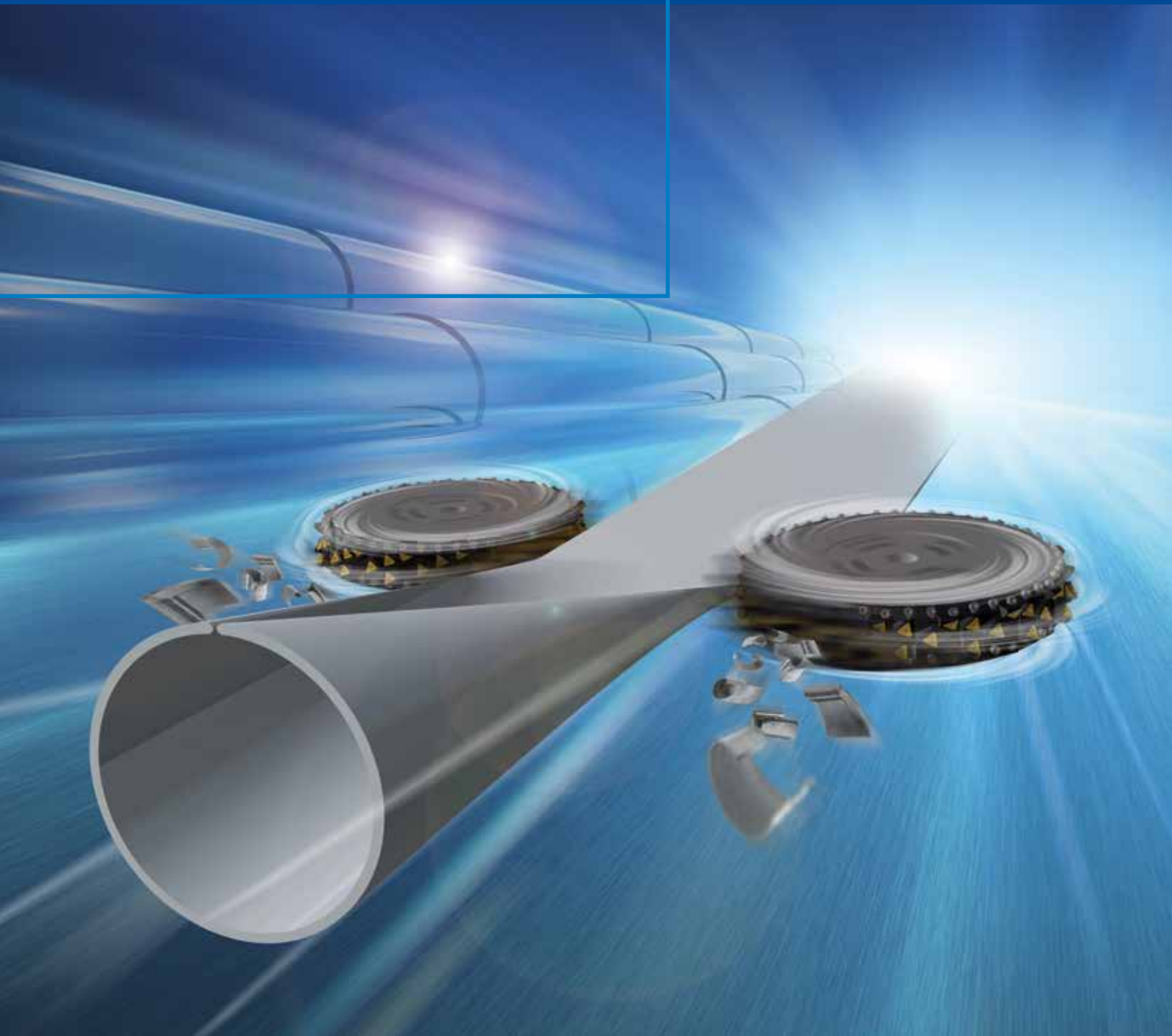


boehlerit

鋼管加工

Tube processing



Boehlerit 於1932年成立，為位於Düsseldorf的Böhler公司做鎢鋼生產。1950年奧地利鋼鐵小鎮Kapfenberg開始生產鎢鋼，也是Boehlerit集團今天的總部所在地。1991年，Leitz集團從德國Oberkochen收購了整個Boehlerit集團，這標誌著Boehlerit歷史上的一個重要里程碑。

自從併入Leitz集團以來，Boehlerit已成功發展成為集團的材料切削中心。它是世界領先的鎢鋼切削材料生產商之一，其產品用於木材、塑膠和金屬切削刀具以及車削、銑削、鑽孔、棒料剝皮、鋼鐵工業和曲軸加工刀具。

用於結構件和抗磨耗的鎢鋼是Boehlerit的另一項核心能力。利用與國際領先的攻牙夾頭生產商Bilz的協同效應，為全球客戶帶來利益。

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、西班牙和土耳其製造的高品質產品融合了最新的研發成果。

研究與開發

Boehlerit的研發部門為了滿足鎢鋼作為切削和抗磨耗材料，必須跟著不斷變化的需求（提高生產力、改進材料、新應用）。它憑藉先進的分析方法並與大學和研究機構密切合作，開發的成果是Boehlerit生產出新的、高品質的、應用導向的產品。

每個部門的具體研發

豐富的經驗和集中的專業知識是服務和產品的核心。作為鋼鐵業刀具的主要焦點，Boehlerit已擴展了用於管材製造的刀具和刀片程序。除了標準計劃外，Boehlerit還具有中型公司的靈活性此額外優勢。因此，可以快速、經濟地根據客戶規格的提供特定解決方案。

Boehlerit – Pioneers in carbide development

The Boehlerit brand was established in 1932 for the carbide production of the Böhler company in Düsseldorf. 1950 was the beginning of carbide production in the Austrian steel town of Kapfenberg where the Boehlerit Group's headquarters are located today. The take-over of the entire Boehlerit Group by the Leitz Group from Oberkochen, Germany in 1991 marked an important milestone in the history of Boehlerit. Since its integration into the Leitz Group, Boehlerit has successfully developed into the group's centre for cutting materials. It is one of the world's leading producers of carbide cutting materials for tools for wood, plastic and metal cutting and tools for turning, milling, drilling, bar peeling, steel industry and crankshaft machining.

Carbide for structural parts and wear protection are yet another core competency of Boehlerit. Synergies with the affiliated company Bilz, the internationally leading producer of tapping chucks, are utilised to the benefit of customers worldwide.

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, Spain and Turkey incorporate the latest research and development findings.

Distribution

Together with the Bilz Group and exclusive partners, Boehlerit Group is represented on nearly all continents. Absolute dedication to its customers, swift consulting and supply service and the highest product quality are its core principles. Our highly specialised distribution organisations with more than 300 qualified application engineers and sales managers live by these principles, and our experienced field staff is always and everywhere on hand nearby to provide consultation and service for any challenge our customers may be faced with.

Research and Development

The Research and Development department of Boehlerit meets the continuously changing demands (increased productivity, improved materials, new applications) that carbide, as a cutting and wear protection material must fulfil. It does so with its advanced analytical methods and in close cooperation with universities and research institutions. The result of the company's concentration on development are new application-oriented products of the highest quality – made by Boehlerit.

Specific Research & Development for each division

Extensive experience and concentrated know-how is at the core of service and products. As a main focus in steel industry tooling, Boehlerit has extended the tool and insert programme for tube and pipe manufacturing. In addition to its standard programme, Boehlerit has the extra advantage of having the flexibility of a medium-sized company. As a result specific solutions according to customers specifications can be realized quickly and economically.

技術優勢，客戶受益	Technological advantages, customer benefits	4
焊縫邊緣處理 刀盤 銑刀片 刮刀片	Weld edge processing Cutters Milling inserts Scarfing inserts	7 8 10 14
內部焊縫處理 刮環 刮刀配件 刮刀片 刀匣	Sheet edge preparation internal Scarfing rings Scarfing bits Scarfing inserts Cartridges	15 16 17 19 20
外部焊縫處理 刮刀片 刀桿	Weld seam scarfing external Scarfing inserts Tool holder	21 25
管端坡口加工 刀具支撐系統 複製支撐 用於管端坡口的可轉位刀片 刀匣的命名系統 與倒角角度和壁厚相關的刀具選擇 刀匣和備用零件 刀匣分解圖 管端加工切削參數建議	Pipe end bevelling Tool support system Copy support Indexable inserts for pipe end bevelling Designation system for cartridges Choice of tool in relation to chamfer angle and wall thickness Cartridges and spare parts Exploded views cartridges Cuttingdata recommendations for tube end bevelling	29 30 31 32 34 35 36 41 42
技術資訊 牌號概覽 ISO命名系統	Technical hints Grade overview ISO designation system	44 46
代理商資訊	Sales organisations	48

生產基地
Production sites



Oberkochen
Boehlerit
德國
Germany



Barcelona
Boehlerit
西班牙
Spain



Istanbul
Boehlerit
Sert Metal
土耳其
Turkey




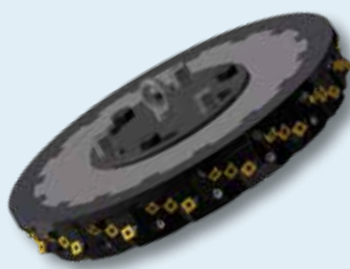
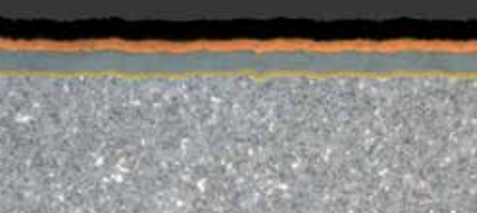
Kapfenberg BOEHLERIT 奧地利, Austria

Technische Änderungen und Druckfehler vorbehalten.
Subject to changes from technical development and printing errors.

技術優勢 Technological advantages

客戶受益 Customer benefits

開發 Development

<p>最佳化的數學模型</p> <p>Optimised mathematical models</p>	<p>切削參數機床功率 Cutting parameter machine power</p>  <p>■ 內倒角 ■ 面倒角 ■ 外倒角</p>	<p>用於找到最佳切削參數（包括必要的切削功率）的數學模型</p> <p>Mathematical models for the precise determination of optimal cutting parameters, including necessary cutting power</p>
<p>特定應用的刀具設計</p> <p>Application-specific tool design</p>		<p>刀具適用於所有工件幾何形狀和尺寸；不會因為尺寸過小而影響強度，也不會因為尺寸過大而導致成本高昂</p> <p>Tools are available for all workpiece geometries and dimensions; no undersizing that could compromise strength or costly oversizing.</p>
<p>特定應用的刀具設計</p> <p>Application-specific tool design</p>		<p>刀片母材與塗層的完美結合保證了不同材料加工的最高安全性</p> <p>The perfect combination consisting of basic substrate and coating guarantee highest security on machining of different materials</p>


焊縫邊緣處理 Weld edge processing

<p>客製化的高端刀具</p> <p>Customer-specific high-end tools</p>		<p>即使是最大直徑，也能實現精確的真實運作特性和輪廓精度。精心挑選的材料和熱處理可確保耐久性強度，從而確保數十年的安全運作</p> <p>Precise true-running characteristics and profile accuracy even for biggest diameters. Carefully selected materials and heat treatments guarantee endurance strength and thus fail-safe operation over decades.</p>
<p>模組化刀具系統</p> <p>Modular tool system</p>		<p>由於可以更換刀片架，一個刀盤本體允許不同的銑削輪廓</p> <p>One base body allows for different milling profiles as the cartridges may be exchanged.</p>
<p>刀匣系統</p> <p>Cartridge system</p>		<p>根據具體要求進行快速且有效率的重組。減少運輸刀具的數量，從而減少庫存成本。需要更換刀匣時無需進行調整，減少因刀具損壞而導致的停機時間</p> <p>Fast and efficient retooling according to specific requirements. Reduction of the number of carriers and thus also of storage costs. No adjustment is required when a cartridge needs to be changed, reduced downtime due to damaged tools.</p>

技術優勢 Technological advantages

客戶受益 Customer benefits

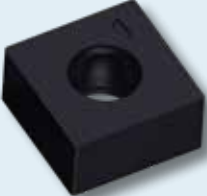
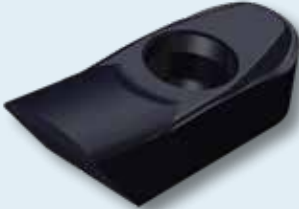
焊縫處理 (內部和外部) Welded seam scarfing (internal and external)

<p>標準化和客戶特定的刀具</p> <p>Standardised and customer-specific tools.</p>		<p>標準刀架可在短時間內提供，但也可短時間交付客製化產品</p> <p>Standard holders available within a short time; custom-made items are also promptly available.</p>
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管端坡口加工 Pipe end bevelling

<p>最高水準的客製化製造</p> <p>Custom-made items at the highest level</p>		<p>使用經過驗證的複製系統精確加工所需的輪廓，即使是橢圓形管</p> <p>Precise machining of the required profiles even on oval-shaped tubes, because of the tried-and-tested copying system.</p>
<p>模組化刀具系統</p> <p>Modular tooling system</p>		<p>透過更換刀匣可實現多種斜角輪廓</p> <p>Exchangeable cartridges allow chamfering of different profiles.</p>

刀片 Inserts

<p>標記為常規定位</p> <p>Marked for regular positioning</p>		<p>優化的同心度屬性及使用者的定向輔助</p> <p>Optimised true-running characteristics and aid for user orientation.</p>
<p>應用優化的刀片</p> <p>Application-optimised cutting inserts</p>		<p>幾何形狀和牌號確保在管道和焊縫邊緣加工中經濟高效地使用</p> <p>Geometry and grade ensure cost-effective use in pipe and weld edge processing</p>



管加工影片



管加工官網簡介



焊縫邊緣處理

Weld edge
processing

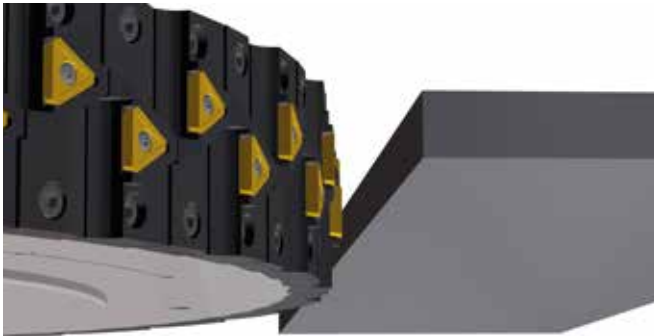




系統優勢

- 容屑槽的設計使進給和銑削深度最大化，同時避免切屑堵塞。
 - 止動環+保護板的組合允許端面倒角的腹板厚度調整並保護刀匣免受損壞。
 - 定位零件可調整端面倒角厚度。
 - 透過更換刀匣，可以使用同一刀盤本體生產不同的輪廓。
 - 若損壞，刀盤本體受到保護，並且無需任何調整即可更換刀匣。
 - 備用零件數量少（螺絲、定位零件）。
- Design of the chip pocket allows the maximizing of the feed as well as of the milling depth while simultaneously avoiding chip impact.
 - Combination of stop ring + protective plate allows web thickness adjustments of the face chamfer and protects the cartridge against damages.
 - Distance pieces allow adjustments of the face chamfer thickness.
 - Different profiles by exchanging the cartridges but using the same cutter body.
 - In case of damage, the cutter body is protected and cartridges can be replaced without any adjustment
 - Small amount of spare parts (screws, distance pieces)

