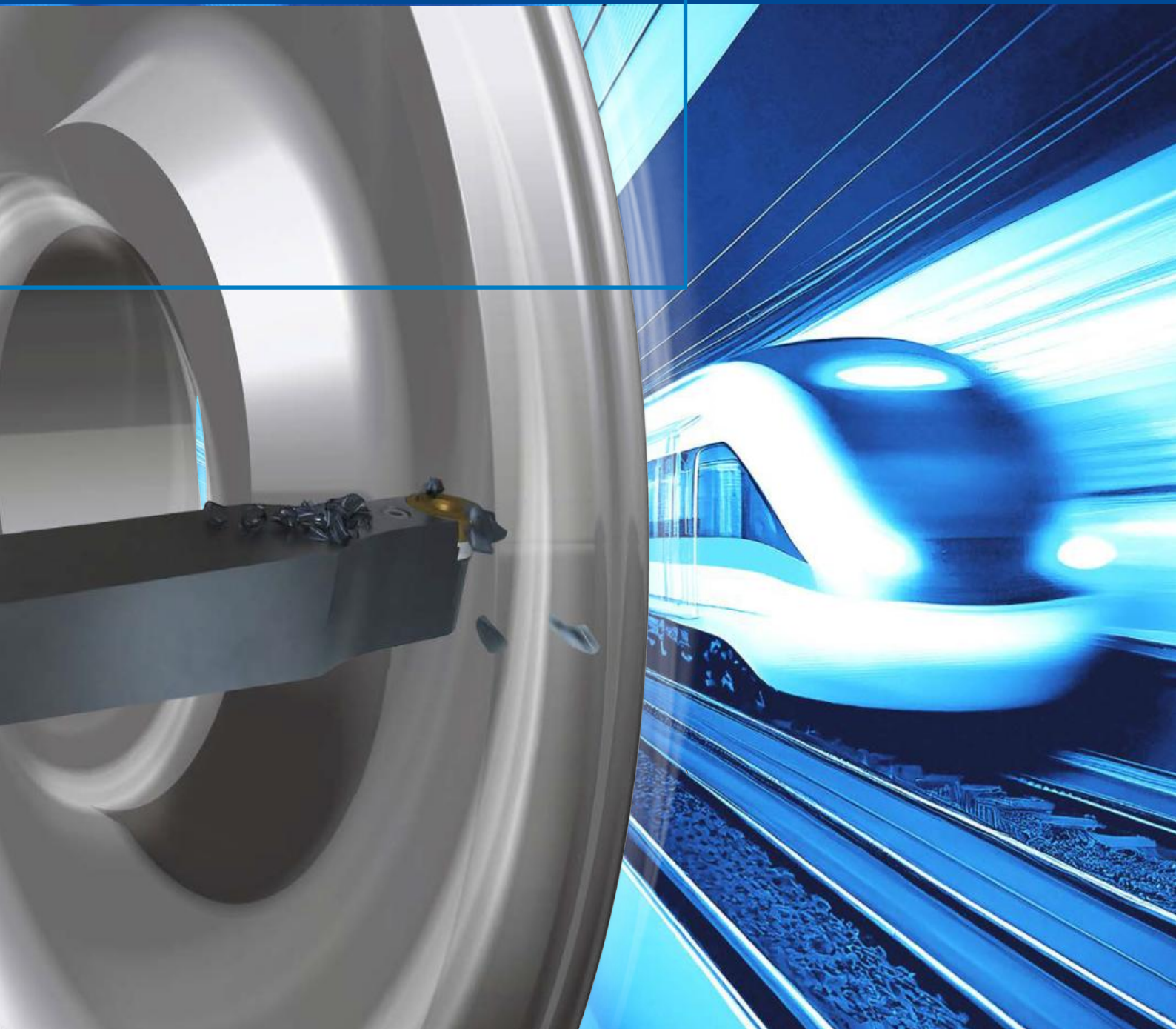


boehlerit

火车轮加工
Railway wheel machining



Boehlerit – 硬质合金开发先驱

Boehlerit是一家家族企业，隶属于Brucklacher集团（Leitz、Bilz和Boehlerit），总部位于奥地利小镇卡芬贝格，为金属、木材、塑胶和复合材料加工的硬质合金和刀具制定了全球标准。

