80 - 1,60	4,0 - 16,0	32,00	9,52	12,00
	RCMR 3209M0-R40	LCP25T	5055948	●	0,80 - 1,60	4,0 - 16,0	32,00	9,52	12,00

Bestellbeispiel Order example: 10 Stück 10 Pieces RCMX 2507M0-R25 oder or 5031805

● Verfügbar ab Lager Available from stock
○ Auf Anfrage On request

	Bestellbezeichnung Item code	Bestell - Nr. Order No.	Verfüg- barkeit Availability	Abmessungen [mm] Dimensions [mm]					Passende Wende- platten Suitable inserts
				H=HF	B	OAL	LH	WF	
	PRDCN 3232P20	6406284	●	32	32	170	32	16	RCMX 20..
	PRDCN 4040S25	6406285	●	40	40	250	42	20	RCMX 25..
	PRDCN 5050V32	6418209	●	50	50	400	52	25	RCMX 32..
	PRGCR 3232P20	6406296	○	32	32	170	-	40	RCMX 20..
	PRGCL 3232P20	6406290	●	32	32	170	-	40	RCMX 20..
	PRGCR 4040S25	6406297	○	40	40	250	-	50	RCMX 25..
	PRGCL 4040S25	6406291	○	40	40	250	-	50	RCMX 25..
	PRGCR 5050S32	5024775	●	50	50	250	-	50	RCMX 32..
	PRGCL 5050S32	5024774	●	50	50	250	-	50	RCMX 32..

Ersatzteile für die Klemmhalter Spare parts for tool holder PR.C...

Schneidkanten- länge Cutting edge length	Schaftgröße Shank size												
		Unterlage Shim	Bestell-Nr. Order No.	Kniehebel Toggle lever	Bestell-Nr. Order No.	Spann- schraube Fixation screw	Bestell-Nr. Order No.	Spann- hülse shim pin	Bestell-Nr. Order No.	Montage- dorn Assembly punch	Bestell-Nr. Order No.	Inbus- schlüssel Allen key	Bestell-Nr. Order No.
20	3232	B05-R1747	6401858	D05-19189	6403975	A03-08235	6401282	E01-09008	6404741	V10-40000	6407855	V01-A0030	6407826
25	4040	B05-R2263	6401859	D05-23235	6403976	A03-10305	6401284	E01-11011	6404742	V10-30000	6407854	V01-A0040	6407828
32	5050	3832	6419722	8132	6420188	1612	6425578	4125	6419916	0025	6418986	5005	6407829

	Bestellbezeichnung Item code	Bestell - Nr. Order No.	Verfüg- barkeit Availability	Abmessungen [mm] Dimensions [mm]					Passende Wende- platten Suitable inserts
				H=HF	B	OAL	LH	WF	
	CRCCN 5050V32	5007550	○	50	50	400	42	25	RCM. 3209M0..