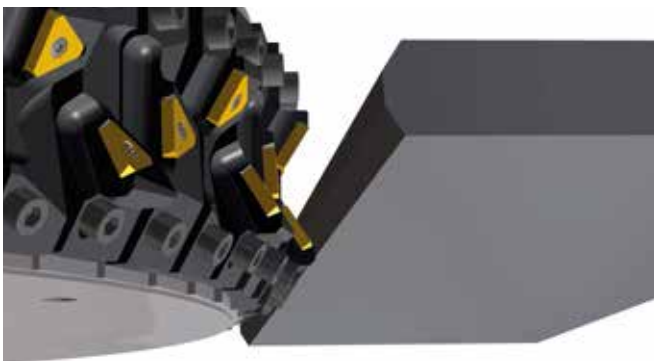
I-輪廓
I-profile



I + V-輪廓 = 附 2 個系列銑刀的X-輪廓
I + V-profile = X-profile with 2 serial cutters

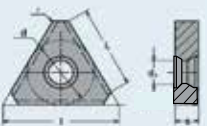




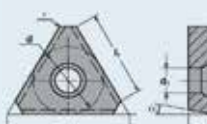


X-輪廓 / 單一刀盤
X-profile / One cutter






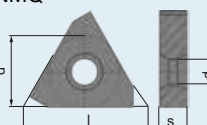


Y-輪廓
Y-profile



TNNQ 	Bestellbezeichnung Ordering Code								Sorte Grade	Ersatzteil Spare part
		l	l ₁	d	s	d ₁	r	α	LCP37M	
	TNNQ-3307	33,00	27,90	19,05	7,00	6,7	0	0°	●	A02-60160 M6x16

TPNX 	Bestellbezeichnung Ordering Code								Sorte Grade	Ersatzteil Spare part
		l	l ₁	d	s	d ₁	r	α	LCP37M	
	TPNX-3106	31,00	22,69	17,90	6,35	6,6	0,0	11°	●	A02-60160 M6x16
	TPNX-3307	33,00	24,28	19,05	7,00	6,6	1,2	11°	●	
	TPNX-2807	28,58	24,2	16,5	7,00	5,5	1,2	11°	●	A06-45120 M4,5x12

TPNX 	Bestellbezeichnung Ordering Code								Sorte Grade		Ersatzteil Spare part
		l	l ₁	d	s	d ₁	r	α	BCP30E	LCP37M	
	TPNX-330716	33,00	27,45	19,05	7,00	6,6	1,6	11°	●	●	A02-60160 M6x16
	TPNX-330727	33,00	23,64	19,05	7,00	6,6	2,7	11°		●	
	TPEX-330727	33,00	23,64	19,05	7,00	6,6	2,7	11°		●	

TNMQ 	Bestellbezeichnung Ordering Code								Sorte Grade	Ersatzteil Spare part
		l	l ₁	d	s	d ₁	r	α	LCP37M	
	TNMQ-2706	27	-	15,88	6,35	5,6	-	0°	●	A02-50140 M5x14

實際的顏色和圖片可能有差異
Colours of the original indexable inserts may deviate from the illustration!

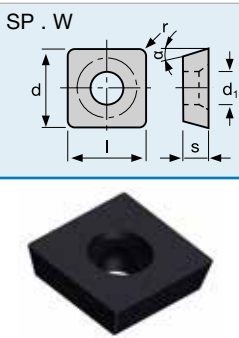


- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

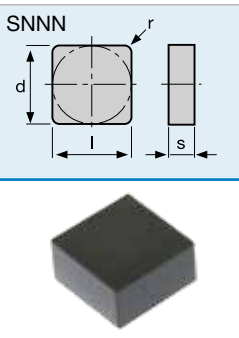
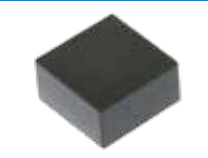
 SNEX	Bestellbezeichnung Ordering Code	l	l ₁	d	s	d ₁	r	α	Sorte Grade		Ersatzteil Spare part
									LCP37M		
	SNEX-150704	15,88	-	15,88	7,94	5,5	0,4	-	●		A02-50140 M5x14
	SNEX-150706	15,88	-	15,88	7,94	5,5	0,6	-	○		
	SNEX 170704	17,5	-	17,5	7,94	5,5	0,4			○	
	SNEX-190704	19,05	-	19,05	7,94	6,6	0,4	-		○	A02-60160 M6x16
	SNEX-200704	20	-	20	7	6,2	0,4	-		○	

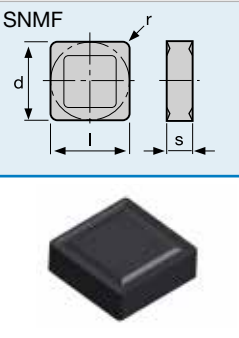

 SNNX	Bestellbezeichnung Ordering Code	l	l ₁	d	s	d ₁	r	α	Sorte Grade		Ersatzteil Spare part
									BCP30E	LCP37M	
	SNNX-150704	15,88	-	15,88	7,94	5,5	0,4	-	●	●	A02-50140 M5x14
	SNNX-190704	19,05	-	19,05	7,94	6,6	0,4	-	●	●	

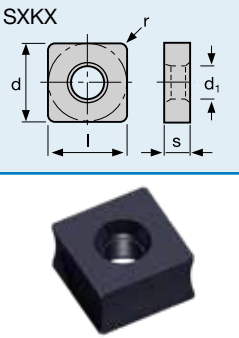


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SP . W 	Bestellbezeichnung Ordering Code								Sorte Grade	Ersatzteil Spare part
	l	l ₁	d	s	d ₁	r	α	LCP37M		
	SPNW 190604	19,05	-	19,05	6,35	6,6	0,4	11°	●	A02-60160 M6 x 16
	SPGW 190612	19,05	-	19,05	6,35	6,6	1,2	11°	○	

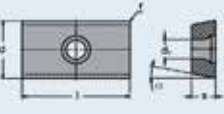


SNNN 	Bestellbezeichnung Ordering Code								Sorte Grade
	l	l ₁	d	s	d ₁	r	α	LCP37M	
	SNNN-150608	15,88	-	15,88	6,35	-	0,8	-	○
	SNNN-190612	19,05	-	19,05	6,35	-	1,2	-	○
	SNNN-250604	25,40	-	25,40	6,35	-	0,4	-	○

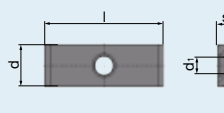


SNMF 	Bestellbezeichnung Ordering Code								Sorte Grade
	l	l ₁	d	s	d ₁	r	α	LCP37M	
	SNMF 190612	19,05	-	19,05	6,35	-	1,2	-	○
	SNMF 250720	25,40	-	25,40	7,94	-	2,0	-	○

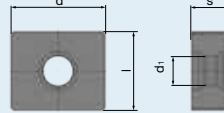


SXXK 	Bestellbezeichnung Ordering Code								Sorte Grade	Ersatzteil Spare part
	l	l ₁	d	s	d ₁	r	α	LCP37M		
	SXXK-1810	18,3	-	18,3	10	6,6	-	-	○	A02-60160 M6x16

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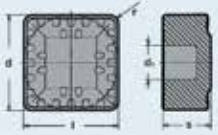


LPEX 	Bestellbezeichnung Ordering Code								Sorte Grade	Ersatzteil Spare part
		l	l ₁	d	s	d ₁	r	α	LCP37M	
	LPEX 360805	36		20	8	6,6	0,5	11°	●	A02-60160 M6x16
	LPNX 360805	36		20	8	6,6	0,5	11°	●	

LNEX 	Bestellbezeichnung Ordering Code								Sorte Grade	Ersatzteil Spare part
		l	l ₁	d	s	d ₁	r	α	LCP37M	
	LNEX 4006	40	-	14	6,36	6,0	-	-	●	A02-50140 M5x14

LNEX 	Bestellbezeichnung Ordering Code								Sorte Grade	Ersatzteil Spare part
		l	l ₁	d	s	d ₁	r	α	LCP37M	
	LNEX 1907	19,05	-	15,88	7,94	5,8	-	-	○	A02-50140 M5x14

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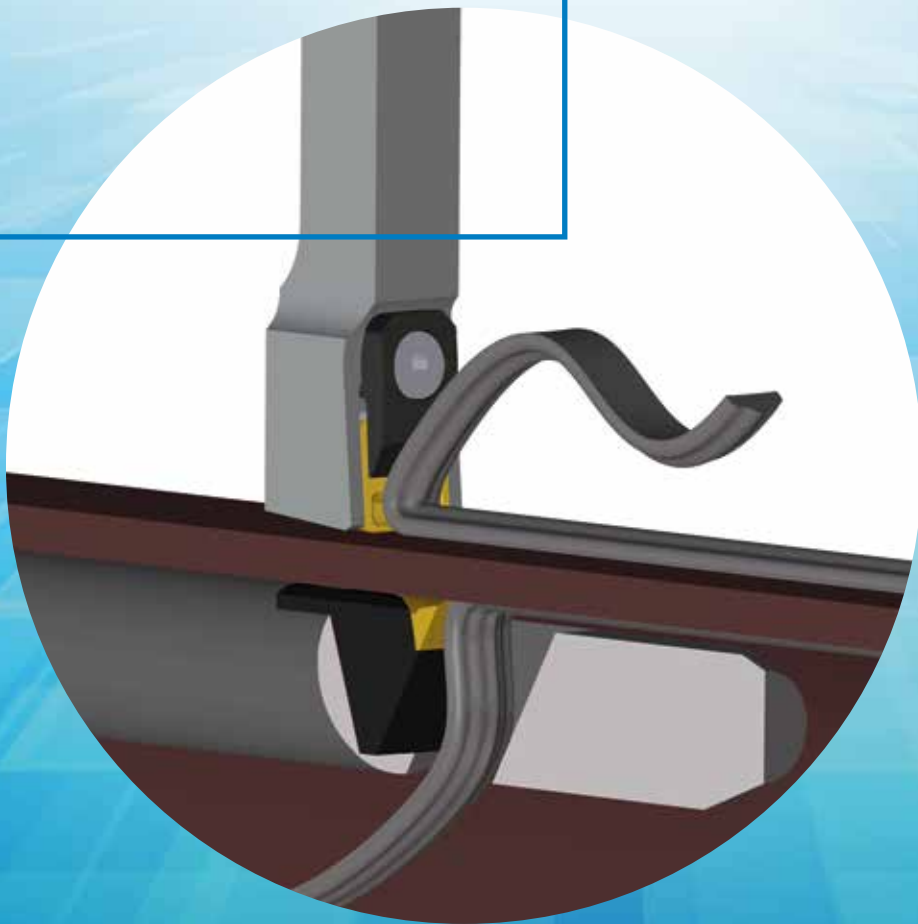
SNMX 	Bestellbezeichnung Ordering Code	l	l ₁	d	s	d ₁	r	α	Sorten Grades
									BCP45S
	SNMX-251224-BHM	25,4	-	25,4	12,8	9,12	2,4		●
	SNMX-251224-BHL	25,4	-	25,4	12,8	9,12	2,4		○

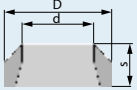

實際的顏色和圖片可能有差異
Colours of the original indexable inserts may deviate from the illustration!

- Verfügbar ab Lager Available from stock
- ⦿ kurzfristig lieferbar shortly available
- Auf Anfrage On request

焊縫處理

Weld seam scarfing



SR-AR 	Bestellbezeichnung Ordering Code	øD	ød ₁	s	Min. Tube ID		Max. Tube ID		Sorte Grade
					mm	inch	mm	inch	LCP39S
	KU0-CR 4.5	8	4,0	4	14	0,551	17	0,669	○
	KU0-CR 5.5 *	8	5,0	4	15,5	0,610	18,5	0,728	○
	KU0-CR 6.5	10	6,0	5	17	0,669	20	0,787	●
	KU0-CR 7,5 *	10	7,0	5	18,5	0,728	21,5	0,846	○
	KU1-CR 7	13	6,0	5	20	0,787	22	0,866	○
	KU1-CR 8	13	7,0	5	22	0,866	24	0,945	●
	KU1-CR 9	13	8,0	5	24	0,945	26	1,024	○
	KU2-CR 10	19	9,0	8	26	1,024	28	1,102	●
	KU2-CR 11	19	10,0	8	28	1,102	30	1,181	●
	KU2-CR 12	19	11,0	8	30	1,181	34	1,338	○
	KU3-CR 14	22	12,0	10	32	1,259	36	1,417	○
	KU3-CR 17	22	15,0	10	36	1,417	41	1,614	○
	KU4-CR 14 *	30	22,0	12	28	1,102	35	1,378	○
	KU4-CR17,5	30	15	12	36	1,417	43,5	1,722	○
	KU4-CR 20 *	30	17,0	12	41	1,614	50	1,969	○
	KU4-CR 23	30	20,0	12	48	1,890	57	2,244	○
	KU4-CR 24 *	30	22	12	48	2,156	64	2,519	○
	KU5-CR 25	35	22,0	12	70	2,765	84	3,307	●
	KU5-CR 26,5 *	35	23,5	12	76	2,992	90	3,543	○
	KU5-CR 28	35	25,0	12	85	3,346	100	3,937	○
	KU6-CR 34	45	30,0	15	100	3,937	130	5,118	●
	KU7-CR 39	50	35,0	15	130	5,118	150	5,906	○
	KU8-CR 46	55	40,0	18	140	5,512	180	7,086	●

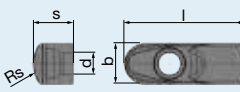


* 中間尺寸
* Intermediate sizes

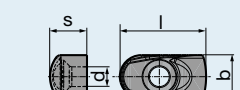


實際的顏色和圖片可能有差異
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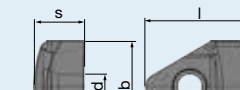


- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request




内部焊缝處理，刮刀配件
Weld seam scarfing internal, scarfing bits



ISD 8-..	 Bestellbezeichnung Ordering Code						Sorte Grade		Ersatzteil Spare part
		Rs	b	l	d	s	BCP15S		
	ISD 8 - R8	8	8	24	4,3	8	●		A02-40108 M4x10,8
	ISD 8 - R6,5	6,5	8	24	4,3	8	●		

ISD 20-..	 Bestellbezeichnung Ordering Code						Sorte Grade		Ersatzteil Spare part
		Rs	b	l	d	s	BCP15S		
	ISD 12 - R10	10	12	24	5,5	10	●		M5 x 8

ISD 20-..	 Bestellbezeichnung Ordering Code						Sorte Grade		Ersatzteil Spare part
		Rs	b	l	d	s	BCP35S		
	ISD 20 - R25	25	20	23,7	5,5	10	●		D-22-032 M5x16

D-21-1138-..	 Bestellbezeichnung Ordering Code						Sorte Grade		Ersatzteil Spare part
		Rs	b	l	d	s	BCP35S	LCP37S	
	ISD 25 - R20	20	25	29,5	6,6	14	●		A02-60160 M6x16
	ISD 25 - R25	25	25	29,5	6,6	14	●		
	ISD 25 - R30	30	25	29,5	6,6	14	●		
	ISD 25 - R35	35	25	29,5	6,6	14	●		
	ISD 25 - R50	50	25	29,5	6,6	14	●		
	ISD 25 - R70	70	25	29,5	6,6	14	●		
	ISD25 - R80 (D-21-1138-R80)							●	
	ISD25 - R90 (D-21-1138-R90)							●	
	ISD25 - R100 (D-21-1138-R100)							●	

刀桿請看第20頁 Tool holder see page 20

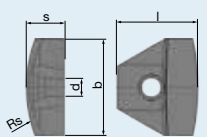
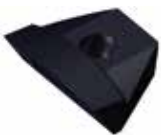
實際的顏色和圖片可能有差異
Colours of the original indexable inserts may deviate from the illustration!

- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

内部焊缝處理，刮刀配件

Weld seam scarfing internal, scarfing bits

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ISD 35-.. 	Bestellbezeichnung Ordering Code	Rs	b	l	d	s	Sorte Grade	Ersatzteil Spare part
								BCP35S
	ISD 35 - R35	35	35	29,5	6,6	14	●	A02-60160
	ISD 35 - R50	50	35	29,5	6,6	14	●	M6x16
	ISD 35 - R70	70	35	29,5	6,6	14	●	

刀桿請看第20頁 Tool holder see page 20

實際的顏色和圖片可能有差異

Colours of the original indexable inserts may deviate from the illustration!

- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

内部焊缝處理，刮刀
Weld seam scarfing internal, scarfing insert



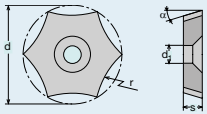


D-21-589-.. 									Sorte Grade	Ersatzteil Spare part
	Bestellbezeichnung Ordering Code	l	l ₁	d	s	d ₁	Rs	α	LCP37M	
	D-21-589-R125	32	24,812	19,05	7	6,7	125	15°	●	A02-60160 M6x16
	D-21-589-R200	32	24,812	19,05	7	6,7	200	15°	●	
	D-21-589-R250	32	24,18	19,05	7	6,7	250	15°	●	

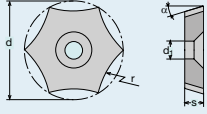
SDNW 25-... 							Sorte Grade	Ersatzteil Spare part		
	Bestellbezeichnung Ordering Code	l	d	s	d ₁	Rs	α	LC240Q		
	SDNW 25 - R100	25	25	7	6,7	100	15°	●	A02-60160 M6x16	

刀桿請看第20頁 Tool holder see page 20

實際的顏色和圖片可能有差異
Colours of the original indexable inserts may deviate from the illustration!

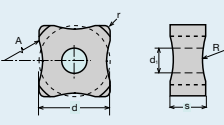

- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

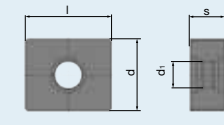

ROMX 	Bestellbezeichnung Ordering Code	d	s	d ₁	r	α	Sorte Grade		Ersatzteile Spare part 
							LC238H	LCP39S	
	ROMX-2404-R10 (DET3)	24,4	4,75	5,35	10	18°	●		Ersatzteile siehe Seite 25 Spare parts see page 25
	ROMX-2404-R13 (DET5)	24,4	4,75	5,35	13	18°	●		
	ROMX-2404-R14 -	24,4	4,75	5,35	14	18°	○		
	ROMX-2404-R15 -	24,4	4,75	5,35	15	18°	○		
	ROMX-2404-R16 (DET7)	24,4	4,75	5,35	16	18°	●		
	ROMX-2404-R17,5 -	24,4	4,75	5,35	17	18°	○		
	ROMX-2404-R21 (DET8)	24,4	4,75	5,35	21	18°	●		
	ROMX-2404-R27 (DET9)	24,4	4,75	5,35	27	18°	●		
	ROMX-2404-R38 (DET10)	24,4	4,75	5,35	38	18°	●		
	ROMX-2404-R47 (DET11)	24,4	4,75	5,35	47	18°	●		
	ROMX-2404-R60 (DET12)	24,4	4,75	5,35	60	18°	●		
	ROMX-2404-R73 (DET13)	24,4	4,75	5,35	73	18°	●		
	ROMX-2404-R98 (DET15)	24,4	4,75	5,35	98	18°	●		
	ROMX-2404-R0	24,4	4,75	5,35	8	18°		○	
	ROMX-2404-R8	24,4	4,75	5,35	8	18°		○	
	ROMX-2404-R12	24,4	4,75	5,35	12	18°		○	
	ROMX-2404-R13,5	24,4	4,75	5,35	13,5	18°		○	
	ROMX-2404-R20	24,4	4,75	5,35	20	18°		○	
	ROMX-2404-R24	24,4	4,75	5,35	24	18°		○	
	ROMX-2404-R30	24,4	4,75	5,35	30	18°		○	
	ROMX-2404-R35	24,4	4,75	5,35	35	18°		○	
	ROMX-2404-R40	24,4	4,75	5,35	40	18°		○	
	ROMX-2404-R45	24,4	4,75	5,35	45	18°		○	
	ROMX-2404-R50	24,4	4,75	5,35	50	18°		○	
	ROMX-2404-R55	24,4	4,75	5,35	55	18°		○	
ROMX-2404-R70	24,4	4,75	5,35	70	18°		○		
ROMX-2404-R80	24,4	4,75	5,35	80	18°		○		
ROMX-2404-R85	24,4	4,75	5,35	85	18°		○		

ROMX 	Radius r		Rohrdurchmesser Tube diameter	
	mm	inch	mm	inch
	ROMX-2404-R10	10	0,393	unter 15,88
ROMX-2404-R13	13	0,512	15,88 - 22,23	5/8 - 7/8
ROMX-2404-R14	14	0,551	20 - 25	0,79 - 0,98
ROMX-2404-R15	15	0,590	23 - 28	0,91 - 1,1
ROMX-2404-R16	16	0,630	22,23 - 31,75	7/8 - 1 1/4
ROMX-2404-R17,5	17	0,669	22 - 35	0,87 - 1,38
ROMX-2404-R21	21	0,826	31,75 - 41,28	1 1/4 - 1 5/8
ROMX-2404-R27	27	1,063	41,28 - 50,80	1 5/8 - 2
ROMX-2404-R38	38	1,496	50,80 - 73,00	2 - 2 7/8
ROMX-2404-R47	47	1,850	73,00 - 92,08	2 7/8 - 3 5/8
ROMX-2404-R60	60	2,362	92,08 - 117,48	3 5/8 - 4 5/8
ROMX-2404-R73	73	2,874	117,48 - 142,88	4 5/8 - 5 5/8
ROMX-2404-R98	98	3,858	168,28 - 193,68	6 5/8 - 7 5/8

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- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

SNMX 	Bestellbezeichnung Ordering Code	l	d	s	r	d ₁	A	R	Min. Tube OD		Max. Tube OD		Sorte Grade	
									mm	inch	mm	inch	LC238H	LCP39S
	SNMX-1507-22-R07	15,87	15,87	7,94	0,8	6,35	7	22	9,80	0,386	12,60	0,496	○	○
	SNMX-1507-22-R09	15,87	15,87	7,94	0,8	6,35	9	22	12,60	0,496	15,88	0,625	○	○
	SNMX-1507-22-R10	15,87	15,87	7,94	0,8	6,35	10	22	13,30	0,524	17,20	0,677	○	○
	SNMX-1507-22-R13	15,87	15,87	7,94	0,8	6,35	13	22	15,88	0,625	22,23	0,875	●	●
	SNMX-1507-22-R15	15,87	15,87	7,94	0,8	6,35	15	22	18,90	0,744	27,60	1,087	●	●
	SNMX-1507-22-R18	15,87	15,87	7,94	0,8	6,35	18	22	25,20	0,992	33,12	1,304	○	○
	SNMX-1507-22-R20	15,87	15,87	7,94	0,8	6,35	20	22	28,00	1,102	36,80	1,449	●	●
	SNMX-1507-22-R22	15,87	15,87	7,94	0,8	6,35	22	22	30,90	1,213	39,60	1,560	○	○
	SNMX-1507-22-R25	15,87	15,87	7,94	0,8	6,35	25	22	35,00	1,378	41,25	1,625	●	●
	SNMX-1507-22-R27	15,87	15,87	7,94	0,8	6,35	27	22	41,28	1,625	50,80	2,000	○	○
	SNMX-1507-22-R30	15,87	15,87	7,94	0,8	6,35	30	22	42,00	1,654	55,20	2,173	●	●
	SNMX-1507-22-R35	15,87	15,87	7,94	0,8	6,35	35	22	49,00	1,929	64,40	2,535	●	●
	SNMX-1507-22-R40	15,87	15,87	7,94	0,8	6,35	40	22	56,00	2,205	73,60	2,898	○	○
	SNMX-1507-22-R42	15,87	15,87	7,94	0,8	6,35	42	22	59,00	2,320	77,50	3,05	○	○
	SNMX-1507-22-R45	15,87	15,87	7,94	0,8	6,35	45	22	63,00	2,480	82,80	3,260	●	●
	SNMX-1507-22-R50	15,87	15,87	7,94	0,8	6,35	50	22	75,00	2,953	92,08	3,625	○	○
	SNMX-1507-22-R55	15,87	15,87	7,94	0,8	6,35	55	22	83,50	3,287	104,78	4,191	●	●
	SNMX-1507-22-R60	15,87	15,87	7,94	0,8	6,35	60	22	92,08	3,625	117,48	4,625	○	○
	SNMX-1507-22-R65	15,87	15,87	7,94	0,8	6,35	65	22	100,66	3,963	125,6	4,945	●	●
	SNMX-1507-22-R70	15,87	15,87	7,94	0,8	6,35	70	22	109,24	4,300	136,2	5,362	○	○
	SNMX-1507-22-R75	15,87	15,87	7,94	0,8	6,35	75	22	117,82	4,638	145,7	5,736	●	●
	SNMX-1907-22-R00	19,05	19,05	7,94	1,2	6,35	0	35	no radius - used for larger tube sizes				●	●
	SNMX-1907-22-R10	19,05	19,05	7,94	1,2	6,35	10	35	14,00	0,551	18,90	0,744	○	○
	SNMX-1907-22-R12	19,05	19,05	7,94	1,2	6,35	12	35	15,88	0,625	22,33	0,875	○	○
	SNMX-1907-22-R15	19,05	19,05	7,94	1,2	6,35	15	35	18,90	0,744	27,60	1,087	●	●
	SNMX-1907-22-R20	19,05	19,05	7,94	1,2	6,35	20	35	28,00	1,102	36,80	1,449	●	●
	SNMX-1907-22-R25	19,05	19,05	7,94	1,2	6,35	25	35	35,00	1,378	41,28	1,625	●	●
	SNMX-1907-22-R35	19,05	19,05	7,94	1,2	6,35	35	35	49,00	1,929	64,40	2,535	●	●
	SNMX-1907-22-R45	19,05	19,05	7,94	1,2	6,35	45	35	63,00	2,480	82,80	3,260	○	○
	SNMX-1907-22-R55	19,05	19,05	7,94	1,2	6,35	55	35	82,50	3,248	97,50	3,839	●	●
	SNMX-1907-22-R60	19,05	19,05	7,94	1,2	6,35	60	35	92,08	3,625	117,48	4,625	○	○
	SNMX-2512-22-R00	25,40	25,40	12,70	0,8	9,12	0	48	no radius - used for larger tube sizes				●	●
	SNMX-2512-22-R25	25,40	25,40	12,70	0,8	9,12	25	48	35,00	1,378	41,25	1,625	○	○
	SNMX-2512-22-R35	25,40	25,40	12,70	0,8	9,12	35	48	49,00	1,929	64,4	2,535	○	○
	SNMX-2512-22-R50	25,40	25,40	12,70	0,8	9,12	50	48	75,00	2,953	92,08	3,625	●	●
SNMX-2512-22-R65	25,40	25,40	12,70	0,8	9,12	65	48	97,50	3,839	120,00	4,724	●	●	
SNMX-2512-22-R80	25,40	25,40	12,70	0,8	9,12	80	48	120,0	4,724	147,20	3,795	○	○	
SNMX-2512-22-R90	25,40	25,40	12,70	0,8	9,12	90	48	135,0	5,315	171,00	6,732	○	○	
SNMX-2512-22-R100	25,40	25,40	12,70	0,8	9,12	100	48	150,0	5,905	190,00	7,480	●	●	
SNMX-2512-22-R120	25,40	25,40	12,70	0,8	9,12	120	48	180,0	7,078	228,00	8,976	○	○	
SNMX-2512-22-R150	25,40	25,40	12,70	0,8	9,12	150	48	225,0	8,858	285,00	11,220	●	●	
SNMX-2512-22-R200	25,40	25,40	12,70	0,8	9,12	200	48	300,0	11,811	380,00	14,961	●	●	
SNMX-2512-22-R250	25,40	25,40	12,70	0,8	9,12	250	48	375,0	14,764	475,00	18,700	●	●	

LOXT 	Bestellbezeichnung Ordering Code	l	d	s	r	d ₁	A	Min. Tube OD		Max. Tube OD		Sorte Grade	
								mm	inch	mm	inch	LCP39S	
	LOXT 3912	39	31	12	-	8,5	0	-	-	-	-	●	

刀架請看第25頁 Tool holder see off page 25

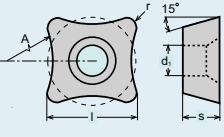

實際的顏色和圖片可能有差異

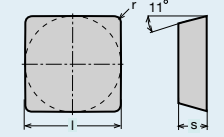

Colours of the original indexable inserts may deviate from the illustration!

