

Nuance Cermet revêtu PVD pour acier

MP3025

Pour d'excellents états de surface.

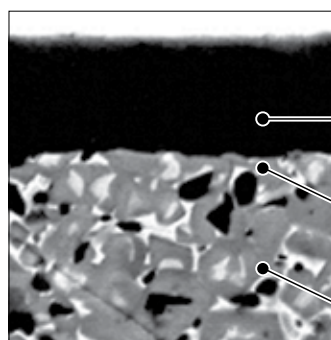


Nuance Cermet revêtue PVD pour acier

MP3025

La nuance MP3025 se distingue par son excellente résistance à l'usure en dépouille et à la rupture.

Grâce à l'amélioration de la force d'adhésion de la surface lisse du substrat, la nuance MP3025 donne d'excellents états de surface et convient donc parfaitement à la production de masse de petites pièces.



Le revêtement PVD composé de titane offre une excellente résistance à l'usure et au collage.

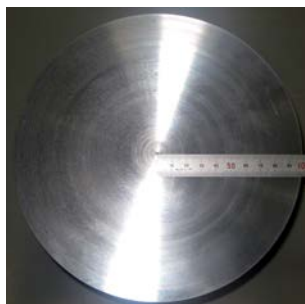
La surface du substrat confère d'excellentes propriétés adhésives à la couche du revêtement.

Résistance supérieure du substrat à la rupture et aux chocs thermiques.

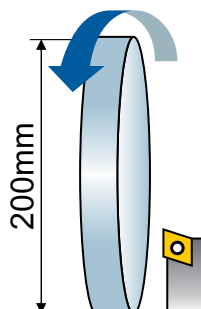
Finitions de haute qualité à vitesses lentes.

MP3025 procure un meilleur état de surface à vitesses lentes que les nuances Cermet PVD de nos concurrents.

MP3025



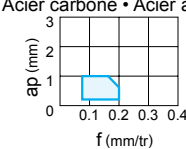
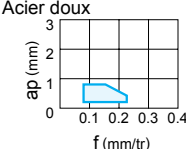
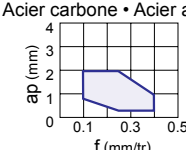
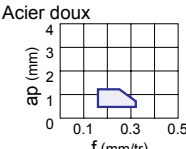
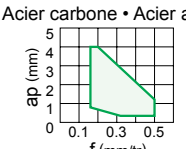
Conventionnel



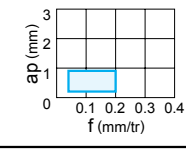
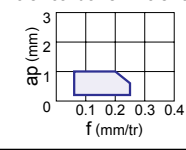
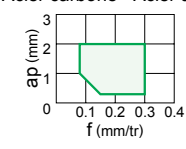
<Condition de coupe>

Pièce à usiner : XC25
Rotation : $n=398$ tr/min.
(Extérieur : $vc=250$ m/min.)
Profondeur de coupe : $ap=1,5$ mm
Avance : $f=0,15$ mm/tour
Coupe lubrifiée

Système de brise-copeaux pour l'usinage de l'acier (plaquettes négatives)

