



## B19 Fräswendeplatten und Schnittdaten

Milling inserts and parameters, Plaquettes de fraisage et paramètres, Inserti e parametri di taglio

			K15M (code 8)	AL20 (code 24)				
	<b>JMB19-429R30-</b> 27,9x12,7x5,0 R3,0	Order- No.	<b>B19D-NY08</b>	<b>B19D-AU24</b>				
<b>U</b> ▼▼▼▼		f <sub>z</sub> [mm]	0,40 (0,20-0,70)	0,45 (0,25-0,75)				
			10	10				

V <sub>c</sub> [m/min]	Stahl Steel Acier Acciaio	Rostfrei Stainless Acier inoxydable Inossidabile	Guss Cast iron Fonte Ghisa	NE-Metalle Non-ferrous metals Non ferreux Metalli non ferrosi	Hochwarmfest Highly heat-resistant Superalliages Resistente al calore	Gehärtet Tempered Aciers traités Temprato
<b>K15M</b>				800 (400 - 1000)		
<b>AL20</b>				800 (400 - 1000)		

### Ersatzteile Spare parts, Pièces de rechange, Parti di ricambio

	<b>SS 5,0-1</b> (M = 4,8-5,0 Nm)		<b>T 20</b>		<b>Fett</b> Grease, Graisse, Grasso
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## B19 Rampingwinkel

Ramping angle type, Angle de ramping, Angolo rampa inserti

D	Ramping- winkel Ramping angle type Angle de ramping Angolo rampa inserti max. α (°)	Bearbeitungs- weg Processing path Distance parcourue lunghezza di lavorazione min. L (mm)	a <sub>p</sub> max. ø/2	ø WP Insert Plaquette Inserti	WP Insert Plaquette Inserti
32	14,0	20	5,00	12,70	JMB19 (FP 429 R..)
35	12,3	23	5,00	12,70	
42	9,5	30	5,00	12,70	
52	7,1	40	5,00	12,70	
66	5,3	54	5,00	12,70	
80	4,2	68	5,00	12,70	