凭借用于铣削、车削、钻孔和成型的切削材料、半成品、精密刀具和刀具系统，Boehlerit确保了全球范围内的工艺安全和效率。该公司广泛的产品组合包括用于曲轴加工以及采矿业、棒材剥皮、管材和板材加工以及重型加工的高度专业化工具。Boehlerit产品系列还具有用于建筑部件和磨损保护的碳化物。

在涂层技术方面，Boehlerit在全球范围内占据着独特的地位，从有史以来第一个奈米CVD黏合层到全球最硬的钻石层。凭借在冶金、涂层技术和最先进的冲压技术方面的多年经验，Boehlerit成为刀具制造商的高素质开发合作伙伴。

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

生产基地

Boehlerit集团制定了国际品质标准。每年，公司都会投资新的生产技术并扩大其先进生产基地的产能。奥地利、德国和土耳其制造的高品质产品融合了最新的研发成果。

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.



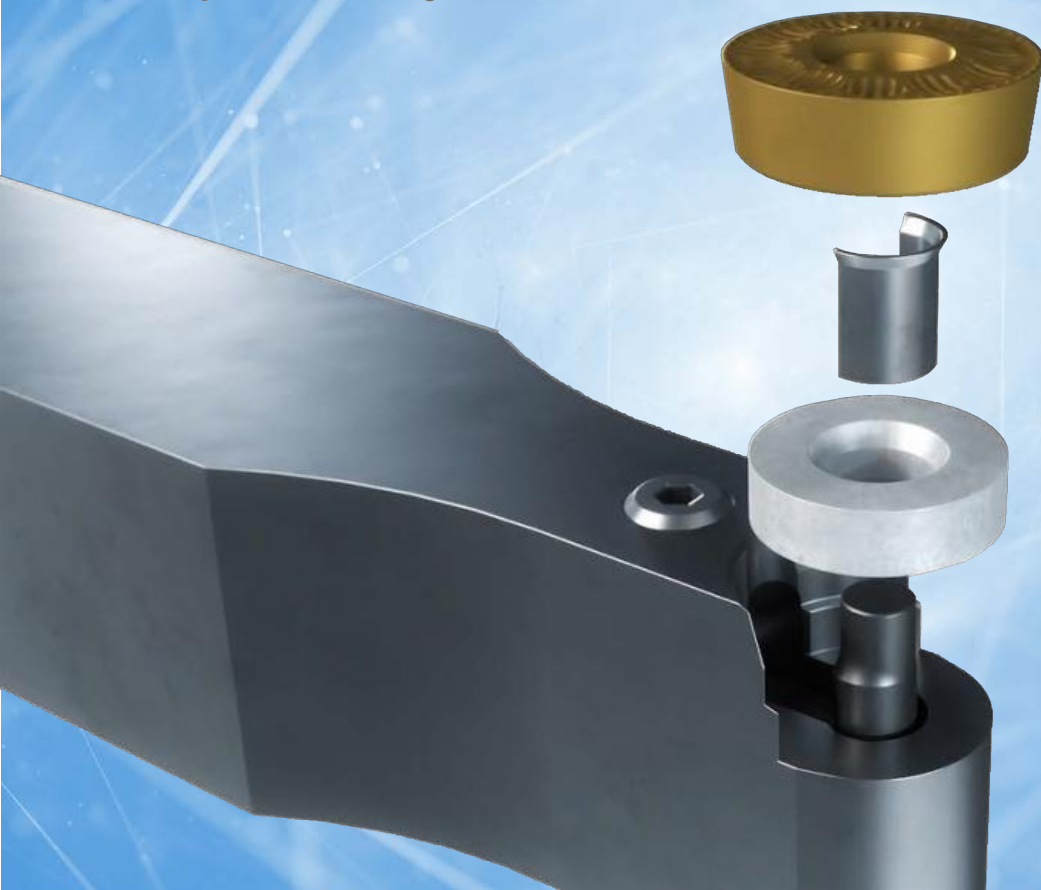
Boehlerit Kapfenberg (Headquarter)
in der Steiermark/Österreich Styria/Austria