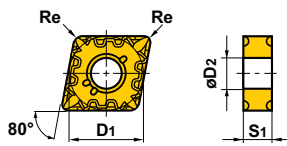
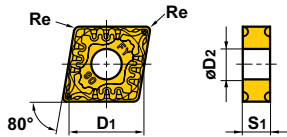
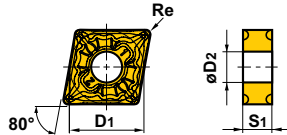
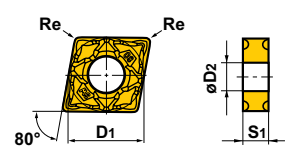
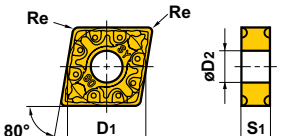
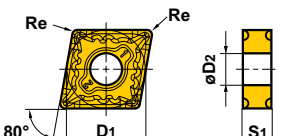
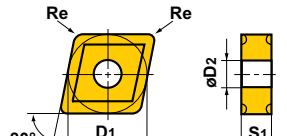
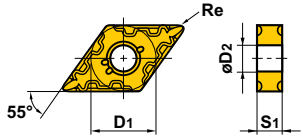
Application	Tolérance	Brise-copeaux	Caractéristiques	Section Géométrie
Usinage en finition	M	FH 	Premier choix pour la finition d'acier carbone, d'acier allié et d'acier inoxydable Brise-copeaux double face. Stabilité de contrôle des copeaux, même à de faibles profondeurs de coupe.	Acier carbone • Acier allié  Pointe 12° Flancs 12°
	M	FY 	Premier choix pour la finition d'acier doux Brise-copeaux double face. Protège efficacement contre le collage des copeaux. Convient à la finition d'acier doux.	Acier doux  Pointe 15° Flancs 15°
Semi-finition	M	LP 	Premier choix pour la semi-finition de l'acier carbone et de l'acier allié Contrôle stable des copeaux dans la gamme de semi-finition. L'arête incurvée permet une évacuation homogène des copeaux.	Acier carbone • Acier allié  Pointe 15° Flancs 11°
	M	SY 	Premier choix pour la semi-finition de l'acier carbone Brise-copeaux double face. Protège efficacement contre le collage des copeaux. Convient à la semi-finition.	Acier doux  Pointe 10° Flancs 10°
Ébauche moyenne	M	MP 	Premier choix pour l'ébauche moyenne de l'acier carbone et de l'acier allié Convient pour l'ébauche moyenne à la semi-finition. Géométrie du brise-copeaux adaptée au copiage et au chariotage en tirant. Géométrie de coupe pour un équilibre optimal entre acuité et résistance à la rupture.	Acier carbone • Acier allié  Pointe 15° Flancs 11°

Système de brise-copeaux pour l'usinage d'acier (plaquettes positives)

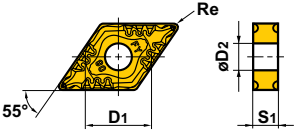
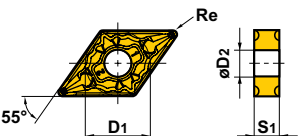
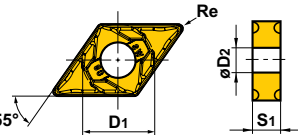
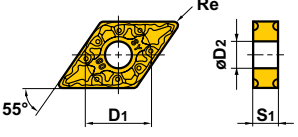
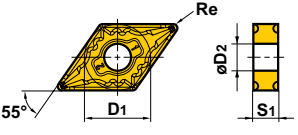
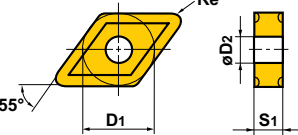
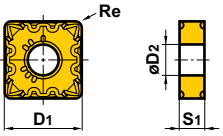
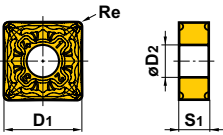
Application	Tolérance	Brise-copeaux	Caractéristiques	Section Géométrie
Usinage en finition	M	NEW FP 	Premier choix pour la finition de l'acier carbone et de l'acier allié La protubérance à la pointe du brise-copeaux contrôle les copeaux, même avec de petites profondeurs de passe. La robustesse du rayon est maintenue pour éviter toute rupture anormale. 5° 7° Plaquette positive	Acier carbone • Acier allié  Pointe 6° Flancs 6°
Semi-finition	M	NEW LP 	Premier choix pour la semi-finition de l'acier carbone et de l'acier allié Excellente acuité de l'arête de coupe grâce au grand angle de coupe. Empêche le collage des copeaux, afin de garantir d'excellents états de surface. Le brise-copeaux optimisé permet un excellent contrôle des copeaux. 5° 7° Plaquette positive	Acier carbone • Acier allié  Pointe 18° Flancs 8°
Ébauche moyenne	M	NEW MP 	Premier choix pour l'ébauche moyenne de l'acier carbone et de l'acier allié La zone plate produit une excellente résistance à l'usure et une résistance supérieure à la rupture. La large poche réduit la vibration et le bourrage des copeaux et empêche l'augmentation de la résistance de coupe, même à grande profondeur. 5° 7° Plaquette positive	Acier carbone • Acier allié  Pointe 18° Flancs 18°