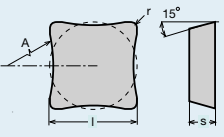


- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

外部焊縫處理，刮刀
Weld seam scarfing external, scarfing inserts



SDUW 	Bestellbezeichnung Ordering Code	l	d	s	r	d ₁	A	Min. Tube OD		Max. Tube OD		Sorte Grade
								mm	inch	mm	inch	LCP39S
	SDUW-250920-R00	25,4	25,4	9,00	2,0	6	0	-	-	-	-	○
	SDUW-250920-R20	25,4	25,4	9,00	2,0	6	20	28,0	1,102	36,80	1,449	○
	SDUW-250920-R25	25,4	25,4	9,00	2,0	6	25	35,0	1,378	41,28	1,625	○
	SDUW-250920-R35	25,4	25,4	9,00	2,0	6	35	49,0	1,929	64,40	2,535	○
	SDUW-250920-R40	25,4	25,4	9,00	2,0	6	40	56,0	2,205	73,60	2,898	○
	SDUW-250920-R45	25,4	25,4	9,00	2,0	6	45	63,0	2,480	82,80	3,260	○
	SDUW-250920-R50	25,4	25,4	9,00	2,0	6	50	75,0	2,953	92,08	3,625	○
	SDUW-250920-R55	25,4	25,4	9,00	2,0	6	55	82,5	3,248	97,50	3,839	○
	SDUW-250920-R60	25,4	25,4	9,00	2,0	6	60	92,08	3,625	117,48	4,625	○
	SDUW-250920-R65	25,4	25,4	9,00	2,0	6	65	97,5	3,839	120,0	4,724	○
	SDUW-250920-R70	25,4	25,4	9,00	2,0	6	70	109,0	4,134	128,8	5,071	○
	SDUW-250920-R75	25,4	25,4	9,00	2,0	6	75	112,5	4,429	142,5	5,610	○
	SDUW-250920-R85	25,4	25,4	9,00	2,0	6	85	127,5	5,020	161,5	6,358	○
	SDUW-250920-R100	25,4	25,4	9,00	2,0	6	100	150,0	5,905	190,0	7,480	○
	SDUW-250920-R120	25,4	25,4	9,00	2,0	6	120	180,0	7,087	228,0	8,976	○
	SDUW-250920-R160	25,4	25,4	9,00	2,0	6	160	240,0	9,450	304,0	11,968	○
SDUW-250920-R200	25,4	25,4	9,00	2,0	6	200	300,0	11,811	380,0	14,961	○	
SDUW-250920-R250	25,4	25,4	9,00	2,0	6	250	375,0	14,764	475,0	18,700	○	

SPUX 	Bestellbezeichnung Ordering Code	l	d	s	r	d ₁	A	Min. Tube OD		Max. Tube OD		Sorte Grade
								mm	inch	mm	inch	LW240
	SPUX-250620	25,4	25,4	6,35	1,6	-	-	-	-	-	-	●

SDMX 	Bestellbezeichnung Ordering Code	l	d	s	r	d ₁	A	Min. Tube OD		Max. Tube OD		Sorte Grade
								mm	inch	mm	inch	LCP39S
	SDMX-250616-R105	25,4	25,4	6,35	1,6	-	105	157,5	6,200	199,5	7,854	●
	SDMX-250616-R120	25,4	25,4	6,35	1,6	-	120	180,0	7,087	228,0	8,976	●
	SDMX-250616-R145	25,4	25,4	6,35	1,6	-	145	217,5	8,563	275,5	10,846	●
	SDMX-250616-R180	25,4	25,4	6,35	1,6	-	180	270,0	10,630	342,0	13,465	●
	SDMX-250616-R300	25,4	25,4	6,35	1,6	-	300	450,0	17,717	570,0	22,441	●
SDMX-250616-R550	25,4	25,4	6,35	1,6	-	550	825,0	32,480	1045,0	41,142	●	
	SDUN-190412-R0	19,05	19,05	4,76	1,2	-	0	für große Durchmesser/Used on large diameter				○
	SDUN-190412-R15	19,05	19,05	4,76	1,2	-	15	18	0,708	27	1,063	○
	SDUN-190412-R19	19,05	19,05	4,76	1,2	-	19	27	1,063	36	1,417	○
	SDUN-190412-R20	19,05	19,05	4,76	1,2	-	20	30	1,181	38	1,496	○
	SDUN-190412-R25	19,05	19,05	4,76	1,2	-	25	35	1,378	47	1,850	○
	SDUN-190412-R32	19,05	19,05	4,76	1,2	-	32	45	1,771	58	2,283	○
	SDUN-190412-R39	19,05	19,05	4,76	1,2	-	39	58	2,283	70	2,756	○
	SDUN-190412-R45	19,05	19,05	4,76	1,2	-	45	70	2,756	80	3,150	○
	SDUN-190412-R48	19,05	19,05	4,76	1,2	-	48	75	2,953	93	3,625	○
	SDUN-190412-R64	19,05	19,05	4,76	1,2	-	64	97	3,839	120	4,724	○
SDUN-190412-R80	19,05	19,05	4,76	1,2	-	80	112	4,429	142	5,610	○	

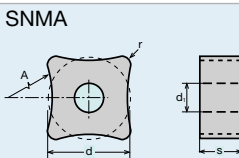

刀架請看第26頁 Tool holder see off page 26

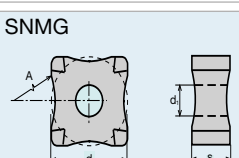

實際的顏色和圖片可能有差異
Colours of the original indexable inserts may deviate from the illustration!

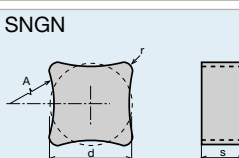

- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

外部焊縫處理，可轉位刀片

Weld seam scarfing external, indexable inserts

SNMA 	Bestellbezeichnung Ordering Code	l	d	s	r	d ₁	A	Min. Tube OD		Max. Tube OD		Sorte Grade
								mm	inch	mm	inch	LCP17S
									SNMA-250924-R25	25,40	25,40	
	SNMA-250924-R30	25,40	25,40	9,52	2,4	9,12	30	42,00	1,654	55,20	2,173	●
	SNMA-250924-R35	25,40	25,40	9,52	2,4	9,12	35	49,00	1,929	64,40	2,535	●
	SNMA-250924-R40	25,40	25,40	9,52	2,4	9,12	40	56,00	2,205	73,60	2,898	●
	SNMA-250924-R50	25,40	25,40	9,52	2,4	9,12	50	75,00	2,953	92,08	3,625	●
	SNMA-250924-R60	25,40	25,40	9,52	2,4	9,12	60	92,08	3,625	117,48	4,625	●
	SNMA-250924-R70	25,40	25,40	9,52	2,4	9,12	70	105,0	4,134	128,80	5,071	●
	SNMA-250924-R80	25,40	25,40	9,52	2,4	9,12	80	120,0	4,724	147,20	5,795	●
	SNMA-250924-R100	25,40	25,40	9,52	2,4	9,12	100	150,0	5,905	190,00	7,480	●
	SNMA-250924-R150	25,40	25,40	9,52	2,4	9,12	150	225,0	8,858	285,00	11,220	●
	SNMA-250924-R200	25,40	25,40	9,52	2,4	9,12	200	300,0	11,811	380,00	14,961	●

SNMG 	Bestellbezeichnung Ordering Code	l	d	s	r	d ₁	A	Min. Tube OD		Max. Tube OD		Sorte Grade
								mm	inch	mm	inch	LCP39S
									SNMG-1507-R13	15,87	15,87	
	SNMG-1507-R18	15,87	15,87	7,94	-	5,50	18	25,20	0,992	33,12	1,304	○
	SNMG-1507-R22	15,87	15,87	7,94	-	5,50	22	30,80	1,213	39,00	1,560	○
	SNMG-1507-R27	15,87	15,87	7,94	-	5,50	27	41,28	1,625	50,80	2,000	●
	SNMG-1507-R35	15,87	15,87	7,94	-	5,50	35	49,00	1,929	64,40	2,535	○
	SNMG-1507-R40	15,87	15,87	7,94	-	5,50	40	56,00	2,205	73,60	2,898	○
	SNMG-1507-R45	15,87	15,87	7,94	-	5,50	45	63,00	2,480	82,80	3,260	○
	SNMG-1507-R50	15,87	15,87	7,94	-	5,50	50	75,0	2,953	92,08	3,625	●
	SNMG-1507-R60	15,87	15,87	7,94	-	5,50	60	92,08	3,625	117,48	4,625	○
	SNMG-1507-R65	15,87	15,87	7,94	-	5,50	65	97,5	3,839	120,0	4,724	○
	SNMG-1907-R12	19,05	19,05	7,94	-	8,00	12	15,88	0,625	22,23	0,875	○
	SNMG-1907-R15	19,05	19,05	7,94	-	8,00	15	18,90	0,744	27,60	1,078	○
	SNMG-1907-R20	19,05	19,05	7,94	-	8,00	20	28,00	1,102	36,80	1,449	○
	SNMG-1907-R25	19,05	19,05	7,94	-	8,00	25	35,00	1,378	41,28	1,625	●
	SNMG-1907-R35	19,05	19,05	7,94	-	8,00	35	49,00	1,929	64,40	2,535	○
	SNMG-1907-R40	19,05	19,05	7,94	-	8,00	40	56,0	2,205	73,60	2,898	○
	SNMG-1907-R42	19,05	19,05	7,94	-	8,00	42	59,0	2,320	77,5	3,05	○
	SNMG-1907-R55	19,05	19,05	7,94	-	8,00	55	82,50	3,248	97,50	3,839	○
	SNMG-1907-R65	19,05	19,05	7,94	-	8,00	65	100,66	3,963	125,60	4,945	○
	SNMG-1907-R75	19,05	19,05	7,94	-	8,00	75	112,5	4,425	142,5	5,610	○
	SNMG-1907-R90	19,05	19,05	7,94	-	8,00	90	135,0	5,315	171,0	6,732	○
	SNMG-2511-R105	25,40	25,40	11,2	-	8,00	105	157,5	6,20	199,5	7,854	○
	SNMG-2512-R35	25,40	25,40	12,7	-	8,00	35	49,0	1,929	64,4	2,535	●
	SNMG-2512-R42	25,40	25,40	12,7	-	8,00	42	59,0	2,320	77,5	3,05	○
	SNMG-2512-R55	25,40	25,40	12,7	-	8,00	55	82,5	3,248	97,5	3,839	○
	SNMG-2512-R85	25,40	25,40	12,7	-	8,00	85	127,5	5,020	161,5	6,358	○

SNGN 	Bestellbezeichnung Ordering Code	l	d	s	r	d ₁	A	Min. Tube OD		Max. Tube OD		Sorte Grade
								mm	inch	mm	inch	LCP39S
									SNGN-150708-R40	15,87	15,87	
	SNGN-150708-R45	15,87	15,87	7,94	0,8	-	45	70	2,756	80	3,150	○
	SNGN-150708-R50	15,87	15,87	7,94	0,8	-	50	76	1,181	85	3,346	○
	SNGN-150708-R60	15,87	15,87	7,94	0,8	-	60	85	1,378	100	3,937	○
	SNGN-150708-R70	15,87	15,87	7,94	0,8	-	70	95	1,771	115	4,527	○
	SNGN-150708-R100	15,87	15,87	7,94	0,8	-	100	115	4,527	160	6,300	○

刀架請看第26頁 Tool holder see off page 26

實際的顏色和圖片可能有差異

Colours of the original indexable inserts may deviate from the illustration!

- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

PXFNR/L 90° Rechtsausführung R wie gezeichnet, Linksausführung L spiegelbildlich, Right hand version R as drawn, left hand version L mirrorlike.								Lager Stock		Passende Wendeplatte Suitable indexable inserts	Seite Page
	Bestellbezeichnung Ordering Code	h	h1	b	l	f	R	L			
	PXFNR/L 2525 M15	25	25	25	150	32	●	○	SNMX-1507-22	22	
	PXFNR/L 2525 M19	25	25	25	150	32	○	○	SNMX-1907-22	22	
	PXFNR/L 2525 S25	25	25	25	250	35	○	○	SNMX-2512-22	22	
	PSFNR/L 2525 M15	25	25	25	150	32	○	○	SNMG-1507	24	
	PSFNR/L 2525 M19	25	25	25	150	32	○	○	SNMG-1907	24	
	PSFNR/L 2525 S25	25	25	25	250	35	○	○	SNMG-2512	24	

Ersatzteile Spare parts			Bestellbezeichnung Ordering Code					
Schneidkantenlänge Cutting edge length	Schaftgröße Shank size							
			Unterlage Shim	Hebel Lever	Spannschraube Fixation screw	Spannhülse Shim pin	Montagedorn Assembly punch	Schlüssel Key
15	2525	PXFNR/L	ANV-2215	D02-15145	A03-08235	E01-07205	V10-20000	V01-A0030
15	2525	PSFNR/L	AS-1507	D02-15145	A03-08235	E01-07205	V10-20000	V01-A0030
19	2525	PXFNR/L	ANV-2219	D02-19210	A03-10270	E01-11011	V10-30000	V01-A0040
19	2525	PSFNR/L	AS-1907	D02-19210	A03-10270	E01-11011	V10-30000	V01-A0040
25	2525	PXFNR/L	ANV-2225	D02-23250	A03-12360	E01-15212	V10-50000	V01-A0050
25	2525	PSFNR/L	AS-2512	D02-23250	A03-12360	E01-15212	V10-50000	V01-A0050

Bestellbeispiel: 1 Stück PXFNR 2525 M15
Order Example: 1 off PXFNR 2525 M15

出貨不含扳手
Delivery without key

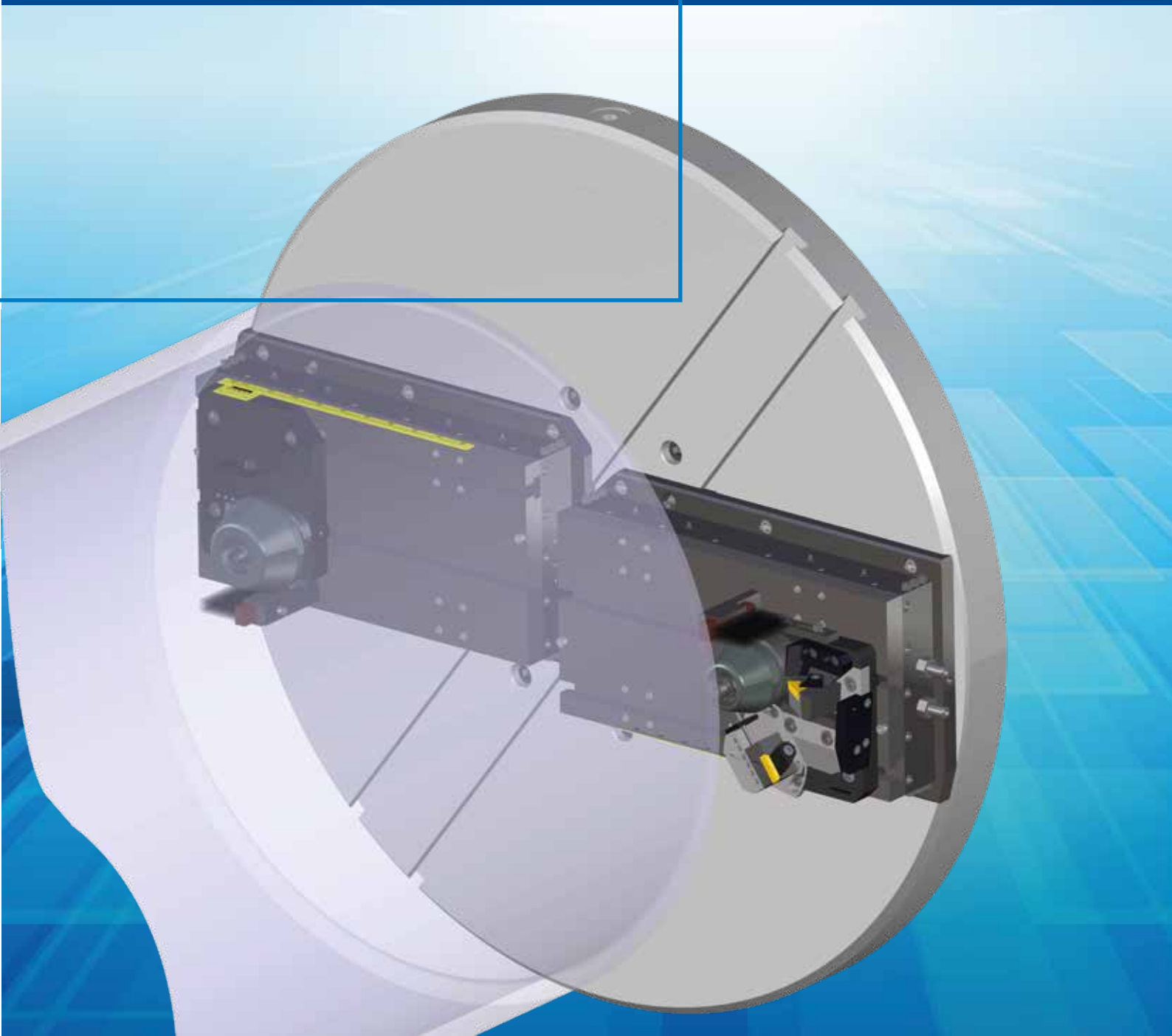
						Lager Stock		Passende Wendeplatte Suitable indexable inserts	Seite Page
	Bestellbezeichnung Ordering Code	h	h1	b	l				
	D-62-038	25,3	29,5	25,3	203	●		SPUX-250620	23