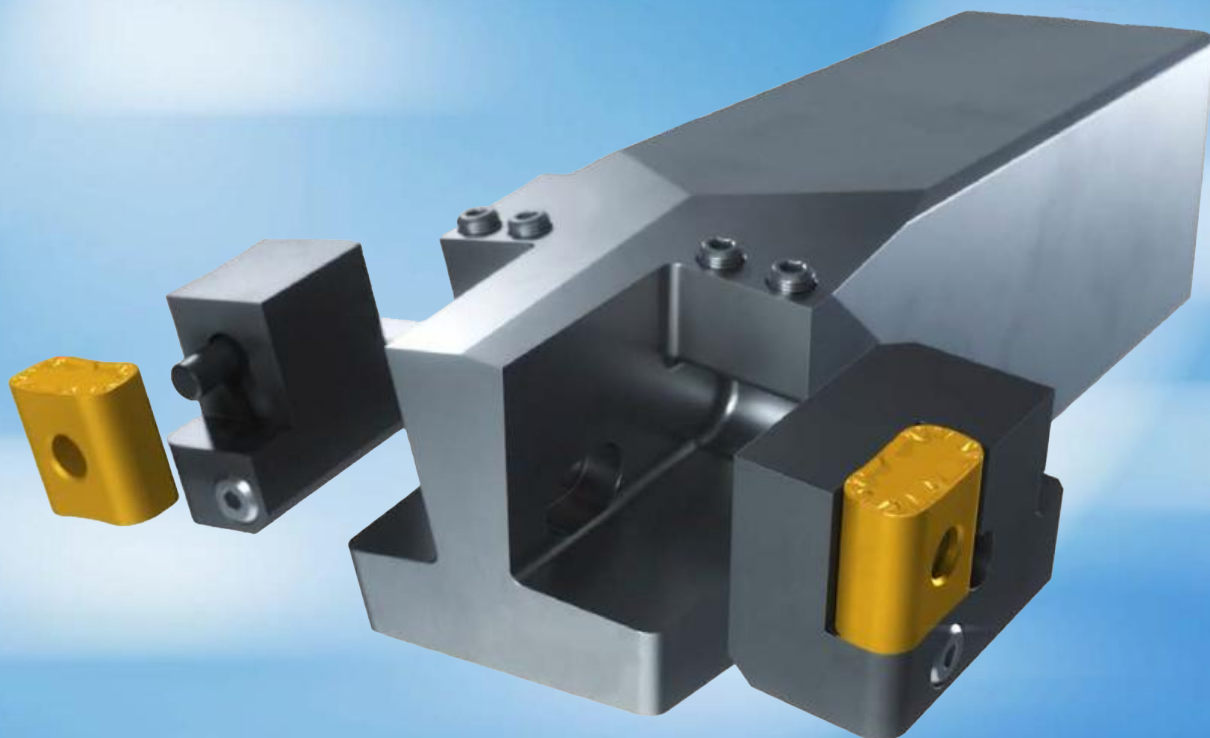
Ersatzteile für die Klemmhalter Spare parts for tool holder CRCCN 5050V32

Schneidkanten- länge Cutting edge length	Schaftgröße Shank size												
		Unterlage Shim	Bestell-Nr. Order No.	Spannpratze Clamp	Bestell-Nr. Order No.	Inbus- schraube Fixation screw	Bestell-Nr. Order No.	Senkkopf- schraube Shimscrew	Bestell-Nr. Order No.	Druckfeder Pressure spring	Bestell-Nr. Order No.	Inbus- schlüssel Allen key	Bestell-Nr. Order No.
32	5050	Bm46416	9076976	Bm46417	9076973	M8x20 DIN912	6412661	M6x16 DIN7991	9076982	0,5x5x30 DIN2098	9076983	V01-A0060 SW6	6407830
												V01-A0040 SW4	6407828

Bestellbeispiel Order Example:: 1 Stück 1 pieces PRDCN 3232P20 6406284

Rechtsausführung wie gezeichnet, Linksausführung spiegelbildlich
Righthand version as shown, lefthand version mirrorlike

● Verfügbar ab Lager Available from stock
○ Auf Anfrage On request



鐵路車輪改造

鐵路車輪修復涉及翻轉磨損的輪組。根據磨損程度，這個過程可以重複幾次。帶有縱向板的刀具系統首先用於加工胎面，然後加工車輪輪廓和凸緣。應選擇盡可能最大的切削深度，以保持盡可能短的加工時間。然而，這在很大程度上取決於所用車輪的磨損狀況。Boehlerit生產具有高水平專業知識的重型加工刀具。Boehlerit的全面承諾一方面代表創新、持續的品質開發和專業知識，另一方面代表重型加工領域的悠久傳統。

Railway wheel reprofiling

Railway wheel repairing involves overturning worn wheel sets. This process can be repeated several times depending on the degree of wear. A tooling system with longitudinal plates is used to machine the tread first followed by the wheel profile and flange. Preferably, the biggest possible cutting depth should be selected to keep machining times as short as possible. However, this depends heavily on the wear condition of the used wheel. Boehlerit manufactures tools for heavy duty machining with a high level of expertise. Boehlerit's comprehensive commitment stands for innovation, continuous quality development and know-how on the one hand and for a long tradition in heavy duty machining on the other.

