

TurnLine

**T-CBN HARDBREAKER HP**

www.tungaloy.de

Tungaloy Report TG0818-518-D1

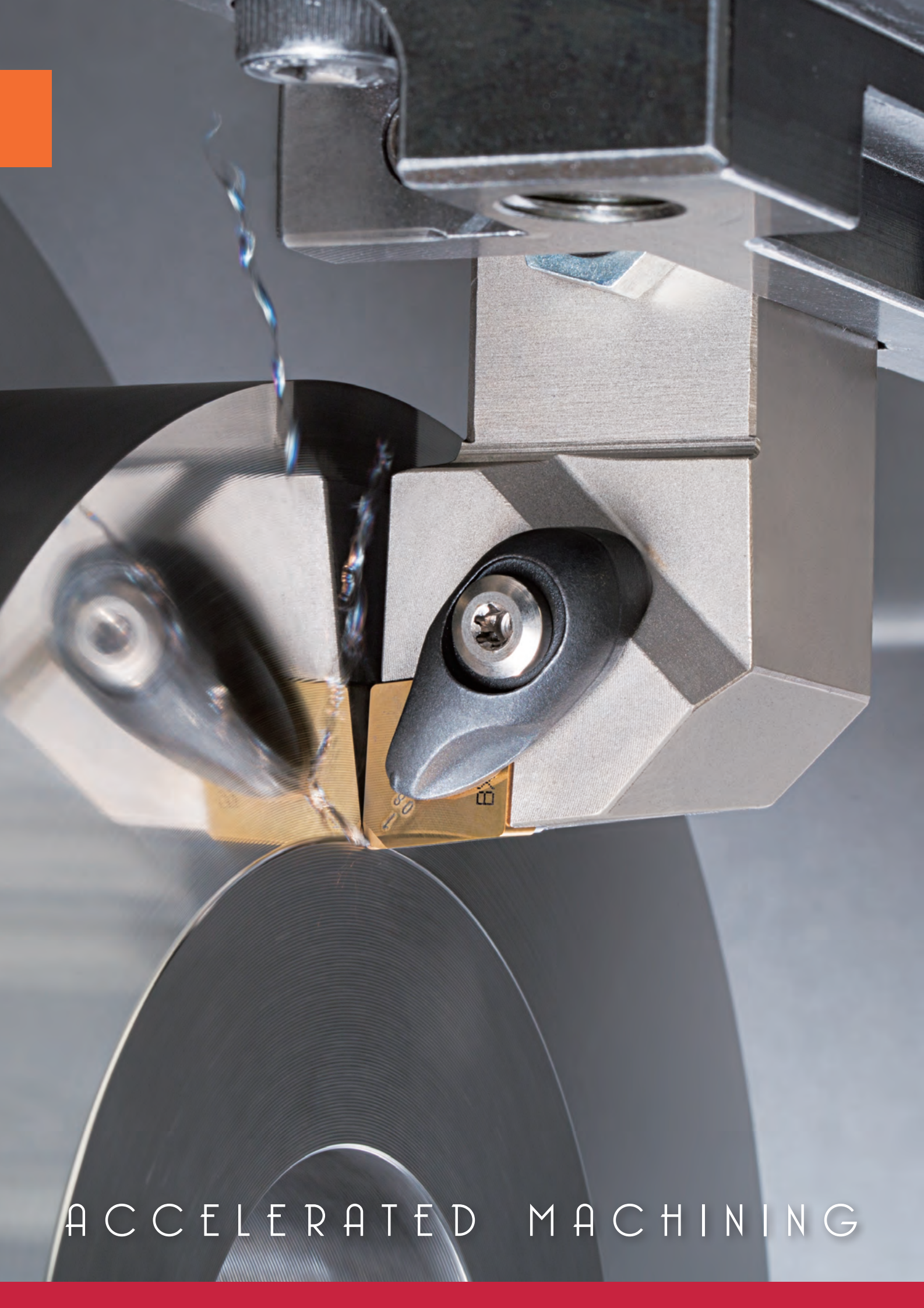
**SM<sup>★</sup>TOOLS<sup>®</sup>**

# NEUE Spanformstufe für effizientes Hartdrehen

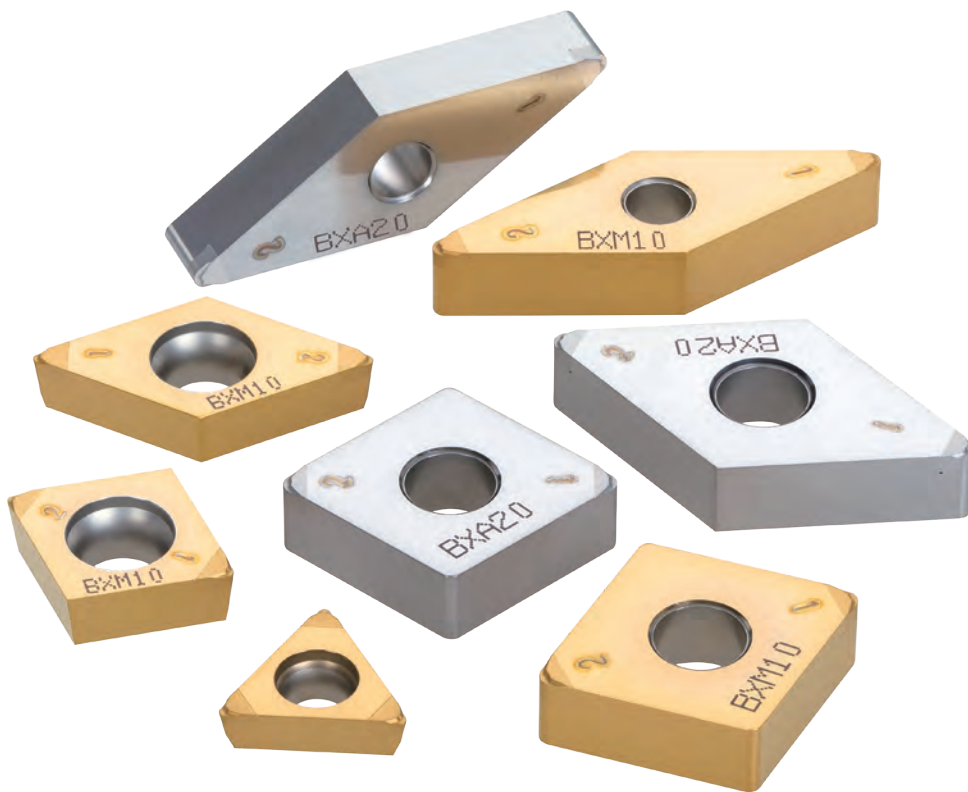
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*FEED the SPEED!*



ACCELERATED MACHINING



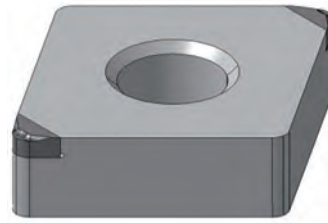
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Innovative 3D Spanformstufe für  
effiziente Spankontrolle

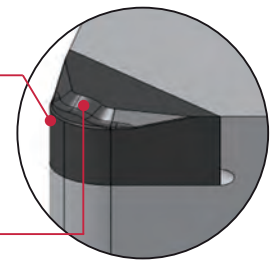