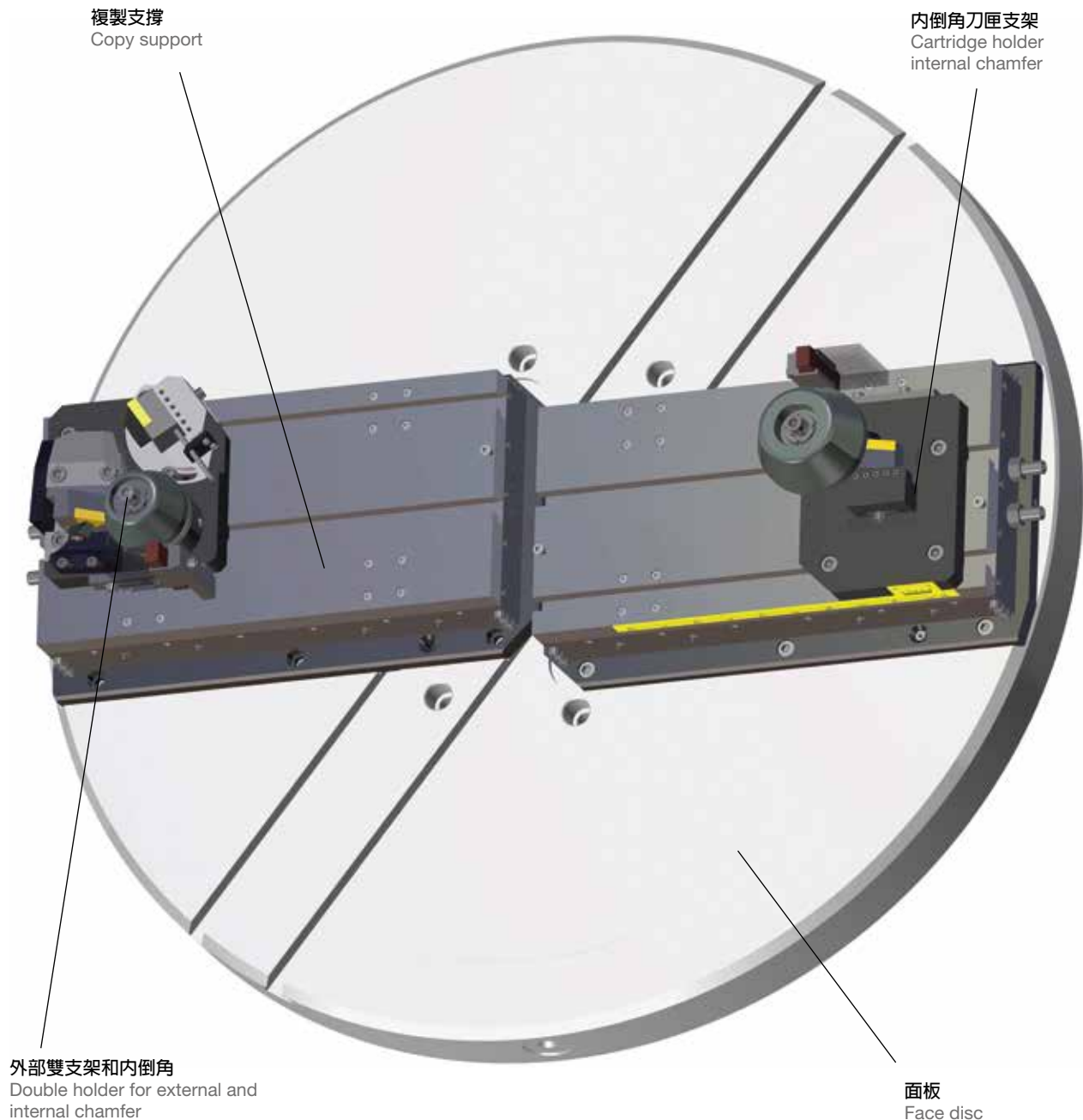
Ersatzteile Spare parts			Bestellbezeichnung Ordering Code				
Schneidkantenlänge Cutting edge length	Schaftgröße Shank size						
			Unterlage Shim	Spannfinger Clamp finger	Schraube Unterlagplatte Fixation screw	Schraube für Spannfinger Screw for clamping finger	Schlüssel Key
25	25,3x25,3		D-20-136	D-18-054-01	M5x12 DIN7991	M8x25 DIN7991	V01-A0030

實際的顏色和圖片可能有差異
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- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

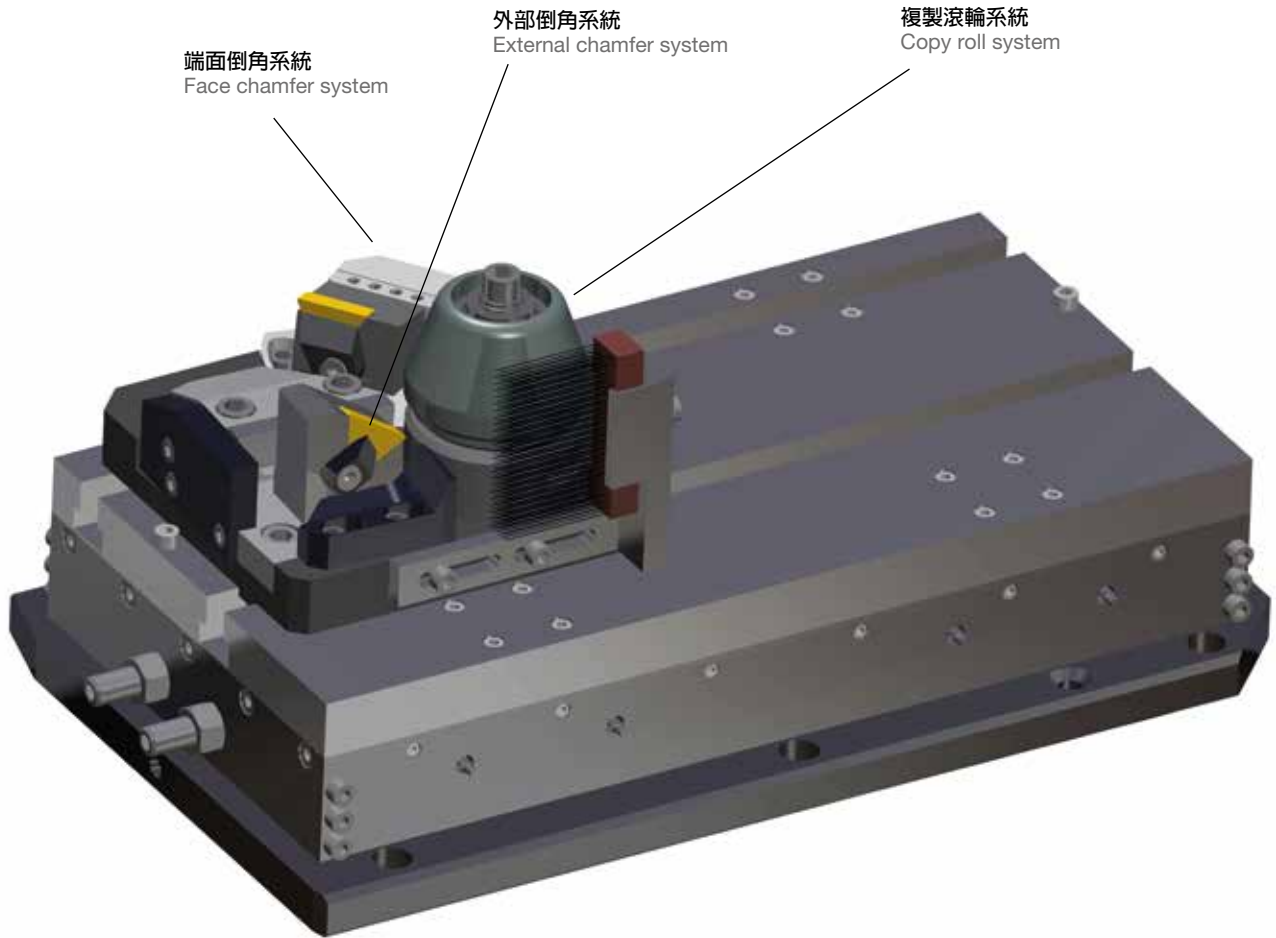
管端坡口加工
Pipe end bevelling





Boehlerit 提供加工管端的完整刀具系統。這些系統由面板、彈簧加載刀具滑塊、刀匣支架、複製輥和各種用於調節的主軸組成。我們為此應用提供廣泛的標準刀匣和可轉位刀片。

Boehlerit offers complete tooling systems for pipe end bevelling machines. These systems are consisting of face disc, spring loaded tool slides, cartridge holders, copy roll and some spindles for adjustment. We are holding on stock a wide program of standard cartridges and standard carbide tips for this application.

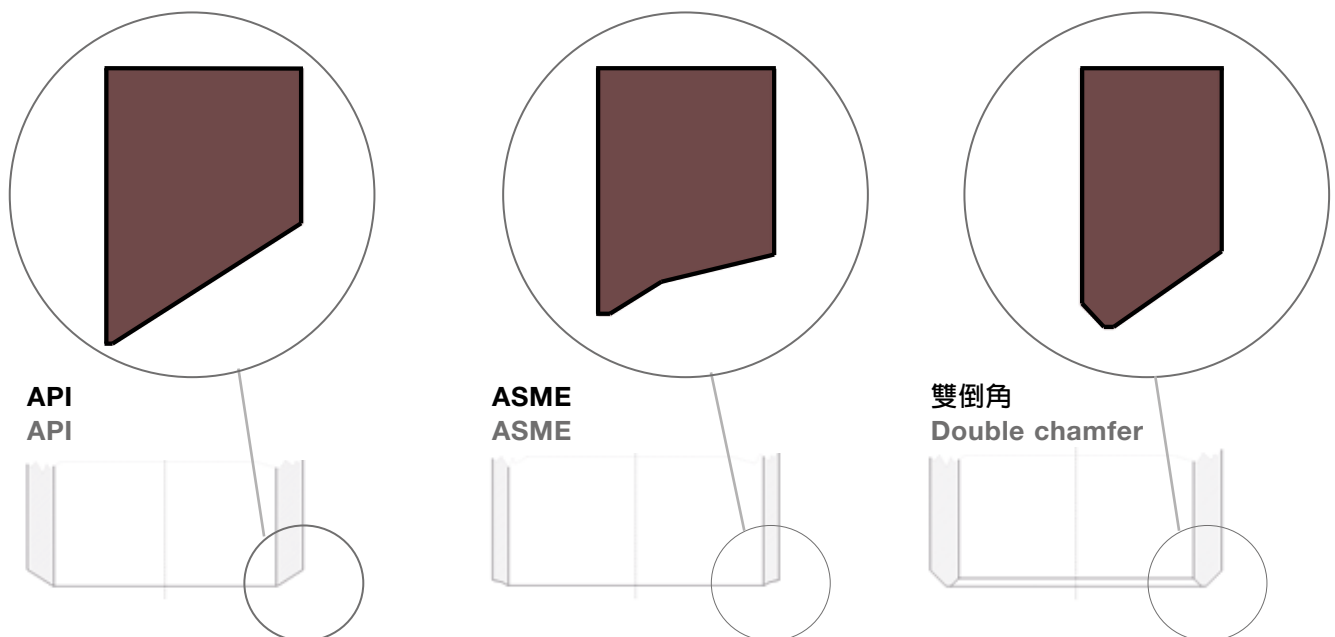


系統的靈活性保證了根據不同的斜角設計標準如B. API 或 ASME

Flexibility of the system guarantees various chamfer designs according to standards like API or ASME

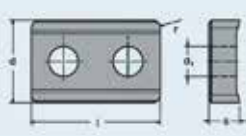



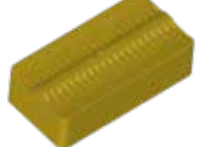
可根據客戶的規格提供不同的型材

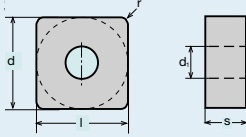



Different profiles according to customers specifications possible



用於管端加工的可轉位刀片

Indexable inserts for pipe end bevelling

LNUX 	Bestellbezeichnung Ordering Code	l	d	s	d ₁	r	α ₁	Sorten Grades		Ersatzteile Spare Parts
								LCP25T		
	LNUX-400924-BBO	40	25,4	9,52	9,2	2,4		●	備用零件 請看36頁 Spare parts off page 36	
	LNUX-501224-BBO	50	25,4	12,7	9,2	2,4		●		
	LNUX-400924-BBM	40	25,4	9,52	9,2	2,4		●		
	LNUX-501224-BBM	50	25,4	12,7	9,2	2,4		●		
	LNUX-601224-BBM	60	25,4	12,7	9,2	2,4		●		
	LNUX-701224-BBM	70	25,4	12,7	9,2	2,4		●		
	LNUX-400924-BBL	40	25,4	9,52	9,2	2,4		●		
	LNUX-501224-BBL	50	25,4	12,7	9,2	2,4		●		
	LNUX-601224-BBL	60	25,4	12,7	9,2	2,4		○		
	LNUX-701224-BBL	70	25,4	12,7	9,2	2,4		○		
	LNUX-501224-TE	50	25,4	12,7	9,2	2,4		●		
	LNUX-701224-TE	70	25,4	12,7	9,2			○		

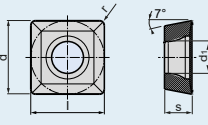

	Bestellbezeichnung Ordering Code	l	d	s	d ₁	r	Sorten Grades				Ersatzteile Spare parts
							LC228E	LC240F	LCP25T	BCP25T.1	
SNMG...-MR 	SNMG-250924-MR	25,4	25,4	9,52	9,2	2,4				○	備用零件 請看36頁 Spare parts off page 36
SNMM...-BBM 	SNMM-250724-BBM	25,4	25,4	7,94	9,2	2,4			●		
	SNMM-250724	25,4	25,4	7,94	9,2	2,4		●			
SNMT...-TE 	SNMT-311216-TE	31,75	31,75	12,8	8,6	1,6	●				

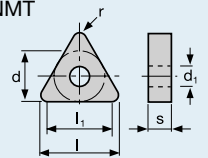








實際的顏色和圖片可能有差異
Colours of the original indexable inserts may deviate from the illustration!



- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

用於管端加工的可轉位刀片
Indexable inserts for pipe end bevelling



	Bestellbezeichnung Ordering Code						Sorten Grades
		l	d	s	d ₁	r	BCP35T.1
SPMT...-SN 	SPMT-120408-MR	12,7	12,7	4,76	5,5	0,8	○

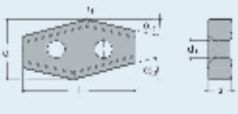







	Bestellbezeichnung Ordering Code							Sorten Grades	Ersatzteile Spare Parts
		l	l ₁	d	s	d ₁	r	LC228E	
	TNMT-440920-TE	41	37,07	25,4	9,52	5,5	2,4	●	備用零件 請看36頁 Spare parts off page 36
	TNMT-440920-TE	41	37,07	25,4	9,52	5,5	2,4	●	
	TNMT-440920-TE	41	37,07	25,4	9,52	5,5	2,4	●	
	TNMT-440920-TE	41	37,07	25,4	9,52	5,5	2,4	●	
	TNMG-330704-BR	26,18	-	19,05	7,93	7,94	0,4	○	
	TNMG-330724-BR	26,18	-	19,05	7,93	7,94	2,4	○	
	TNMG-330904-BR	26,18	-	19,05	9,52	7,94	0,4	○	
	TNMG-330924-BR	26,18	-	19,05	9,52	7,94	2,4	○	

	Bestellbezeichnung Ordering Code							Sorten Grades
		l	l ₁	d	s	r	α	LCP37M
	TPUN-330620-T	33	26,23	19,5	6,35	2,0	11°	○
	TPUN-450720-T	45	38,08	26,0	7,94	2,0	11°	○

實際的顏色和圖片可能有差異
Colours of the original indexable inserts may deviate from the illustration!

- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

用於管端加工的可轉位刀片
Indexable inserts for pipe end bevelling

YNUX 	Bestellbezeichnung Ordering Code								Sorten Grades	Ersatzteile Spare Parts
		l	d	s	d ₁	r	α ₁	α ₂	LCP25T	
	YNUX-400920-BBM	40	28,9	9,52	9,2	2	10,125°	10,125°	●	備用零件 請看36頁 Spare parts off page 36
	+ YNUX401020-BBM									
	YNUX-501217-BBM	50	29,2	12,7	9,2	10	10°	7°	●	
	+ LNUX241200-BBM									
	YNUX-501227-BBM	50	32	12,7	9,2	5	12°	15°	●	
	+ LNUX251200-BBM									
	YNUX-601228-BBM	60	32	12,7	9,2	5	13°	15°	○	
	+ LNUX301200-BBM									
	YNUX-501217-BBO	50	29,2	12,7	9,2	10	10°	7°	○	
	+ LNUX241200-BBO									
	YNUX-601228-BBO	60	32	12,7	9,2	5	13°	15°	○	
	+ LNUX301200-BBO									
	YNUX-501219-BBM	50	27	12,7	7,2	1	19°	0°	●	
	+ YNUX501200-BBM									
	YNUX-501310-BFF	50	27,8	12,8	9,2	2	5	5	●	

+ alte Bestellbezeichnung old ordering identification

實際的顏色和圖片可能有差異
Colours of the original indexable inserts may deviate from the illustration!

- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

參考倒角角度和板厚選擇刀具

Choice of tool in relation to chamfer angle and wall thickness



K
刀具種類
Type of tool

K = Kassette
= Cartridge

KT = Kassette
= Cartridge

mit with

WSP **TNM.**
Insert Insert

KY = Kassette
= Cartridge

mit with

WSP **YNUX**
Insert Insert

4
切削刃長度 mm
Length of cutting edge in mm

mm	Wendeplatte
mm	Indexable insert
2 = 25,4	SNMM 250724
3 = 33,0	TNMT 330924
3 = 33,0	TNMT 330924
4 = 44,0	TNMT 440924
4 = 40	LNUX 400924
4 = 40	YNUX 400924 *
5 = 50	LNUX 501224
5 = 50	YNUX 501217 *
6 = 60	LNUX 601224
6 = 60	YNUX 601228
7 = 70	LNUX 701224

*) alte Bezeichnung
old designation

*Tulpenprofil Tulip profile

1
f-量測值 mm
Measure f in mm

1 = 48 mm

2 = 50 mm

45°
倒角角度 α
chamfer angle α

α° :

0
2
4
6
7
8
10
15
22
25
27
30
32
35
37
40
45
50

$\alpha^\circ 1/\alpha^\circ 2$

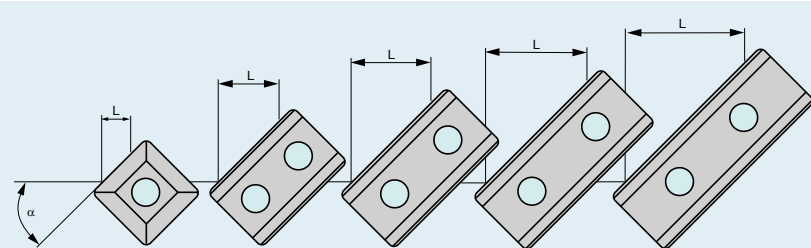
10/30
10/37,5
14/33
13/30

L
切削方向
Direction of cut

R

管端加工刀匣的命名系統

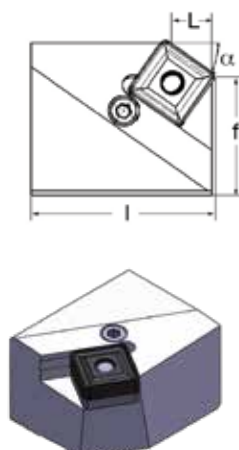
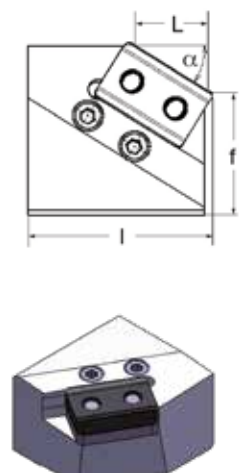
Designation system for cartridges for pipe end preparation



刀匣 Cartridge	K-2 R/L	K-4 R/L	K-5 R/L	K-6 R/L	K-7 R/L
可轉位刀片 Indexable insert	SNMM 25	LNUX 40	LNUX 50	LNUX 60	LNUX 70
倒角 Chamfer	L = 最大壁厚 L = Maximum wall Thickness				
$\alpha = 0^\circ$	16,0	32,0	40,0	50,0	60,0
$\alpha = 2^\circ$	16,0	32,0	40,0	50,0	60,0
$\alpha = 3^\circ$	16,0	32,0	40,0	50,0	60,0
$\alpha = 4^\circ$	16,0	32,0	40,0	49,5	60,0
$\alpha = 5^\circ$	15,5	32,0	40,0	49,5	59,5
$\alpha = 6^\circ$	15,5	32,0	40,0	49,5	59,5
$\alpha = 7^\circ$	15,5	32,0	39,5	49,5	59,5
$\alpha = 10^\circ$	15,5	31,5	39,5	49,0	59,0
$\alpha = 12,5^\circ$	15,5	31,0	39,0	48,5	58,5
$\alpha = 15^\circ$	15,5	31,0	38,5	48,0	58,0
$\alpha = 17,5^\circ$	15,0	30,5	38,0	47,5	57,0
$\alpha = 20^\circ$	15,0	30,0	37,5	46,5	56,0
$\alpha = 22^\circ$	15,0	29,5	37,0	46,0	55,0
$\alpha = 25^\circ$	14,5	29,0	36,0	45,0	54,0
$\alpha = 27^\circ$	14,0	28,5	35,5	44,0	53,0
$\alpha = 30^\circ$	14,0	27,5	34,5	43,0	51,0
$\alpha = 32^\circ$	13,5	27,0	34,0	42,0	50,0
$\alpha = 35^\circ$	13,0	26,0	32,5	40,5	48,0
$\alpha = 37^\circ$	12,5	25,5	32,0	39,5	47,0
$\alpha = 40^\circ$	12,0	24,5	30,5	37,5	45,0
$\alpha = 45^\circ$	11,0	22,5	28,0	34,5	41,0

管端加工的刀匣和備用零件

Cartridges and spare parts for pipe end bevelling

繪製的為左手版本 鏡向的為右手版本 Left hand version shown, right hand version mirrorlike	Bestellbezeichnung Ordering code	α	f	l	L	Lager Stock		可轉位刀片 Indexable inserts	Seite Page
						R	L		
	K-2-2-0°-R/L	0°	50	72	16,0	●	●	SNMM 2507..	32
	K-2-2-2°-R/L	2°	50	72	16,0	●	●		
	K-2-2-4°-R/L	4°	50	72	16,0	●	●		
	K-2-2-7°-R/L	7°	50	72	15,5	●	●		
	K-2-2-10°-R/L	10°	50	72	15,5	●	●		
	K-2-1-15°-R/L	15°	48	72	15,5	●	●		
	K-2-1-25°-R/L	25°	48	72	14,5	●	●		
	K-2-1-27°-R/L	27°	48	72	14,0	●	●		
	K-2-1-30°-R/L	30°	48	72	14,0	●	●		
	K-2-1-32°-R/L	32°	48	72	13,5	●	●		
	K-2-1-35°-R/L	35°	48	72	13,0	●	●		
	K-2-1-37°-R/L	37°	48	72	12,5	●	●		
	K-2-1-40°-R/L	40°	48	72	12,0	●	●		
	K-2-1-45°-R/L	45°	48	72	11,0	●	●		
	K-2-1-50°-R/L	50°	48	72		●	●		
	K-2-1-60°-R/L	60°	48	72		●	●		
	K-4-2-0°-R/L	0°	50	72	32,0	●	●	LNUX 40...	32
	K-4-2-2°-R/L	2°	50	72	32,0	●	●		
	K-4-2-4°-R/L	4°	50	72	32,0	●	●		
	K-4-2-6°-R/L	6°	50	72	32,0	●	●		
	K-4-2-7°-R/L	7°	50	72	32,0	●	●		
	K-4-2-10°-R/L	10°	50	72	31,5	●	●		
	K-4-1-12,5°-R/L	12,5°	48	72	31,0	●	●		
	K-4-1-15°-R/L	15°	48	72	31,0	●	●		
	K-4-1-17,5°-R/L	17,5°	48	72	30,5	●	●		
	K-4-1-22°-R/L	22°	48	72	29,5	●	●		
	K-4-1-27°-R/L	27°	48	72	28,5	●	●		
	K-4-1-30°-R/L	30°	48	72	27,5	●	●		
	K-4-1-32°-R/L	32°	48	72	27,0	●	●		
	K-4-1-35°-R/L	35°	48	72	26,0	●	●		
	K-4-1-37°-R/L	37°	48	72	25,5	●	●		
	K-4-1-40°-R/L	40°	48	72	24,5	●	●		
K-4-1-45°-R/L	45°	48	72	22,5	●	●			

註：可依要求訂製，我們很樂意為您提供建議！

Note: Customized designs on request! We will be happy to advise you!

備用零件 Spare parts		Bestellnummer Ordering code					
可轉位刀片 Indexable insert	切削刃長 Cutting length						
		墊片 Shim ③	槓桿 Lever ④	固定螺絲 Fixation screw ⑥	墊片定位銷 Shim pin ⑤		
SNMM 25..	25	B01-S-2463	D02-23250	D-22-013	E01-15212		
LNUX 40..	40	D-20-037	D02-23250	D-22-013	E01-15212		

Bestellbeispiel: 1 Stück K-2-2-0°-R
Ordering example: 1 piece K-2-2-0°-R

出貨時不含扳手和固定銷
Delivery without key and mounting pin

- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

繪製的為左手版本 鏡向的為右手版本 Left hand version shown, right hand version mirrorlike	Bestellbezeichnung Ordering code					Lager Stock		可轉位刀片 Indexable inserts	Seite Page
		α	f	l	L	R	L		
	K-5-2-0°-R/L	0°	50	72	40,0	●	○	LNUX 50...	32
	K-5-2-2°-R/L	2°	50	72	40,0	○	○		
	K-5-2-3°-R/L	3°	50	72	40,0	○	○		
	K-5-2-6°-R/L	6°	50	72	40,0	○	○		
	K-5-1-7,5°-R/L	7,5°	48	72	39,5	○	○		
	K-5-1-8°-R/L	8°	50	72	39,5	○	○		
	K-5-1-10°-R/L	10°	48	72	39,5	○	○		
	K-5-1-12°-R/L	12°	48	72	39,0	○	○		
	K-5-1-15°-R/L	15°	48	72	38,5	○	●		
	K-5-1-17,5°-R/L	17,5°	48	72	38,0	○	○		
	K-5-1-20°-R/L	20°	48	72	37,5	○	○		
	K-5-1-22°-R/L	22°	48	72	37,0	○	●		
	K-5-1-25°-R/L	25°	48	72	36,0	○	●		
	K-5-1-27°-R/L	27°	48	72	35,5	○	●		
	K-5-1-30°-R/L	30°	48	72	34,5	●	●		
	K-5-1-32°-R/L	32°	48	72	34,0	○	●		
K-5-1-35°-R/L	35°	48	72	32,5	○	●			
K-5-1-37°-R/L	37°	48	72	32,0	○	●			
K-5-1-45°-R/L	45°	48	72	28,0	●	●			
	K-6-2-0°-R/L	0°	50	72	50,0	●	●	LNUX 60...	32
	K-6-1-10°-R/L	10°	48	72	49,0	○	○		
	K-6-1-15°-R/L	15°	48	72	48,0	○	○		
	K-6-1-25°-R/L	25°	48	72	45,0	○	○		
	K-6-1-30°-R/L	30°	48	72	43,0	○	○		
	K-6-1-32°-R/L	32°	48	72	42,0	○	●		
	K-6-1-35°-R/L	35°	48	72	40,5	○	●		
	K-6-1-37°-R/L	37°	48	72	39,5	○	○		
	K-6-1-45°-R/L	45°	48	72	34,5	○	○		

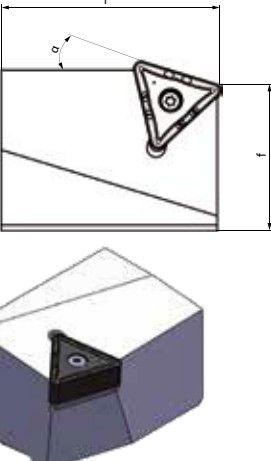
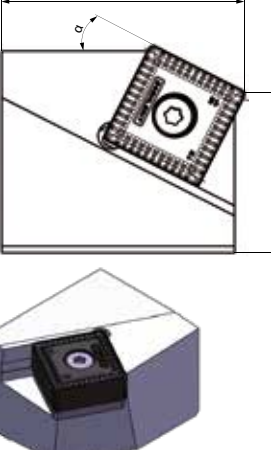
註：可依要求訂製，我們很樂意為您提供建議！
Note: Customized designs on request! We will be happy to advise you!