全新斷屑槽型

借助新的RWF（用於精加工操作的斷屑幾何形狀），Boehlerit為鐵路車輪修復的車削工藝提供了另一種優化。新開發的斷屑槽透過專門開發的倒角抑制機器的振動，從而確保在較低進給範圍內實現最佳斷屑。憑藉這種幾何形狀以及改進的牌號BCP10T和BCP20T，Boehlerit正在擴大產品組合。由於採用了新的成分和新開發的CVD塗層，因此可以應對高溫發展和硬度條件，並且由於金色閃亮的顏色也提供了理想的磨損檢測。

New innovative chip breaking geometry

With the new RWF – chip breaking geometry for finishing operations, Boehlerit offers another optimization in the turning process for railway wheel repairing. The new developed chipbreaker suppresses vibrations of the machine due to a specially developed chamfer and thus guarantees optimum chipbreaking in the lower infeed range. With this geometry and the modified grades BCP10T and BCP20T, Boehlerit is expanding the portfolio. Due to the new composition and a newly developed CVD – coating it is possible to cope with the high temperature developments as well as hardness conditions and additionally guarantees an ideal wear detection due to the golden shiny color.



LNUX -RWF



NEW



Radsatz

	Bestellbezeichnung Item code	Schneidstoffsorte Cutting materials	Bestell-Nr. Order No.	Verfügbarkeit Availability	Vorschub Feed f [mm / U rev]	Schnitttiefe Cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm]			
							IC	S	D1	RE
	LNUX 191940SN-RWF	BCP10T	5213686	●	0,25 - 1,30	2 - 6	19,05	10,00	6,35	4,0
	LNUX 191940SN-RWF	BCP20T	5213687	●	0,25 - 1,30	2 - 6	19,05	10,00	6,35	4,0
	LNUX 191940SN-BRWT	LCP15T	5031791	●	0,30 - 1,30	2 - 7	19,05	10,00	6,35	4,0
	LNUX 191940SN-BRWT	LCP25T	5055942	●	0,30 - 1,30	2 - 7	19,05	10,00	6,35	4,0
	LNUX 191940SN-RWT	BCP10T	5213680	○	0,30 - 1,30	2 - 7	19,05	10,00	6,35	4,0
	LNUX 191940SN-RWT	BCP20T	5213681	○	0,30 - 1,30	2 - 7	19,05	10,00	6,35	4,0
	LNUX 191940SN-BRW	LCP15T	5031793	●	0,50 - 1,50	2 - 10	19,05	10,00	6,35	4,0
	LNUX 191940SN-BRW	LCP25T	5055941	●	0,50 - 1,50	2 - 10	19,05	10,00	6,35	4,0
	LNUX 191940SN-RW	BCP10T	5213684	○	0,50 - 1,50	2 - 10	19,05	10,00	6,35	4,0
	LNUX 191940SN-RW	BCP20T	5213685	○	0,50 - 1,50	2 - 10	19,05	10,00	6,35	4,0

NEW

NEW

NEW

	Bestellbezeichnung Item code	Schneidstoffsorte Cutting materials	Bestell-Nr. Order No.	Verfügbarkeit Availability	Vorschub Feed f [mm / U rev]	Schnitttiefe Cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm]				
							L	IC	S	D1	RE
	LNUX 301940SN-RWF	BCP10T	5193622	●	0,40 - 1,70	4 - 17	30,00	19,05	12,00	6,35	4,0
	LNUX 301940SN-RWF	BCP20T	5213689	●	0,40 - 1,70	4 - 17	30,00	19,05	12,00	6,35	4,0
	LNUX 301940SN-BRW	LCP15T	5031452	●	0,50 - 1,70	4 - 14	30,00	19,05	12,00	6,35	4,0
	LNUX 301940SN-BRW	LCP25T	5055944	●	0,50 - 1,70	4 - 14	30,00	19,05	12,00	6,35	4,0
	LNUX 301940SN-RW	BCP10T	5213688	○	0,50 - 1,70	4 - 14	30,00	19,05	12,00	6,35	4,0
	LNUX 301940SN-RW	BCP20T	5213692	○	0,50 - 1,70	4 - 14	30,00	19,05	12,00	6,35	4,0
	LNUX 301940SN-BRWR	LCP15T	5031766	●	1,00 - 2,00	4 - 20	30,00	19,05	12,00	6,35	4,0
	LNUX 301940SN-BRWR	LCP25T	5055943	○	1,00 - 2,00	4 - 20	30,00	19,05	12,00	6,35	4,0
	LNUX 301940SN-RWR	BCP10T	5213690	○	1,00 - 2,00	4 - 20	30,00	19,05	12,00	6,35	4,0
	LNUX 301940SN-RWR	BCP20T	5213691	○	1,00 - 2,00	4 - 20	30,00	19,05	12,00	6,35	4,0