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## Neuer HP Spanformstufe Für die Schlichtbearbeitung von gehärtetem Stahl

- 1 Durch die Spanformstufe wird die auf die Schneidkante wirkende Kraft signifikant reduziert und Standzeiten deutlich erhöht.
- 2 Weicher Schnitt und niedrige Schnittkräfte zur Einhaltung engster Toleranzen ohne Abweichungen
- 3 Die **HP** Spanformstufe, mit Wiper Schneide erzielt exzellente Oberflächengüte und ausgezeichnete Spankontrolle.

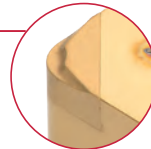
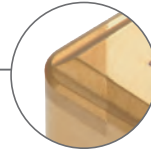
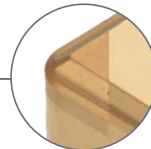
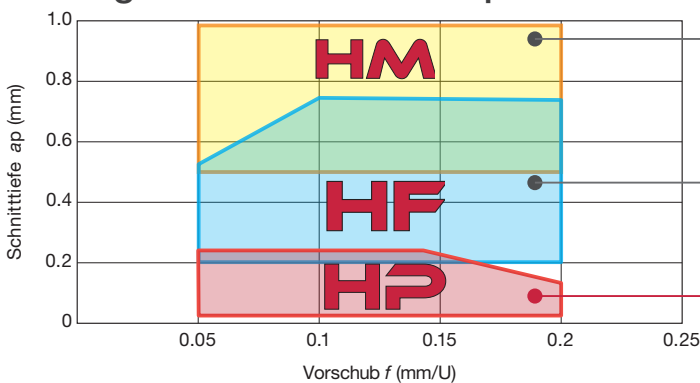