Boehlerit Sert Metal
in Istanbul/Türkei Turkey



Boehlerit Deutschland
in Oberkochen Deutschland/Germany



火车轮加工

铁路车轮的轮面和轮缘对于确保车辆的安全运行和舒适运行至关重要。Boehlerit 提供专门改造的刀具解决方案，用于翻转磨损的轮对。一般来说，铁路车轮加工分为新轮车削和修轮。

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.



新车轮车削

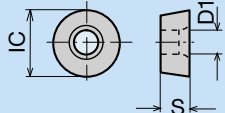
在新的车轮车削中，所需的车轮（例如火车、货车、地铁）是使用复杂的刀具解决方案（圆形可转位刀片）制造的。首先，透过锻造和滚压对车轮进行粗略预加工，然后使用Boehlerit专门改装的刀具将其加工至最终轮廓。该工艺允许湿法和干法生产。

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.

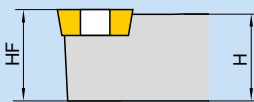
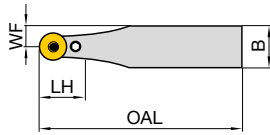
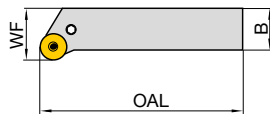


Radsatz

	Bestellbezeichnung Item code	Schneid- stoffsorte 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
	RCMX...R25								
	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
	RCMX...								
	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...								
	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...R40								
	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
	RCMH....R40								
	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...R25								
	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
	RCMR...R40								
	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

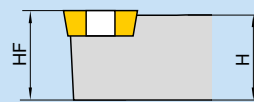
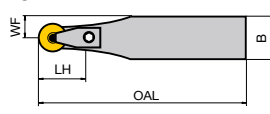
Bestellbeispiel Order example: 10 Stück 10 Pieces RCMX 2507M0-R25 oder or 5031805

● 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	
PRDC-N  	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..
PRGC-R/L  	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	
PRDC-N  	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.	Senk- kopfschraube 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



铁路车轮改造

铁路车轮修复涉及翻转磨损的轮组。根据磨损程度，这个过程可以重复几次。带有纵向板的刀具系统首先用于加工胎面，然后加工车轮轮廓和凸缘。应选择尽可能最大的切削深度，以保持尽可能短的加工时间。然而，这在很大程度上取决于所用车轮的磨损状况。Boehlerit生产具有高水平专业知识重型加工刀具。Boehlerit的全面承诺一方面代表创新、持续的品质开发和专业知识，另一方面代表重型加工领域的悠久传统。

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.



全新断屑槽型

借助新的RWF（用于精加工操作的断屑几何形状），Boehlerit为铁路车轮修复的车削工艺提供了另一种优化。新开发的断屑槽透过专门开发的倒角抑制机器的振动，从而确保在较低进给范围内实现最佳断屑。凭借这种几何形状以及改进的牌号BCP10T和BCP20T，Boehlerit正在扩大产品组合。由于采用了新的成分和新开发的CVD涂层，因此可以应对高温发展和硬度条件，并且由于金色闪亮的颜色也提供了理想的磨损检测。

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.

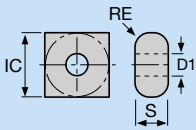
LNUX -RWF



NEW



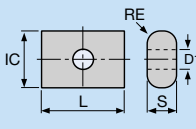
Radsatz

	Bestellbezeichnung Item code	Schneid- stoffsorte 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

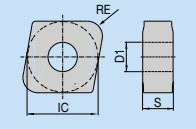
NEW

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							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

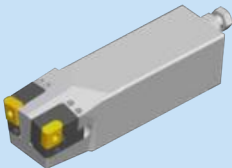
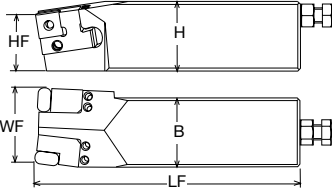
NEW