NEW

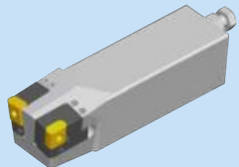
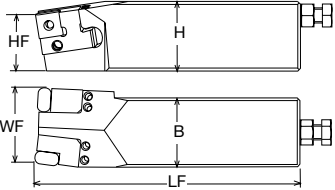
NEW

NEW

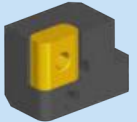
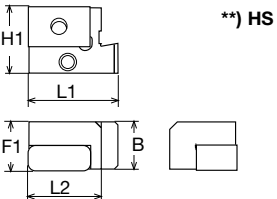
	Bestellbezeichnung Item code	Schneidstoffsorte Cutting materials	Bestell-Nr. Order No.	Verfügbarkeit Availability	Vorschub Feed f [mm / U rev]	Schnitttiefe Cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm]				
							L	IC	S	D1	RE
	CNMX 190740-BRWT	LCP25T	5065810	●	0,30 - 1,30	4 - 12	19,05	19,05	7,93	7,80	4,0

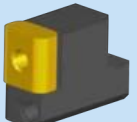
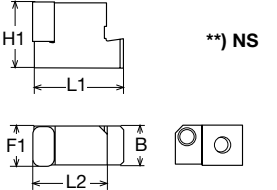
Bestellbeispiel: 10 Stück LNUX 191940SN-BRWT LCP15T or 5031791
Order example: 10 pieces LNUX 191940SN-BRWT LCP15T or 5031791





● Verfügbar ab Lager Available from stock
○ Auf Anfrage On request

	Grundhalter für Hegenscheidt-Maschine Basic holder for Hegenscheidt machine								Passende Kassetten Suitable cartridges
	Bestellbezeichnung Item Code	Bestell -Nr. Order No.	Verfügbarkeit Availability	B	H	LF	HF	WF	
	BRWT01-32 5555R	5196044	●	55	55	210	44	60	BRWC01...R BRWC02...L
	BRWT01-32 5555L	6401787	●	55	55	210	44	60	BRWC01...L BRWC02...R

Ersatzteile für die Klemmhalter Spare parts for Tool holder BRWT01-32 5555 R; BRWT01-32 5555 L							
							
Gewindestift Grub screw	Bestell -Nr. Order No.	Inbusschlüssel Allen key	Bestell -Nr. Order No.	6-kt-Schraube Hex-screw	Bestell -Nr. Order No.	6-kt-Mutter Hex nut	Bestell -Nr. Order No.
M6 x 16 ISO4028	5001133	V01-A0030	6407826	M12x50 DIN93388	9191977	M12 (Typ1) ISO 4032	5022893

	Kassetten Cartridges								Passende Platten Suitable inserts
	Bestellbezeichnung Item Code	Bestell -Nr. Order No.	Verfügbarkeit Availability	B	L1	L2	H1	F1	
 **) HS	BRWC01-LN19 3223R	6401782	●	22,5	42,4	35	32	23	LNUX 1919.
	BRWC01-LN19 3223L	6401781	●	22,5	42,4	35	32	23	
	BRWC01-LN30 3223R	6401784	●	22,5	42,4	35	32	23	LNUX 3019.
	BRWC01-LN30 3223L	6401783	●	22,5	42,4	35	32	23	

	Kassetten Cartridges								Passende Platten Suitable inserts
	Bestellbezeichnung Item Code	Bestell -Nr. Order No.	Verfügbarkeit Availability	B	L1	L2	H1	F	
 **) NS	BRWC02-LN19 3219R	6401786	●	18,5	42,4	35	32	19,1	LNUX 191940
	BRWC02-LN19 3219L	6401785	●	18,5	42,4	35	32	19,1	

Ersatzteile für die Kassetten Spare parts for Cartridges BRWC..						
						
