Jongen Werkzeugtechnik GmbH & Co. KG

Internal product Information

The New Inserts

FP 63 R 0,8

a completion to the product range Type 63

1. Technical Description

Die Type FP 63 R0,8

As product range expansion the insert type FP 63 R0,8 with edge radius 0,8 mm has been added to our sales programme. The geometry data and the recommendation for use are therefore identical.

2. Technical Description

Step milling of all usual materials with availability of corresponding different radius on the working piece.

3. Coating Qualities

HT32

Code 33, ISO-Classification M20-M30

Hard wearing and tough finest grain carbide with a AlTiN- Nanocomposit-coating for middle – high cutting speeds and middle feed rates. This quality is suitable for dry milling and can also be adopted with cooling. Application areas are roughing and finishing high grade materials, tool steel and stainless steel.

HT45

Code 31, ISO-Classification P30-P35

Very tough fine grain carbide with a AlTiN- Nanocomposit-coating for middle – high cutting speeds and high feed rates. This quality is suitable for dry milling and can also be adopted with cooling. Application areas are roughing and finishing of almost all steels and cast iron qualities such as: Structural steel, tool steel, heat-treatable steel, as well as unalloyed steel, low alloyed steel, high alloyed steel and also grey cast iron, globular raphite cast iron etc.

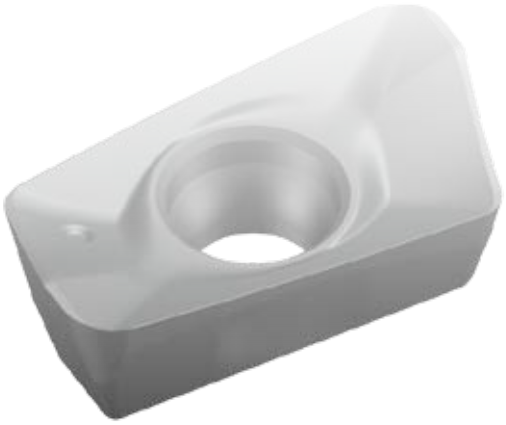
HT20

Code 32, ISO-Classification K15-K20

Very hard wearing fine grain carbide with a AlTiN- Nanocomposit-coating for middle – high cutting speeds with high feed rates. This quality is suitable for dry milling and can also be adopted with cooling. Application areas are roughing and finishing of cast iron materials, e.g. grey-, tempered-, vermicular-, graphite- and globular graphite cast iron.

FP 63 R0,8 > Precision sintered insert

HT32 = 7,50 €
HT45 = 7,50 €
HT20 = 7,50 €



4. Cutting Data Recommendations

		HT45 (code 31)	HT32 (code 33)	HT20 (code 32)				
 **FP 63 R0,8** (B21) 6,8x4,0x2,5 R0,8	~							
	f_z [mm]	0,08 (0,04-0,20)	0,08 (0,04-0,20)	0,10 (0,05-0,20)				
	VPE	20	20	20				

V_c [m/min]	Steel	Stainless	Cast iron	Non-ferrous metals	Highly heat-resistant	Tempered
HT45	250 (200 - 350)	240 (140 - 300)	240 (130 - 280)			
HT32	250 (200 - 350)	240 (140 - 300)			60 (40 - 200)	
HT20			260 (180 - 350)			80 (40 - 120)

axial depth of cut max. 6 mm

The above mentioned data are standard values.
Up and down corrections are admitted depending on the machine type, working piece and holding fixture.