Optimierte  
Schneidkanten-  
präparation für  
geringste  
Schnittkräfte

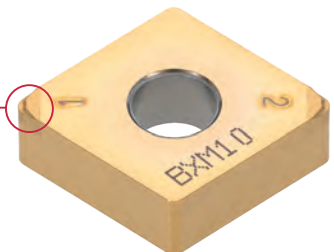


HP Spanformstufe

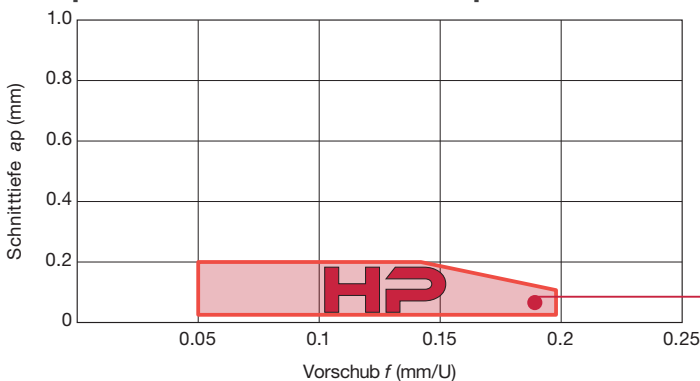
### Für negative Wendeschneidplatten



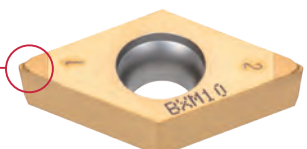
**HP**



### Für positive Wendeschneidplatten




**HP**




## SCHNITTLEISTUNG

Stabile Spankontrolle für lange Standzeiten

**HARDBREAKER HP**




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**Vs.**

40 Min.

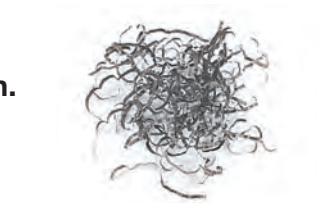
↓

80 Min.

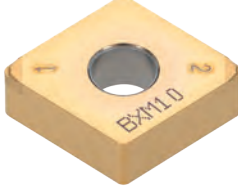
Mitbewerber




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**HP**



Wendeschnidplatte : 2QP-CNGM120408-HP BXM10  
 Werkstoff : 18CrMo4 58HRC  
 Schnittgeschwindigkeit :  $V_c = 180$  m/min  
 Vorschub :  $f = 0.15$  mm/U  
 Schnitttiefe :  $a_p = 0.15$  mm  
 Halter : ACLNR2525M12-A  
 Kühlung : Emulsion  
 Bearbeitung : Kontinuierliche Schnitt/Außen

## Antivibration

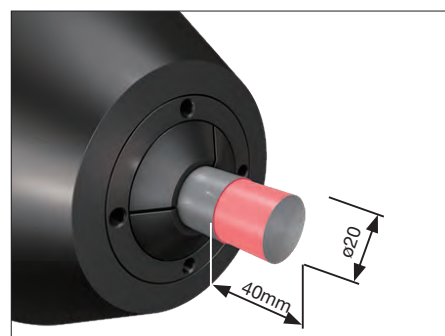
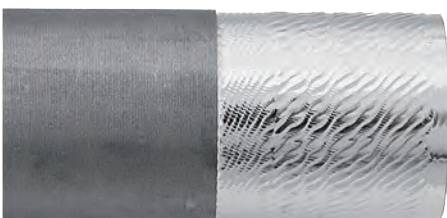
→ Verhindert Vibrationen und ermöglicht beste Oberflächengüte

### HARDBREAKER HP



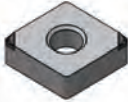
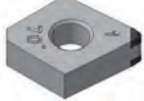
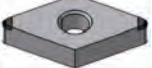


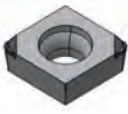
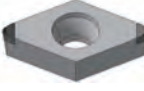
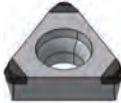
Niedrige Schnittkräfte ermöglichen vibrationsfreie Bearbeitung

Mitbewerber (ohne Spanformstufe)



Wendeschnidplatte : 2QP-CNGM120408-HP BXM10  
 Werkstoff : 18CrMo4 58HRC  
 Schnittgeschwindigkeit :  $V_c = 150$  m/min  
 Vorschub :  $f = 0.15$  mm/U  
 Schnitttiefe :  $a_p = 0.15$  mm  
 Bearbeitung : Kontinuierliche Schnitt/Außen