Wendeschneidplatte f. Kasette Inserts for cartridge	Kniehebel Toogle Lever	Bestell -Nr. Order No.	Spannschraube Fixation screw	Bestell -Nr. Order No.	Inbusschlüssel Allen key	Bestell -Nr. Order No.
LNUX 191940, LNUX 301940	D02-18170	6403967	A03-08235	6401282	V01-A0030	6407826

*) Rechtsausführung wie gezeichnet, Linksausführung spiegelbildlich **) HS = Hauptschneide
 *) Righthand version drawn, lefthand version mirrorlike = Main cutting edge
 **) NS = Nebenschneide = Minor cutting edge
 ● Verfügbar ab Lager Available from stock
 ○ Auf Anfrage On request

Sorte Grade	ISO	Anwendungsbereich Application range	Werkstoffgruppe Material group						Bearbeitungsverfahren Application				Farbliche Darstellung der WSP je nach Beschichtung Color guide for inserts depending on coating	
			P Stahl Steel	M Rostfrei Stainless	K Grauguss Grey cast iron	N NE-Metalle Non-ferrous metals	S Hochwärmest High temperature materials	H Harte Werkstoffe Hard materials	T Drehen Turning	M Fräsen Milling	D Bohren Drilling	S Gewindebearbeitung Threading		
LCP15T	HC-P15		■						●					
	HC-K15				□				●					
LCP25T	HC-P25		■						●					
	HC-M25			□					●					
BCP10T	HC-P10		■						●					
	HC-K15				□				●					
BCP20T	HC-P20		■						●					
	HC-K25			□					●					

Anwendungsschwerpunkt
Application peak

Gesamtbereich nach ISO 513
Full range to ISO 513

■ Hauptanwendung
Main application
 □ Weitere Anwendungen
Further applications

● Standardsorte
Standard grade

Schneidstoffsorten Cutting grades

● LCP15T (HC-P15, HC-K15)

Drehsorte für Stahlwerkstoffe mit einer hohen Zugfestigkeit und Bearbeitungstemperatur. Auch für das Gussdrehen geeignet.

● LCP25T (HC-P25, HC-M25)

(Universelle Drehsorte)
Hauptsorte zum Drehen von Stahlwerkstoffen und leicht zerspanbarem rostbeständigem Stahl, bei mittleren Schnittgeschwindigkeiten, auch bei unterbrochenem Schnitt. Diese Mehrbereichssorte zeichnet sich durch hohe Verschleißfestigkeit und ausgezeichnete Zähigkeitseigenschaften in einem breiten Einsatzspektrum aus.

● BCP10T (HC-P10, HC-K15)

Verschleißbeständige Sorte mit CVD-Beschichtung, sehr gut geeignet bei hohen Schnittgeschwindigkeiten und glattem Schnitt. Ideal auch für hohe Stückzahlserien.

● BCP20T (HC-P20, HC-K25)

Zum Drehen von universellen Stahlwerkstoffen. Sorte besteht aus einem P20-Substrat mit einer CVD-Beschichtung. Hervorragend bei langem konstantem Schnitt bei mittlerer bis hoher Schnittgeschwindigkeit. Für leicht unterbrochene Bearbeitung, als auch zum Bearbeiten von Schmiedehaut und Zunder geeignet.

● LCP15T (HC-P15, HC-K15)

Grade for steel materials with a tensile strength and high temperature. Suitable for stainless steel application

● LCP25T (HC-P25, HC-M25)

(Universal turning grade)
Main grade for machining steel materials and easily machinable stainless steels at medium cutting speeds, included interrupted cut. This general purpose grade is characterized by the properties of high wear resistance and excellent characteristics across a wide range of applications.

● BCP10T (HC-P10, HC-K15)

Wear resistant grade with CVD coating, very good suitable for high cutting speeds and smooth cut. Ideal also for high quantities.

● BCP20T (HC-P20, HC-K25)

For turning of universal steel materials. Grade is a P20 substrate with CVD coating. Excellent for long constant cuts, on medium to high cutting speeds. For slight broken machining as well as suitable for machining of forging skin and tinder.



Technische Hinweise

Technical hints

www.boehlerit.com


Schnittwertempfehlungen für Drehen LCP15T und LCP25T

Turning data recommendations for LCP15T and LCP25T

Werkstoffgruppe Material group	Gliederung der Werkstoff-Hauptgruppen und Kennbuchstaben			Brinell Härte Brinell hardness HB	Schnittgeschwindigkeit Cutting speed v_c (m/min)	
	Werkstoff Material				LCP15T	LCP25T
						
