



Jongen Werkzeugtechnik GmbH & Co, KG

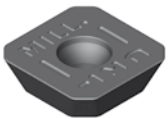
FP 141 CT10

For our face milling cutters, type 140, we have introduced now also an insert with Cermet-coating, named FP 141 CT10.

This type is preferably to apply for finishing steels, high grade steels and GGG + GG materials, whereas by further improvement of Cermet-cutting materials, roughing operations may be conditionally possible. In the last case stable working conditions are of utmost importance.

This quality is exclusively suitable for dry milling.

Technical Data

| | | | |
|---|-------------|---------------|---|
|  | FP 141 CT10 | 16,30 €/piece | Measures: 14,3x14,3x4,0, Insert seat: A13 Precision ground insert, chamfered and rounded cutting edge, reinforced cutting edge, supporting and cutting surfaces ground Packing units: 10 pcs. |
|---|-------------|---------------|---|

Cutting Data Recommendations

| Material | Hardness | Cutting speed V _c [m/min.] |
|--|-------------------------|---------------------------------------|
| structural steel, unalloyed steel | < 180 HB | 500 (300 - 600) |
| tool steel, heat-treatable steel, alloyed steel | 180 - 350 HB | 450 (300 - 600) |
| stainless-steel, high grade steel, high alloyed steel, | < 270 HB | 300 (200 - 400) |
| grey cast iron | < 800 N/mm ² | 500 (400 - 600) |
| globular graphite cast iron | < 350 N/mm ² | 550 (400 - 600) |

The above mentioned data are standard values.

Up and down corrections are admitted depending on the machine type, tool and holding fixture.

It is recommended to choose between 0,1- 0,3 mm of feed rate per tooth, depending on the quality of surface finish.

During internal tests a surface finish of R_z 1,66- 1,99µm (R_a 0,2-0,3µm) has been achieved, with feed rates per tooth between 0,1- 0,3 mm and a cutting speed of 500 m/min.