備用零件 Spare parts		Bestellnummer Ordering code					
可轉位刀片 Indexable insert	切削刃長 Cutting length	墊片 Shim ③	槓桿 Lever ④	固定螺絲 ⑥	螺絲 DIN 7991 Screw DIN 7991 ⑤	螺絲 DIN 7984 Screw DIN 7984 ⑤	
		LNUX 50..	50	D-20-038	D02-23250	D-22-013	M5x10 -8.8
LNUX 60..	60	D-20-068	D02-23250	D-22-013		M5x10 -8.8	

Bestellbeispiel: 1 Stück K-5-2-2°-R
Ordering example: 1 piece K-5-2-2°-R

出貨時不含扳手和固定銷
Delivery without key and mounting pin

- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

繪製的為左手版本 鏡向的為右手版本 Left hand version shown, right hand version mirrorlike	Bestellbezeichnung Ordering code	α	f	l	L	Lager Stock		可轉位刀片 Indexable inserts	Seite Page	
						R	L			
KT-3-1- α -L 	KT-3-1-17°-L	17°	48	72		●	●	TNMT 3309	33	
K-3-1- α -L 	K-3-1-27°-L	27°	48	72		●		SNMT 3112..	32	
	K-3-2-0°-R	0°	50	72			●			

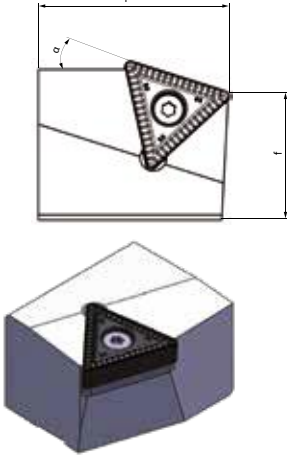
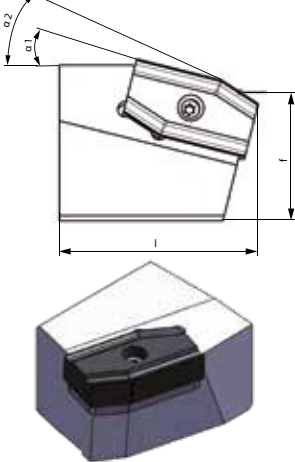
註：可依要求訂製，我們很樂意為您提供建議！
Note: Customized designs on request! We will be happy to advise you!

備用零件 Spare parts	Bestellnummer Ordering code			
可轉位刀片 Indexable insert	墊片 Shim 	墊片螺絲 Shim screw 	固定螺絲 Fixation screw 	扳手 Key 
TNMT 330924	D-20-114	E09-F6045	D22-027	Torx 1
				
SNMT 311216	D-20-111	E02-F12080	A02-80250	Torx 30

Bestellbeispiel: 1 Stück KT-3-1-17°-L
Ordering example: 1 piece KT-3-1-17°-L

出貨不含扳手
Delivery without key

- Verfügbar ab Lager Available from stock
- kurzfristig lieferbar shortly available
- Auf Anfrage On request

繪製的為左手版本 鏡向的為右手版本 Left hand version shown, right hand version mirrorlike	Bestellbezeichnung Ordering code	α	f	l	L	Lager Stock		可轉位刀片 Indexable inserts	Seite Page
						R	L		
	KT-4-1-12,5°-R/L	12,5°	48	72		●	●	TNMT-4409..	33
	KT-4-1-17,5°-R/L	17,5°	48	72		●	●		
	KT-4-1-32,5°-R/L	32,5°	48	72		●	●		
		$\alpha 1 / \alpha 2$	f	l	L				
	KY-5-1-14°/33°-L	14°/33°	50	77			●	YNUX 5012..	33

● : Ab Lager verfügbar Available from stock
 ○ : kurzfristig lieferbar shortly available

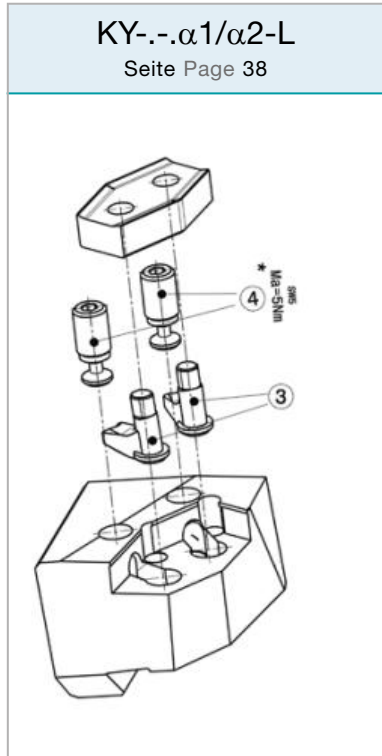
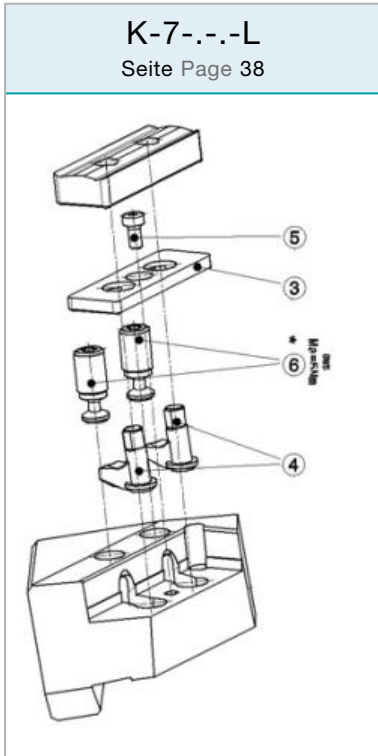
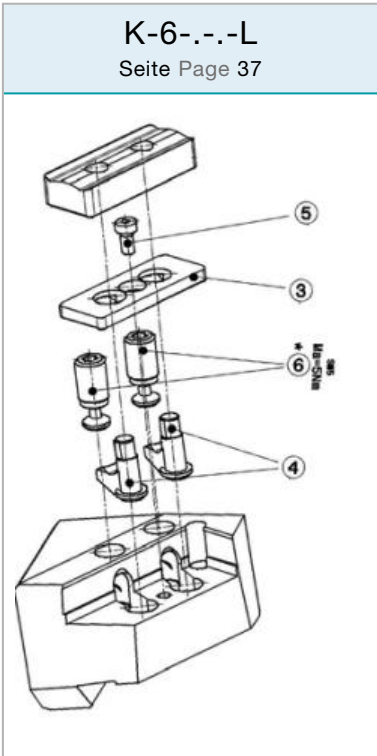
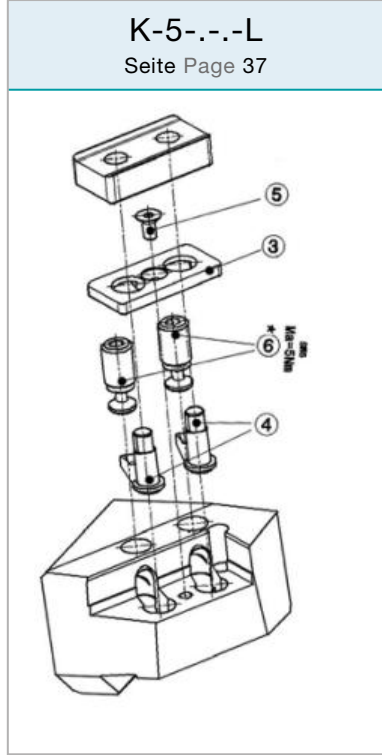
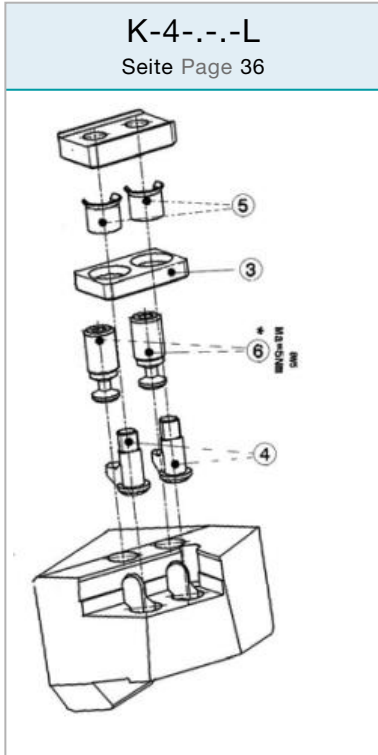
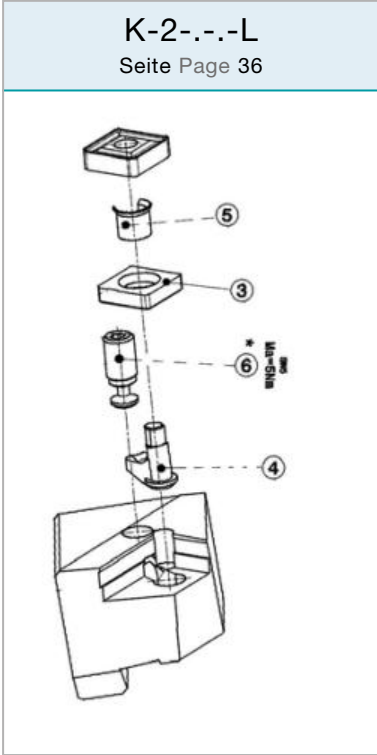
註：可依要求訂製，我們很樂意為您提供建議！
 Note: Customized designs on request! We will be happy to advise you!

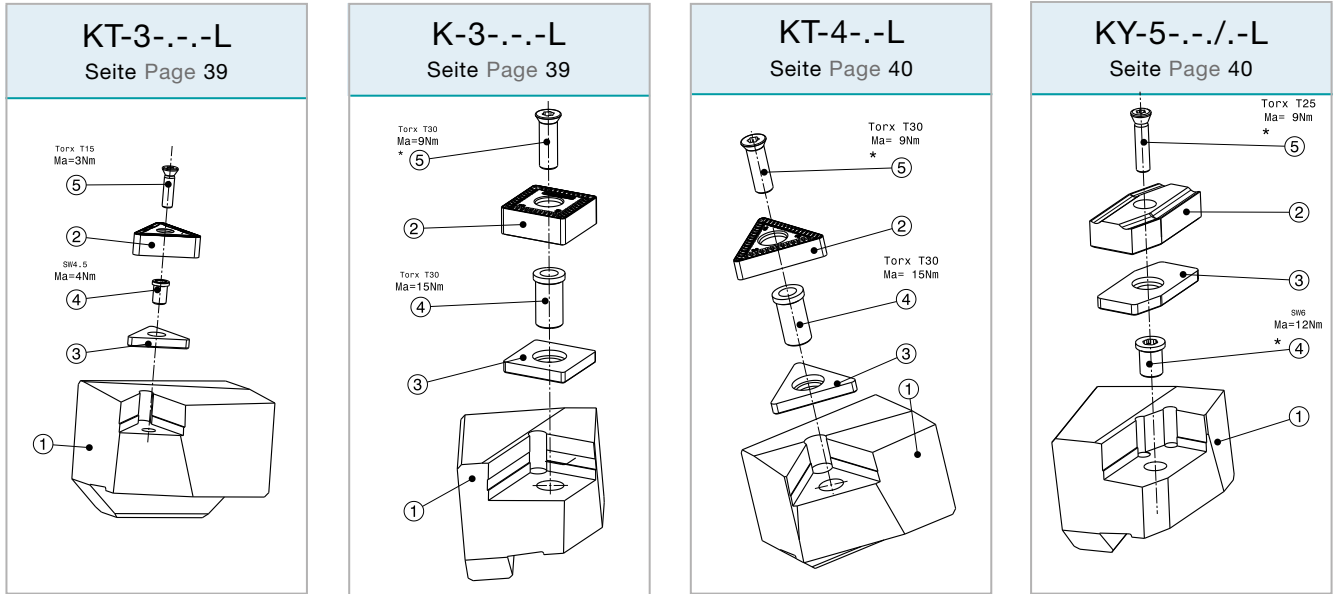
備用零件 Spare parts	Bestellnummer Ordering code			
可轉位刀片 Indexable insert	墊片 Shim	墊片螺絲 Shim screw	固定螺絲 Fixation screw	扳手 Key
TNMT 440920	D-20-102	E02-F12080	A02-80250	Torx 30
YNUX 501219	D-20-096	D23-001	D22-022	Torx 25

Bestellbeispiel: 1 Stück KT-17,5°-L
 Ordering example: 1 piece KT-17,5°-L

出貨不含扳手
 Delivery without key

● Verfügbar ab Lager Available from stock
 ○ kurzfristig lieferbar shortly available
 ○ Auf Anfrage On request





管加工切削參數建議
Cutting data recommendations pipe end preparation

管外徑 英寸	速度 m/min.	轉速 U/min.	最小進給 mm/min min.	最大進給 mm/min max.	速度 m/min.	轉速 U/min.	最小進給 mm/min min.	最大進給 mm/min max.	速度 m/min.	轉速 U/min.	最小進給 mm/min min.	最大進給 mm/min max.
Od pipe diameter inch	Cutting speed m/min.	Revolu- tion r.p.m.	Feed mm/min min.	Feed mm/min max.	Cutting speed m/min.	Revolu- tion r.p.m.	Feed mm/min min.	Feed mm/min max.	Cutting speed m/min.	Revolu- tion r.p.m.	Feed mm/min min.	Feed mm/min max.
鋼 St37 (B) Steel St37 (B)												
板厚(英寸) Wall thickness inch 0,375 / 0,500 / 0,625 / 0,750				板厚(英寸) Wall thickness inch 0,875 / 1,000				板厚(英寸) Wall thickness inch 1,250 / 1,500				
24	139,8	73	33	40	120,6	63	22	28				
26	139,0	67	30	37	120,3	58	20	26				
28	138,5	62	28	34	120,6	54	19	24				
30	138,8	58	26	32	119,7	50	17	22	100,5	42	10	15
32	140,4	55	25	30	120,0	49	16	21	99,6	39	10	14
34	138,4	51	23	28	119,4	44	15	20	100,4	37	9	13
36	140,8	49	22	27	120,7	42	14	19	100,5	35	9	12
38	139,5	46	21	26	118,3	39	13	17	100,1	33	8	12
40	140,4	44	20	24	118,1	37	13	17	98,9	31	8	11
42	140,8	42	19	23	120,6	36	13	16	100,5	30	7	10
44	140,4	40	18	22	119,4	34	12	15	98,3	28	7	10
45	139,5	38	17	21	121,1	33	12	15	99,1	27	7	9
48	137,9	36	16	20	118,7	31	11	14	99,6	26	6	9
50	139,6	35	16	19	119,7	30	10	13	99,7	25	6	9
52	141,0	34	15	19	120,3	29	10	12	99,6	24	6	8
54	137,9	32	14	18	120,6	28	10	12	99,1	23	6	8
56	138,5	31	14	17	120,6	27	9	12	98,3	22	5	8
58	138,8	30	13	17	120,3	26	9	12	97,2	21	5	7
60	138,8	29	13	16	119,7	25	9	11	96,0	20	5	7
62	138,5	28	13	15	118,7	24	8	11	98,9	20	5	7
64	137,9	27	12	15	117,5	23	8	10	97,0	19	5	7



