
















## B27 Fräswendepplatten und Schnittdaten

Milling inserts and parameters, Plaquettes de fraisage et paramètres, Inserti e parametri di taglio

			HC45 (code 41)	HT32 (code 33)	HC35 (code 50)	XC35 (code 46)	HT20 (code 32)	K15M (code 8)	
	<b>JMB27-T09PR08-</b> IK 9,52x4,62 R0,8 + Fase*	Order- No.	<b>B27A-BT41</b>	<b>B27A-YP33</b>			<b>B27A-JX32</b>		
	 	$f_z$ [mm]	0,15 (0,10-0,30)	0,20 (0,15-0,30)			0,20 (0,15-0,30)		
	<b>JMB27-T09GR08-</b> IK 9,52x4,62 R0,8	Order- No.	<b>B27B-OU41</b>		<b>B27B-UY50</b>	<b>B27B-UA46</b>	<b>B27B-PY32</b>		
	 	$f_z$ [mm]	0,15 (0,10-0,30)		0,15 (0,10-0,30)	0,15 (0,10-0,30)	0,20 (0,15-0,30)		
	<b>JMB27-T09GR02-</b> IK 9,52x4,62 R0,2	Order- No.						<b>B27B-XT08</b>	
	 	$f_z$ [mm]						0,20 (0,15-0,25)	
			20	20	20	20	20	20	
									
	<b>JMB27-T09S-</b> IK 9,52x4,62	Order- No.					<b>B27B-OZ32</b>		
	 	$f_n$ [mm/U]					2,00 (1,00-5,00)		
							10		

\* Fase, chamfer, avec chanfrein, smusso

$v_c$ [m/min]	Stahl Steel Acier Acciaio	Rostfrei Stainless Acier inoxydable Inossidabile	Guss Cast iron Fonte Ghisa	NE-Metalle Non-ferrous metals Non ferreux Metalli non ferrosi	Hochwarmfest Highly heat-resistant Superalliages Resistente al calore	Gehärtet Tempered Aciers traités Temprato
<b>HC45</b>	250 (200 - 350)	240 (140 - 300)	240 (130 - 280)			
<b>HT32</b>	250 (200 - 350)	240 (140 - 300)			60 (40 - 200)	
<b>HC35</b>	220 (200 - 350)	160 (100 - 300)			60 (40 - 200)	
<b>XC35</b>	120 (60 - 160)	100 (60 - 180)			80 (40 - 200)	
<b>HT20</b>			260 (180 - 350)			80 (40 - 120)
<b>K15M</b>				400 (300 - 600)		

Ersatzteile Spare parts, Pièces de rechange, Parti di ricambio

	<b>SS 4,0-10</b> (M = 3,2-3,3 Nm)		<b>T 15+</b>		<b>Fett</b> Grease, Graisse, Grasso
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## **B27 Montageanleitung Breitschichtplatte** *Assembly instruction wiper insert,* *Instruction de montage de la plaque racleuse, Istruzioni per il montaggio dell'inserto raschiante*