## WENDESCHNEIDPLATTEN

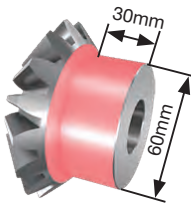
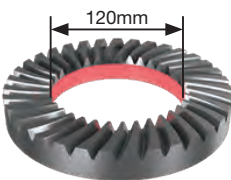
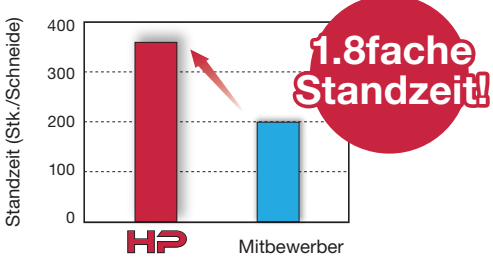
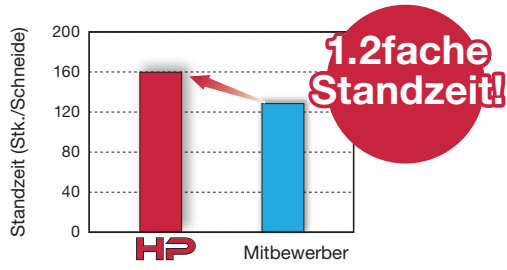
Form	Katalog Nr.	Schneidstoff		Innenkreis	Dicke	Loch-Ø	Eckenradius	CBN Länge
		Beschichtet						
		BXM10	BXA20					
		IC	S	D1	RE	LE		
	2QP-CNGM120404-HP	●	●	12.7	4.76	5.16	0.4	2.3
	2QP-CNGM120408-HP	●	●	12.7	4.76	5.16	0.8	2.2
	2QP-CNGM120408WL-HP	●	●	12.7	4.76	5.16	0.8	2.2
	2QP-GNGG120404-HP	●	●	12.7	4.76	5.16	0.4	2.3
	2QP-GNGG120408-HP	●	●	12.7	4.76	5.16	0.8	2.2
	2QP-DNGM150404-HP	●	●	12.7	4.76	5.16	0.4	2.5
	2QP-DNGM150408-HP	●	●	12.7	4.76	5.16	0.8	2.1
	3QP-TNGM160404-HP	●	●	9.525	4.76	3.81	0.4	2.2
	3QP-TNGM160408-HP	●	●	9.525	4.76	3.81	0.8	1.9
	2QP-VNGM160408-HP	●	●	9.525	4.76	3.81	0.8	2.2
	2QP-CCGT060204-HP	●	●	6.35	2.38	2.8	0.4	2.3
	2QP-CCGT09T304-HP	●	●	9.525	3.97	4.4	0.4	2.3
	2QP-CCGT09T308-HP	●	●	9.525	3.97	4.4	0.8	2.2
	2QP-CCGT09T304WL-HP	●	●	9.525	3.97	4.4	0.4	2.3
	2QP-CCGT09T308WL-HP	●	●	9.525	3.97	4.4	0.8	2.2
	2QP-DCGT070204-HP	●	●	6.35	2.38	2.8	0.4	2.5
	2QP-DCGT11T304-HP	●	●	9.525	3.97	4.4	0.4	2.5
	2QP-DCGT11T308-HP	●	●	9.525	3.97	4.4	0.8	2.1
	3QP-TPGT110304-HP	●	●	6.35	3.18	3.4	0.4	2.2
	3QP-TPGT110308-HP	●	●	6.35	3.18	3.4	0.8	1.9

● Neues Produkt  
● Markteinführung in 2018

## STANDARD SCHNITTDATEN

ISO	Schneidstoff	Bearbeitung	Schnittgeschwindigkeit Vc(m/min)	Schnitttiefe ap (mm)	Vorschub f (mm/U)
<b>H</b>	BXM10	Kontinuierlich	120 - 350	0.05 - 0.20	0.05 - 0.20
	BXA20	Kontinuierlich	70 - 180	0.05 - 0.20	0.05 - 0.20
		Leicht unterbrochen	70 - 180	0.05 - 0.20	0.05 - 0.20

## PRAKTISCHE BEISPIELE

Werkstück		Kegelradgetriebe	Zahnrad
Wendeschneidplatte		2QP-CNGM120408-HP	2QP-CNGM120408WL-HP
Schneidstoff		BXA20	BXA20
Werkstoff		18CrMo4 (HRC58)	18CrMo4 (HRC58)
			
Schnittbedingungen	Schnittgeschwindigkeit: Vc (m/min)	160	150
	Vorschub : f (mm/U)	0.10	0.12
	Schnitttiefe : ap (mm)	0.15	0.18
	Kühlung	Emulsion	ohne
Resultat			

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