管外徑 英寸	速度 m/min.	轉速 U/min.	最小進給 mm/min min.	最大進給 mm/min max.	速度 m/min.	轉速 U/min.	最小進給 mm/min min.	最大進給 mm/min max.	速度 m/min.	轉速 U/min.	最小進給 mm/min min.	最大進給 mm/min max.
Od pipe diameter inch	Cutting speed m/min.	Revolu- tion r.p.m.	Feed mm/min min.	Feed mm/min max.	Cutting speed m/min.	Revolu- tion r.p.m.	Feed mm/min min.	Feed mm/min max.	Cutting speed m/min.	Revolu- tion r.p.m.	Feed mm/min min.	Feed mm/min max.
鋼 St50 (X50) Steel St50 (X50)												
板厚(英寸) Wall thickness inch 0,375 / 0,500 / 0,625 / 0,750				板厚(英寸) Wall thickness inch 0,875 / 1,000 / 1,250				板厚(英寸) Wall thickness inch 1,500				
24	120,6	63	25	32	99,6	52	13	18				
26	120,3	58	23	29	99,6	48	12	17				
28	120,6	54	22	27	100,5	45	11	16				
30	119,7	50	20	25	100,5	42	10	15	81,4	34	8	12
32	120,0	47	19	24	99,6	39	10	14	79,2	31	8	11
34	119,4	44	18	22	100,4	37	9	13	81,4	30	7	10
36	120,7	42	17	21	100,5	35	9	12	80,4	28	7	10
38	118,3	39	16	20	100,1	33	8	12	81,9	27	7	9
40	118,1	37	15	19	98,9	31	8	11	79,8	25	6	9
42	120,6	36	14	18	100,5	30	7	10	80,4	24	6	8
44	119,4	34	14	17	98,3	28	7	10	80,7	23	6	8
46	121,1	33	13	17	99,1	27	7	9	80,7	22	5	8
48	118,7	31	12	16	99,6	26	6	9	80,4	21	5	7
50	119,7	30	12	15	99,7	25	6	9	79,8	20	5	7
52	120,3	29	12	15	99,6	24	6	8	78,8	19	5	7
54	120,6	28	11	14	99,1	23	6	8	81,9	19	5	7
56	120,6	27	11	14	98,3	22	5	8	80,4	18	4	6
58	120,3	26	10	13	97,2	21	5	7	78,7	17	4	6
60	119,7	25	10	13	96,0	20	5	7	81,4	17	4	6
62	118,7	24	10	12	98,9	20	5	7	79,2	16	4	6
64	117,5	23	9	12	97,0	19	5	7	81,7	16	4	6
鋼 St60 (X60) Steel St60 (X60)												
板厚(英寸) Wall thickness inch 0,375 / 0,500 / 0,625 / 0,750 / 0,875					板厚(英寸) Wall thickness inch 1,000 / 1,250 / 1,500							
24	99,6	52	21	26	80,4	42	11	15				
26	99,6	48	19	24	80,9	39	10	14				
28	100,5	45	18	23	80,4	36	9	13				
30	100,5	42	16	21	81,4	34	8	12				
32	99,6	39	15	20	79,2	31	8	11				
34	100,4	37	14	19	81,4	30	7	10				
36	100,5	35	13	18	80,4	28	7	10				
38	100,1	33	12	17	81,9	27	7	9				
40	98,9	31	12	16	79,8	25	6	9				
42	100,5	30	11	15	80,4	24	6	8				
44	98,3	28	11	14	80,7	23	6	8				
46	99,1	27	11	14	80,7	22	5	8				
48	99,6	26	10	13	80,4	21	5	7				
50	99,7	25	10	13	79,8	20	5	7				
52	99,6	24	9	12	78,8	19	5	7				
54	99,1	23	9	12	81,9	19	5	7				
56	98,3	22	9	11	80,4	18	4	6				
58	97,2	21	8	11	78,7	17	4	6				
60	96,0	20	8	10	81,4	17	4	6				
62	98,9	20	8	10	79,2	16	4	6				
64	97,0	19	8	10	81,7	16	4	6				

Sorte Grade	ISO	Anwendungsbereich Range of applications	Werkstoffgruppe Group of materials						Bearbeitungsverfahren Application					
			P	M	K	N	S	H	T	M	D	S	G	P
			Stahl Steel	Rostfrei Stainless	Grauguß Grey cast iron	NE-Metalle (Al, etc.) Nonferrous metals	Hochwarmfest Hightempera- ture mate- rials	Harte Werkstoffe Hard materials	Drehen Turning	Fräsen Milling	Hobeln Scarfing	Gewinde- bearbeitung Threading	Einstechen Grooving	Abstechen Parting
LCP37M	HC-P40		■							●				
	HC-M40			□						●				
BCP30E	HC-P30		■							●				
	HC-M30			□						●				
LCP25T	HC-P25		■							●				
	HC-M25			□						●				
LC228E	HC-P30		■							●				
	HC-M30			□						●				
LC240F	HC-P40		■							●				
	HC-M40			□						●				
BCP35S	HC-P35		■								●			
LCP39S	HC-P40		■								●			
	HC-M40			□							●			
LC225N	HC-P25		■							●				
BCP45S	HC-K50				■						●			
LC238H	HC-P38		■								●			
LCP17S	HC-P15		■								●			
	HC-K15				■						●			
LCP37S	HC-P40		■								●			
	HC-M40			□							●			
LW240	HC-P40		■								●			

Anwendungsschwerpunkt
Application peak

Gesamtbereich nach ISO 513
Full range to ISO 513

■ Hauptanwendung
Main application

□ Weitere Anwendung
Further applications

● Standardsorte
Standard grade

● **LCP37M (HC-P40/M45) Goldlox**

(通用銑削牌號)

用於粗加工合金鋼、非合金鋼和不鏽鋼材料的主要牌號。此牌號可以非常經濟地用於管加工的大部分材料。

● **LCP25T (HC-P25, HC-M25)**

(通用車削牌號)

主要用於中等切削速度（包括斷續切削）車削鋼材和易切削不鏽鋼，這種多用途牌號的特點是在廣泛的應用中具有高耐磨性和優異的韌性。

● **LC228E (HC-P30, HC-M30)**

用於重切削，適合以中等切削速度加工低合金到高合金鋼和不鏽鋼。

● **LC240F (HC-P40, HC-M40)**

用於以中等切削速度加工合金鋼和非合金鋼的材質。多層TiN TiCN塗層應用於極強堅韌的母材上。這種切削材料將硬質材料塗層的耐磨性與母材的切削刃穩定性和抗崩刃性結合在一起。

● **BCP35S (HC-P35)**

高韌性牌號，適合連續切削或刮削時短時間斷續切削。精細的母材與 AlTiN 塗層相結合，確保在最高溫下的高耐磨性和抗破裂保護。

● **BCP30E (HC-P30 HC-M30)**

通用鋼銑削類型可在各種鋼材上實現高加工可靠性，特別堅韌的鎢鋼母材保證了這一點。使用仔細協調的塗層參數可以沉積特別厚的 PVD 塗層，從而顯著降低對裂縫的敏感性。

● **LCP37M (HC-P40/M45) Goldlox**

(Universal milling grade)

Main grade for roughing of alloyed, unalloyed respectively rust-resistant steel materials. The majority of the used materials for the production of tubes can be machined very economically with this grade.

● **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

● **LC228E (HC-P30, HC-M30)**

Grade for heavy duty machining, very good suitable for low to high alloyed steels and stainless steels at medium cutting speeds.

● **LC240F (HC-P40, HC-M40)**

Grade for machining alloyed and unalloyed steels at medium cutting speeds. The multilayer TiN TiCN coating is on a very tough base material. This grade has the wear resistance of the hard material coating as well as the cutting edge stability and breakage security of the substrate.

● **BCP35S (HC-P35)**

Heavy-duty grade particularly well suited for a continuous cut and/or briefly interrupted cut in scraping operations. The fine base substrate in combination with the AlTiN coat ensures high abrasion and chipping resistance as well as optimum temperature resistance.


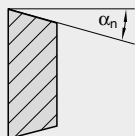
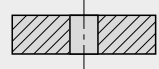





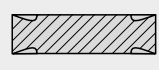

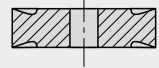


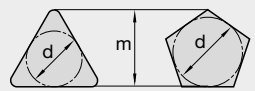
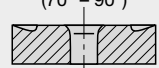


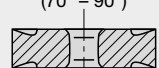


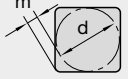






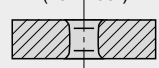


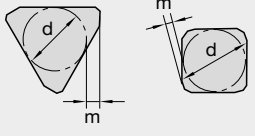
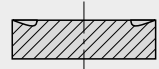


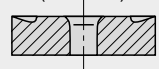


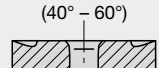


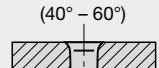



● **BCP30E (HC-P30 HC-M30)**

Universal steel milling grade for high machining safety on a wide range of steelgrades, guaranteed by the particularly tough substrate. The PVD coating is deposited extraordinary thick by special coating parameters, which significantly reduces cracking sensitivity

舊牌號對照

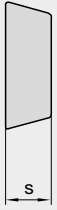
Old grade denominations

VA815 = LCP37M
VA1205 = LCP25T
LC238E = BCP35S
VA652 = LCP39S
VA1371 = BCP45S
VA1071 = LCP37S

S Grundform Insert shape	N Freiwinkel Clearance angle	M Toleranzen Tolerances	X Spanformer, Befestigung Chip breaker, fixation	12 Schneidenlänge Cutting edge length																																																																														
A  85°		<table border="1"> <thead> <tr> <th></th> <th>m</th> <th>s</th> <th>d</th> </tr> </thead> <tbody> <tr><td>A</td><td>±0,005</td><td>±0,025</td><td>±0,025</td></tr> <tr><td>C</td><td>±0,013</td><td>±0,025</td><td>±0,025</td></tr> <tr><td>E</td><td>±0,025</td><td>±0,025</td><td>±0,025</td></tr> <tr><td>F</td><td>±0,005</td><td>±0,025</td><td>±0,013</td></tr> <tr><td>G</td><td>±0,025</td><td>±0,13</td><td>±0,025</td></tr> <tr><td>H</td><td>±0,013</td><td>±0,025</td><td>±0,013</td></tr> <tr><td>J</td><td>±0,005</td><td>±0,025</td><td>siehe see Tab. 4</td></tr> <tr><td>K</td><td>±0,013</td><td>±0,025</td><td>siehe see Tab. 4</td></tr> <tr><td>L</td><td>±0,025</td><td>±0,025</td><td>siehe see Tab. 4</td></tr> <tr><td>M</td><td>siehe see Tab. 5</td><td>±0,13</td><td>siehe see Tab. 4</td></tr> <tr><td>N</td><td>siehe see Tab. 5</td><td>±0,025</td><td>siehe see Tab. 4</td></tr> <tr><td>U</td><td>siehe see Tab. 5</td><td>±0,13</td><td>siehe see Tab. 4</td></tr> </tbody> </table>		m	s	d	A	±0,005	±0,025	±0,025	C	±0,013	±0,025	±0,025	E	±0,025	±0,025	±0,025	F	±0,005	±0,025	±0,013	G	±0,025	±0,13	±0,025	H	±0,013	±0,025	±0,013	J	±0,005	±0,025	siehe see Tab. 4	K	±0,013	±0,025	siehe see Tab. 4	L	±0,025	±0,025	siehe see Tab. 4	M	siehe see Tab. 5	±0,13	siehe see Tab. 4	N	siehe see Tab. 5	±0,025	siehe see Tab. 4	U	siehe see Tab. 5	±0,13	siehe see Tab. 4	A 	<table border="1"> <thead> <tr> <th></th> <th>l</th> </tr> </thead> <tbody> <tr><td>06</td><td>6,350</td></tr> <tr><td>07</td><td>7,938</td></tr> <tr><td>09</td><td>9,525</td></tr> <tr><td>11</td><td>11,000</td></tr> <tr><td>12</td><td>12,700</td></tr> <tr><td>15</td><td>15,875</td></tr> <tr><td>16</td><td>16,500</td></tr> <tr><td>19</td><td>19,050</td></tr> <tr><td>22</td><td>22,000</td></tr> <tr><td>25</td><td>25,400</td></tr> <tr><td>31</td><td>31,750</td></tr> <tr><td>38</td><td>38,100</td></tr> </tbody> </table>		l	06	6,350	07	7,938	09	9,525	11	11,000	12	12,700	15	15,875	16	16,500	19	19,050	22	22,000	25	25,400	31	31,750	38	38,100
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E  75°	C 7°	<table border="1"> <thead> <tr> <th>d</th> <th>M, N</th> <th>m</th> <th>U</th> </tr> </thead> <tbody> <tr> <td>über over</td> <td>bis up to</td> <td></td> <td></td> </tr> <tr> <td>3,9</td> <td>10,0</td> <td>±0,08</td> <td>±0,13</td> </tr> <tr> <td>10,0</td> <td>15,0</td> <td>±0,13</td> <td>±0,20</td> </tr> <tr> <td>15,0</td> <td>20,0</td> <td>±0,15</td> <td>±0,27</td> </tr> <tr> <td>20,0</td> <td>26,0</td> <td>±0,18</td> <td>±0,38</td> </tr> <tr> <td>26,0</td> <td>32,0</td> <td>±0,20</td> <td>±0,38</td> </tr> </tbody> </table>	d	M, N	m	U	über over	bis up to			3,9	10,0	±0,08	±0,13	10,0	15,0	±0,13	±0,20	15,0	20,0	±0,15	±0,27	20,0	26,0	±0,18	±0,38	26,0	32,0	±0,20	±0,38	G 																																																			
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26,0	32,0	±0,20	±0,38																																																																															
H  120°	D 15°		H 																																																																															
K  55°	E 20°	Eckenrundung, ungerade Seitenzahl Corner rounding uneven number of sides	J 																																																																															
L  90°	F 25°		M 																																																																															
M  86°	G 30°	Eckenrundung, gerade Seitenzahl Corner rounding, even number of sides	N 																																																																															
O  135°	N 0°	Fasenplatten Chamfered inserts	Q 																																																																															
P  108°	N 0°		R 																																																																															
R  -	N 0°		T 																																																																															
S  90°	N 0°		U 																																																																															
T  60°	P 11°		W 																																																																															
V  35°	O																																																																																	
W  80°	Normalfreiwinkel, die eine besondere Beschreibung erfordern. Normal clearance angles, which require a special description.		X mit Besonderheit nach Zeichnung with special feature according to drawing																																																																															

() Kegelwinkel für Schraube
 () Cone angle for screw

06
 Dicke
 Thickness

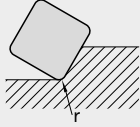


	S
02	2,38
03	3,18
T3	3,97
04	4,76
05	5,56
06	6,35
07	7,94
08	8,00
09	9,52

Abmessungen in mm
 Dimensions in mm

08
 Schneidenecke
 Cutting edge corner

Für Radiusplatten
 For radius inserts



	Eckradius-r Corner radius-r
00	scharfkantig sharp-edged
02	0,2
04	0,4
08	0,8
12	1,2
16	1,6
20	2,0

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