PLAQUETTES

● Plaquettes négatives (à trou)

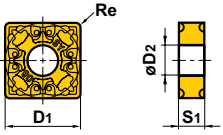
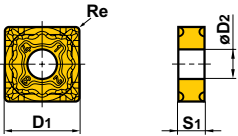
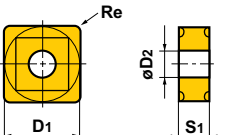
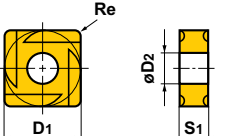
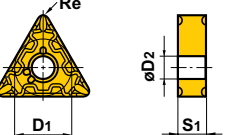
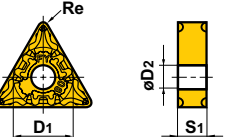
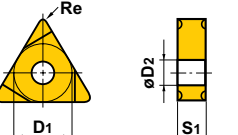
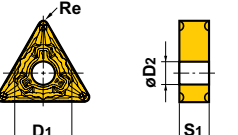
Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
FH  Usinage en finition	CNMG120402-FH	M	●	12.7	4.76	0.2	5.16	
	120404-FH	M	●	12.7	4.76	0.4	5.16	
	120408-FH	M	●	12.7	4.76	0.8	5.16	
FY  Usinage de finition	CNMG120404-FY	M	●	12.7	4.76	0.4	5.16	
	120408-FY	M	●	12.7	4.76	0.8	5.16	
LP  Semi-finition	CNMG120404-LP	M	●	12.7	4.76	0.4	5.16	
	120408-LP	M	●	12.7	4.76	0.8	5.16	
SW  Semi-finition (Planage)	CNMG120404-SW	M	●	12.7	4.76	0.4	5.16	
	120408-SW	M	●	12.7	4.76	0.8	5.16	
	120412-SW	M	●	12.7	4.76	1.2	5.16	
SY  Semi-finition	CNMG120404-SY	M	●	12.7	4.76	0.4	5.16	
	120408-SY	M	●	12.7	4.76	0.8	5.16	
MP  Ébauche moyenne	CNMG120404-MP	M	●	12.7	4.76	0.4	5.16	
	120408-MP	M	●	12.7	4.76	0.8	5.16	
	120412-MP	M	●	12.7	4.76	1.2	5.16	
Standard  Ébauche moyenne	CNMG120404	M	●	12.7	4.76	0.4	5.16	
	120408	M	●	12.7	4.76	0.8	5.16	
FH  Usinage de finition	DNMG150402-FH	M	●	12.7	4.76	0.2	5.16	
	150404-FH	M	●	12.7	4.76	0.4	5.16	
	150408-FH	M	●	12.7	4.76	0.8	5.16	
	150602-FH	M	●	12.7	6.35	0.2	5.16	
	150604-FH	M	●	12.7	6.35	0.4	5.16	
	150608-FH	M	●	12.7	6.35	0.8	5.16	

● : Article stocké.

