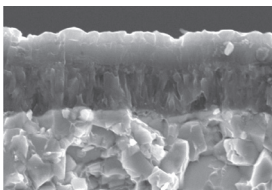
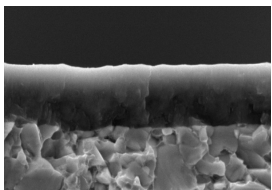
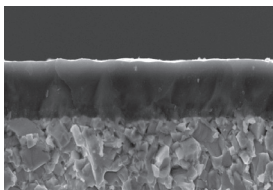
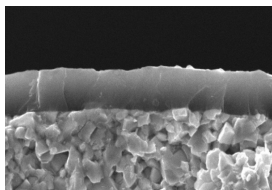
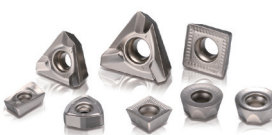


Nova generacija rezalnih plošč KORLOY UN(P)C – vrhunska obdelava zlitin HRSA (UNC805 / UNC840 / **UPC810** / **UPC845**)

• Vrhunska kakovosti za obdelavo HRSA, vključno z Inconelom, Hastelloyem, titanovo zlitino itd.

Podrobne informacije

1

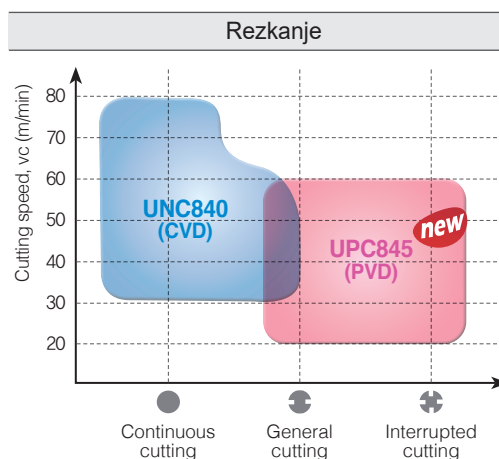
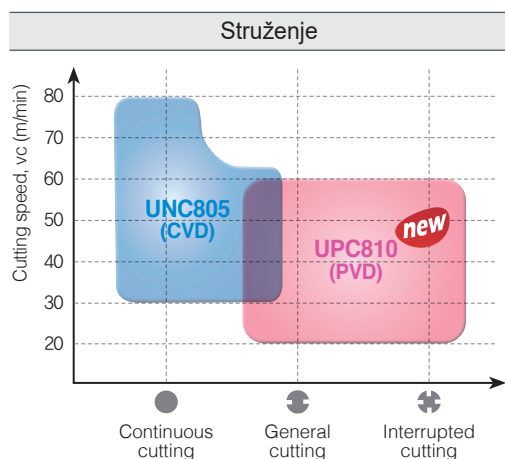
UNC805 (CVD Struženje)	UN840 (CVD Rezkanje)	UPC810 (PVD Struženje) new	UPC845 (PVD rezkanje) new
			
			
- Dobra zmogljivost pri visokohitrostni obdelavi - Za visokohitrostno obdelavo z nizkim pomikom - Za kovane obdelovance - Za visoko trdoto (HRC35 ali več) HRSA - Za velike obdelovance (Ø200 ali več)		- Dobra zmogljivost pri obdelavi z nizko hitrostjo in visokim podajanjem - Za visoko prekinjeno rezanje - Za obdelavo litega in okroglega materiala - Za nizko trdoto (pod HRC35) HRSA - Za obdelavo (pod Ø200)	

2

- * Izboljšana podlaga za zmanjšanje odpornosti proti termičnim razpokam pri visokih temperaturah in preprečevanje nepričakovanih poškodb orodja.
- * Večji volumen odstranjevanja odrezkov zahvaljujoč tehnologiji Ultra coating z visoko trdoto in mazivnostjo.
- * Zmanjšanje nabiranja ostrih robov zaradi optimiziranega rezalnega roba vložka.

3

Področje uporabe



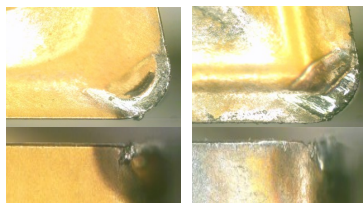
Primerjava (Struženje)

Grade	KORLOY	SANDVIK	TaeguTec	Kyocera	Kenametal	SECO
S05	UNC805	S05F	TT3005 TT05C	CA6515	KCM15	TH1500
S10	UPC810 ^{new}	GC1105	TT5080 TT3010	PR1115	KC5010	TH1000

Primeri (Struženje)