P	Unlegierter Stahl ¹⁾ Unalloyed steel ¹⁾	ca. 0,15 %C	geglüht annealed	125	70 - 200	50 - 170
		≈ 0,15 %C				
		ca. 0,45 %C	geglüht annealed	190		
		≈ 0,45 %C				
		ca. 0,45 %C	vergütet hardened and temp.	250		
		ca. 0,75 %C	geglüht annealed	270		
		≈ 0,75 %C				
		ca. 0,75 %C	vergütet hardened and temp.	300		
		≈ 0,75 %C				
	Niedrig legierter Stahl ¹⁾ Low-alloy steel ¹⁾		geglüht annealed	180	60 - 170	40 - 140
			vergütet hardened and temp.	275		
			vergütet hardened and temp.	300		
		vergütet hardened and temp.	350			
Hochlegierter Stahl und hochlegierter Werkzeugstahl ¹⁾ High-alloy steel and high alloy tool steel ¹⁾		geglüht annealed	200	50 - 150	30 - 120	
		gehärtet und angelassen hardened and temp.	325			
	Nichtrostender Stahl ¹⁾ Stainless steel ¹⁾		ferritisch/martensitisch geglüht ferritic/martensitic annealed		200	30 - 120
			martensitisch vergütet martensitic hardened and temp.		240	
K	Grauguss Grey cast iron	perlitisch/ferritisch perlitic/ferritic	180	60 - 200	-	
		perlitisch (martensitisch) perlitic (martensitic)	260			
	Gusseisen mit Kugelgraphit Nodular graphite cast iron	ferritisch ferritic	160			
		perlitisch perlitic	250			
	Temperguss Malleable cast iron	ferritisch ferritic	130			
		perlitisch perlitic	230			
M	Nichtrostender Stahl ¹⁾ Stainless steel ¹⁾	austenitisch ²⁾ , abgeschreckt austenitic ²⁾ , quenched	180	-	40 - 100	

¹⁾ und Stahlguss and cast steel

 = Nassbearbeitung wet machining

 = Trockenbearbeitung dry machining

Schnittwertempfehlungen für Drehen BCP10T und BCP20T

Turning data recommendations for BCP10T and BCP20T

Werkstoffgruppe Material group	Gliederung der Werkstoff-Hauptgruppen und Kennbuchstaben			Schnittgeschwindigkeit Cutting speed v _c (m/min)	
	Werkstoff Material	Brinell Härte Brinell hardness HB			
			BCP10T	BCP20T	
P	Unlegierter Stahl ¹⁾ Unalloyed steel ¹⁾	ca. 0,15 %C geglüht ≈ 0,15 %C annealed	125	90 - 220	70 - 200
		ca. 0,45 %C geglüht ≈ 0,45 %C annealed	190		
		ca. 0,45 %C vergütet ≈ 0,45 %C hardened and temp.	250		
		ca. 0,75 %C geglüht ≈ 0,75 %C annealed	270		
		ca. 0,75 %C vergütet ≈ 0,75 %C hardened and temp.	300		
	Niedrig legierter Stahl ¹⁾ Low-alloy steel ¹⁾	geglüht annealed	180	80 - 190	60 - 160
		vergütet hardened and temp.	275		
		vergütet hardened and temp.	300		
		vergütet hardened and temp.	350		
	Hochlegierter Stahl und hochlegierter Werkzeugstahl ¹⁾ High-alloy steel and high alloy tool steel ¹⁾	geglüht annealed	200	70 - 170	50 - 140
		gehärtet und angelassen hardened and temp.	325		
	Nichtrostender Stahl ¹⁾ Stainless steel ¹⁾	ferritisch/martensitisch geglüht ferritic/martensitic annealed	200	-	-
		martensitisch vergütet martensitic hardened and temp.	240		
	K	Grauguss Grey cast iron	perlitisches/ferritisch perlitic/ferritic	180	80 - 220
perlitisches (martensitisch) perlitic (martensitic)			260		
Gusseisen mit Kugelgraphit Nodular graphite cast iron		ferritisch ferritic	160		
		perlitisches perlitic	250		
Temperguss Malleable cast iron		ferritisch ferritic	130		
	perlitisches perlitic	230			
M	Nichtrostender Stahl ¹⁾ Stainless steel ¹⁾	austenitisch ²⁾ , abgeschreckt austenitic ²⁾ , quenched	180	-	60 - 120

¹⁾ und Stahlguss
and cast steel

Trockenbearbeitung
Dry machining

Nassbearbeitung
Wet machining

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