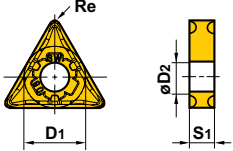
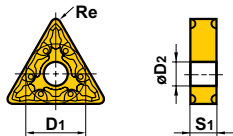
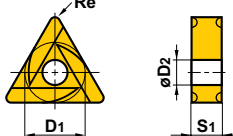
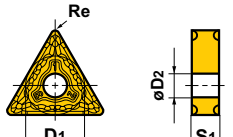
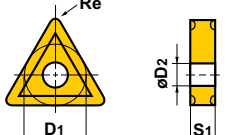
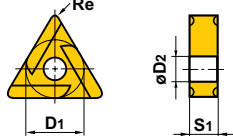
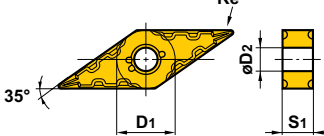
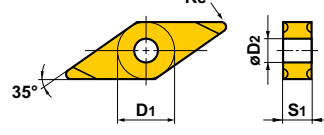
Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
FY  Usinage en finition	DNMG150404-FY	M	●	12.7	4.76	0.4	5.16	
	150408-FY	M	●	12.7	4.76	0.8	5.16	
	150604-FY	M	●	12.7	6.35	0.4	5.16	
	150608-FY	M	●	12.7	6.35	0.8	5.16	
LP  Semi-finition	NEW DNMG110404-LP	M	●	9.525	4.76	0.4	3.81	
	NEW 110408-LP	M	●	9.525	4.76	0.8	3.81	
	150404-LP	M	●	12.7	4.76	0.4	5.16	
	150408-LP	M	●	12.7	4.76	0.8	5.16	
	NEW 150412-LP	M	●	12.7	4.76	1.2	5.16	
	150604-LP	M	●	12.7	6.35	0.4	5.16	
	150608-LP	M	●	12.7	6.35	0.8	5.16	
SW  Semi-finition (Planage)	DNMX150404-SW	M	●	12.7	4.76	0.4	5.16	
	150408-SW	M	●	12.7	4.76	0.8	5.16	
	150604-SW	M	●	12.7	6.35	0.4	5.16	
	150608-SW	M	●	12.7	6.35	0.8	5.16	
SY  Semi-finition	DNMG150404-SY	M	●	12.7	4.76	0.4	5.16	
	150408-SY	M	●	12.7	4.76	0.8	5.16	
	150604-SY	M	●	12.7	6.35	0.4	5.16	
	150608-SY	M	●	12.7	6.35	0.8	5.16	
MP  Ébauche moyenne	DNMG150404-MP	M	●	12.7	4.76	0.4	5.16	
	150408-MP	M	●	12.7	4.76	0.8	5.16	
	150412-MP	M	●	12.7	4.76	1.2	5.16	
	150604-MP	M	●	12.7	6.35	0.4	5.16	
	150608-MP	M	●	12.7	6.35	0.8	5.16	
	150612-MP	M	●	12.7	6.35	1.2	5.16	
Standard  Ébauche moyenne	DNMG150404	M	●	12.7	4.76	0.4	5.16	
	150408	M	●	12.7	4.76	0.8	5.16	
	150604	M	●	12.7	6.35	0.4	5.16	
	150608	M	●	12.7	6.35	0.8	5.16	
FH  Usinage de finition	SNMG120404-FH	M	●	12.7	4.76	0.4	5.16	
	120408-FH	M	●	12.7	4.76	0.8	5.16	
LP  Semi-finition	SNMG120404-LP	M	●	12.7	4.76	0.4	5.16	
	120408-LP	M	●	12.7	4.76	0.8	5.16	

PLAQUETTES

● Plaquettes négatives (à trou)