UNC805

- **Workpiece** 9723 (ISO), Inconel718 (AISI), IN718 (KS)
- **Cutting conditions** vc (m/min) = 60, fn (mm/rev) = 0.15, ap (mm) = 0.4, wet
- **Cutting pass** After 15 minutes of machining, both the rake surface and major cutting edge of insert showed no excessive wear
- **Tools** **Insert** CNMG120408-VP4
Holder PCLNR2525-M12N

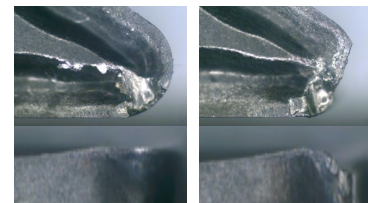


[UNC805]

[Conventional grade]

UPC810

- **Workpiece** 5832-11 (ISO), Ti-6Al-4V (AISI), Ti-6Al-4V (KS)
- **Cutting conditions** vc (m/min) = 60, fn (mm/rev) = 0.35, ap (mm) = 0.4, wet
- **Cutting pass** After 15 minutes of machining, both the rake surface and major cutting edge of insert showed no excessive wear
- **Tools** **Insert** VBGT160408-MU
Holder SVJML2525-M16



[UPC810]

[Conventional grade]

Priporočeni pogoji rezanja (struženje)

Application		Grade	Chip breaker		Recommended cutting conditions					
					Inconel			Titanium alloy		
					vc (m/min)	fn (mm/rev)	ap (mm)	vc (m/min)	fn (mm/rev)	ap (mm)
Finishing	High speed machining	UNC805	General use (1st recommendation)	VP2	30-60	0.10-0.20	≤ 1.0	40-80	0.10-0.20	≤ 1.0
			Good chip control	LU						
			Good toughness	MU						
	High feed machining	UPC810	General use (1st recommendation)	VP2	20-50	0.10-0.30	≤ 1.0	30-60	0.10-0.30	≤ 1.0
			Good chip control	LU						
			Good toughness	MU						
Medium cutting	High speed machining	UNC805	General use (1st recommendation)	MM	30-60	0.10-0.25	≤ 1.5	40-80	0.10-0.25	≤ 1.5
			Good chip control	LU						
			Good toughness	MU						
	High feed machining	UPC810	General use (1st recommendation)	VP3	20-50	0.10-0.30	≤ 1.5	30-60	0.10-0.30	≤ 1.5
			Good chip control	LU						
			Good toughness	MU						
Roughing	High speed machining	UNC805	General use (1st recommendation)	VP4	30-60	0.15-0.30	≤ 3.0	40-80	0.15-0.30	≤ 3.0
			Good chip control	LU						
			Good toughness	MU						
	High feed machining	UPC810	General use (1st recommendation)	VP4	20-50	0.10-0.40	≤ 3.0	30-60	0.10-0.40	≤ 3.0
			Good chip control	LU						
			Good toughness	MU						

Primerjava (Režkanje)

Grade	KORLOY	SANDVIK	TaeguTec	Kyocera	MMC	CERATIZIT	ISCAR	Walter
S40	UNC840	S40T	TT9540	CA6535	US735	CTC5235 CTC5240	IC928 IC830	WSM25S WSM30S WSM35S
S45	UPC845 ^{new}	S30T GC1030 GC2040	TT3540	PR1535	VP15TF MP9130	-	IC830	WSM45S

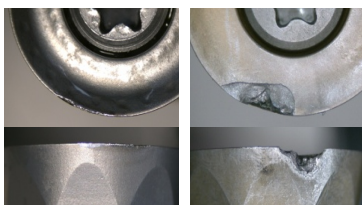
Primeri (Režkanje)

UNC840

- **Workpiece** 9723 (ISO), Inconel718 (AISI), IN718 (KS)
- **Cutting conditions** vc (m/min) = 40, fz (mm/t) = 0.35, ap (mm) = 1.5 -1.8, wet
- **Cutting pass** After 20 minutes of machining, both the rake surface and major cutting edge of insert showed no excessive wear
- **Tools** **Insert** RPMT12040M0E-ML4
Holder FMRCM4055RP-4



[UNC840]



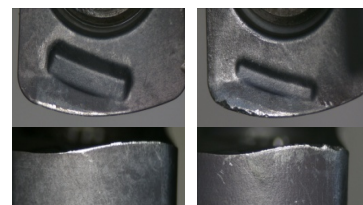
[Conventional grade]

UPC845

- **Workpiece** 5832-11 (ISO), Ti-6Al-4V (AISI), Ti-6Al-4V (KS)
- **Cutting conditions** vc (m/min) = 40, fz (mm/t) = 0.7, ap (mm) = 0.5, wet
- **Cutting pass** After 30 minutes of machining, both the rake surface and major cutting edge of insert showed no excessive wear
- **Tools** **Insert** LNMX060310R-ML
Holder HFMDS032R-5C32-200-LN06



[UPC845]



[Conventional grade]