NEW

	Bestellbezeichnung Item code	Schneid- stoffsorte 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

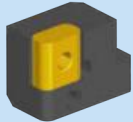
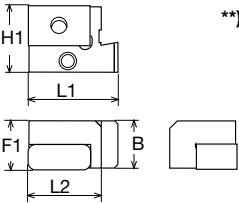
Bestellbeispiel: 10 Stück LNUX 191940SN-BRWT LCP15T or 5031791
Order example: 10 pieces LNUX 191940SN-BRWT LCP15T or 5031791

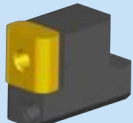
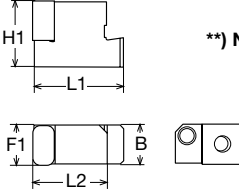
● Verfügbar ab Lager Available from stock
○ Auf Anfrage On request

	Grundhalter für Hegenscheidt-Maschine Basic holder for Hegenscheidt machine								Passende Kassetten Suitable cartridges
	Bestellbezeichnung Item Code	Bestell -Nr. Order No.	Verfüg- barkeit Availa- bility	B	H	LF	HF	WF	
BRWT01...R/L *) 	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	Inbusschlüssel Allen key	6-kt-Schraube Hex-screw	6-kt-Mutter Hex nut
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.	Verfüg- barkeit Availability	B	L1	L2	H1	F1	
BRWT01...R/L *)  **) 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.	Verfüg- barkeit Availability	B	L1	L2	H1	F	
BRWC02...R/L *)  **) 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. Kassette Inserts for cartridge	Kniehebel Toogle Lever	Spannschraube Fixation screw	Inbusschlüssel Allen key
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	M	K	N	S	H	T	M	D	S	
		01 05 10 15 20 25 30 35 40 45 50	Stahl Steel	Rostfrei Stainless	Grauguss Grey cast iron	NE-Metalle Non-ferrous metals	Hochwarmfest High temperature materials	Harte Werkstoffe Hard materials	Drehen Turning	Fräsen Milling	Bohren Drilling	Gewinde- bearbeitung 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

● LC25T (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)		
					LCP15T	LCP25T	
	Werkstoff Material						
P	Unlegierter Stahl ¹⁾ Unalloyed steel ¹⁾	ca. 0,15 %C ≈0,15 %C	geglüht annealed	125	70 - 200	50 - 170	
		ca. 0,45 %C ≈0,45 %C	geglüht annealed	190			
		ca. 0,45 %C ≈0,45 %C	vergütet hardened and temp.	250			
		ca. 0,75 %C ≈0,75 %C	geglüht annealed	270			
		ca. 0,75 %C ≈0,75 %C	vergütet hardened and temp.	300			
	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 ferritic/martensitic	geglüht annealed		200	30 - 120
			martensitisch martensitic	vergütet 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		Brinell Härte Brinell hardness HB	Schnittgeschwindigkeit Cutting speed v_c (m/min)	
				BCP10T	BCP20T
				 	 
P	Unlegierter Stahl ¹⁾ Unalloyed steel ¹⁾	ca. 0,15 %C gegläht ≈ 0,15 %C annealed	125	90 - 220	70 - 200
		ca. 0,45 %C gegläht ≈ 0,45 %C annealed	190		
		ca. 0,45 %C vergütet ≈ 0,45 %C hardened and temp.	250		
		ca. 0,75 %C gegläht ≈ 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 ge- glüht ferritic/martensitic annealed	200		
		martensitisch vergütet martensitic hardened and temp.	240		
K	Grauguss Grey cast iron	perlitisches/ferritisches perlitic/ferritic	180	80 - 220	-
		perlitisches (martensitisches) perlitic (martensitic)	260		
	Gusseisen mit Kugelgraphit Nodular graphite cast iron	ferritisches ferritic	160		
		perlitisches perlitic	250		
	Temperguss Malleable cast iron	ferritisches 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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