Priporočeni pogoji rezanja (Režkanje)

Application		Grade	Chip breaker		Recommended cutting conditions							
					Inconel				Titanium alloy			
					vc (m/min)	fz (mm/t)	ap (mm)	ae (mm)	vc (m/min)	fz (mm/t)	ap (mm)	ae (mm)
FMR P-positive	High speed machining	UNC840	For general cutting (KA*)	ML	30 - 50	0.4 - 0.5	≤ 2.0	0.7D - 0.1D	30 - 80	0.4 - 0.8	≤ 2.0	0.7D - 0.1D
			For general cutting (MU*)	ML2								
			Rough	ML3								
			Finishing	ML4								
			Heavy interrupted cutting, Low depths of cut	MF								
			Heavy interrupted cutting, High depths of cut	MM								
FMR P-positive	High feed machining	UPC845	For general cutting (KA*)	ML	20 - 40	0.4 - 0.6	≤ 3.0	0.7D - 0.1D	20 - 60	0.4 - 1.0	≤ 3.0	0.7D - 0.1D
			For general cutting (MU*)	ML2								
			Rough	ML3								
			Finishing	ML4								
			Heavy interrupted cutting, Low depths of cut	MF								
			Heavy interrupted cutting, High depths of cut	MM								
HFM / HFMD	High speed machining	UNC840	Finishing - Medium	ML	30 - 50	0.6 - 1.0	≤ 1.0	0.7D - 0.1D	30 - 80	0.6 - 1.0	≤ 1.0	0.7D - 0.1D
			Medium - Rough	MF								
	High feed machining	UPC845	Finishing - Medium	ML	20 - 40	0.6 - 1.2	≤ 1.0	0.7D - 0.1D	20 - 60	0.6 - 1.2	≤ 1.0	0.7D - 0.1D
			Medium - Rough	MF								
APMT / ADKT	High speed machining	UNC840	Finishing - Medium	ML	30 - 50	0.05 - 0.2	≤ 9.0	≤ 0.3D	30 - 80	0.05 - 0.2	≤ 9.0	≤ 0.3D
			Medium - Rough	MF								
	High feed machining	UPC845	Finishing - Medium	ML	20 - 40	0.07 - 0.3	≤ 9.0	≤ 0.3D	20 - 60	0.07 - 0.3	≤ 9.0	≤ 0.3D
			Medium - Rough	MF								

※ KA Grade : Grinding / MU Grade : Non-Grinding

Ploščice na zalogi (struženje)

Designation		Grade	
		UNC805	UPC810
CNMG	120408-MM	●	●
	120412-MM	●	●
	120408-VP2	●	●
	120408-VP3		●
	120412-VP3	●	●
	120408-VP4	●	●
	120412-VP4	●	●
DNMG	150604-MM	●	●
	150608-MM	●	●
	150604-VP2	●	
	150608-VP2	●	
	150604-VP3	●	●
	150608-VP3		●
	150608-VP4	●	●
SNMG	120408-MM	●	●
	120412-MM	●	●
	120408-VP3		●
	120412-VP3		●
	120408-VP4	●	●
	120412-VP4	●	●

Designation		Grade	
		UNC805	UPC810
VBGT	160404-MU	●	●
	160408-MU	●	●
	160412-MU	●	●
VBMT	160404-LU	●	●
	160408-LU	●	●
	160412-LU	●	●
	160404-MP	●	●
	160408-MP	●	●
	160412-MP	●	●
VNMG	160404-VP3		●
	160408-VP3		●
WNMG	80408-MM	●	●
	80412-MM	●	●
	80408-VP2	●	
	80412-VP2	●	
	80408-VP3		●
	80412-VP3		●
	80408-VP4	●	●
	80412-VP4	●	●

Ploščice na zalogi (rezkanje)

Designation		Grade	
		UNC840	UPC845
ADKT	170608PESR-ML	●	●
	170608PESR-MM	●	●
APMT	11T308PDER-ML	●	●
	11T3PDER-ML	●	●
LNMX	060310R-MF	●	●
	060310R-ML	●	●
RPET	10T3M0E-ML	●	●
	1606M0E-ML		●
RPMT	10T3M0E-MF	●	●
	1204M0E-MF	●	●
	1204M0E-ML2	●	●
	1204M0E-ML3	●	●

Designation		Grade	
		UNC840	UPC845
RPMT	1204M0E-ML4	●	●
	1204M0S-MM	●	●
	1606M0E-MF	●	●
	1606M0E-ML1	●	●
	1606M0E-ML2		●
	1606M0S-MM		●
	2007M0E-MF		●
	2007M0S-MM		●
WNGX	040308PNER-ML	●	●
	080608PNER-ML	●	●
WNMX	09T316ZNN-ML	●	●
	130520ZNN-ML	●	●