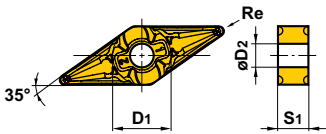
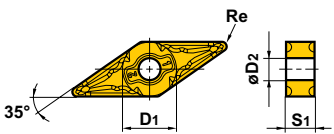
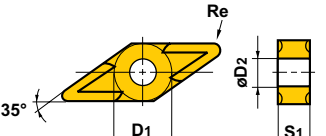
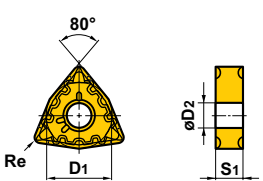
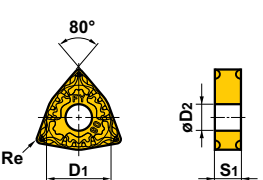
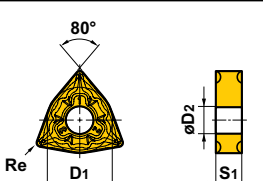
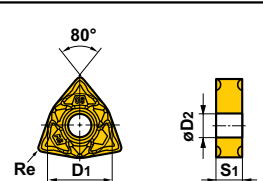
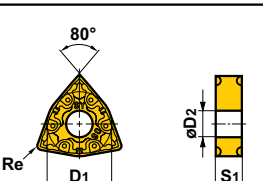
Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
SY  Semi-finition	SNMG120408-SY	M	●	12.7	4.76	0.8	5.16	
MP  Ébauche moyenne	SNMG120404-MP	M	●	12.7	4.76	0.4	5.16	
	120408-MP	M	●	12.7	4.76	0.8	5.16	
	120412-MP	M	●	12.7	4.76	1.2	5.16	
Standard  Ébauche moyenne	SNMG090304	M	●	9.525	3.18	0.4	3.81	
	090308	M	●	9.525	3.18	0.8	3.81	
	120404	M	●	12.7	4.76	0.4	5.16	
	120408	M	●	12.7	4.76	0.8	5.16	
R/L  Ébauche moyenne	SNGG120404R	G	●	12.7	4.76	0.4	5.16	
	120408R	G	●	12.7	4.76	0.8	5.16	
	120404L	G	●	12.7	4.76	0.4	5.16	
	120408L	G	●	12.7	4.76	0.8	5.16	
FH  Usinage de finition	TNMG160402-FH	M	●	9.525	4.76	0.2	3.81	
	160404-FH	M	●	9.525	4.76	0.4	3.81	
	160408-FH	M	●	9.525	4.76	0.8	3.81	
FY  Usinage de finition	TNMG160404-FY	M	●	9.525	4.76	0.4	3.81	
	160408-FY	M	●	9.525	4.76	0.8	3.81	
R/L-F  Usinage de finition	TNGG160402R-F	G	●	9.525	4.76	0.2	3.81	
	160404R-F	G	●	9.525	4.76	0.4	3.81	
	160408R-F	G	●	9.525	4.76	0.8	3.81	
	160402L-F	G	●	9.525	4.76	0.2	3.81	
	160404L-F	G	●	9.525	4.76	0.4	3.81	
	160408L-F	G	●	9.525	4.76	0.8	3.81	
LP  Semi-finition	TNMG160404-LP	M	●	9.525	4.76	0.4	3.81	
	160408-LP	M	●	9.525	4.76	0.8	3.81	
	 160412-LP	M	●	9.525	4.76	1.2	3.81	
	 220408-LP	M	●	12.7	4.76	0.8	5.16	

● : Article stocké.

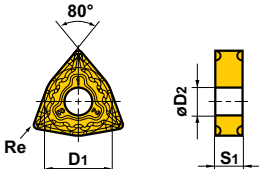
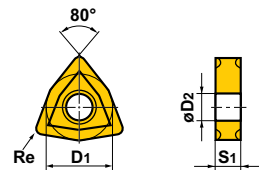
Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
SW  Semi-finition (Planage)	TNMX160404-SW	M	●	9.525	4.76	0.4	3.81	
	160408-SW	M	●	9.525	4.76	0.8	3.81	
SY  Semi-finition	TNMG160404-SY	M	●	9.525	4.76	0.4	3.81	
	160408-SY	M	●	9.525	4.76	0.8	3.81	
R/L-K  Semi-finition	TNGG160402R-K	G	●	9.525	4.76	0.2	3.81	
	160404R-K	G	●	9.525	4.76	0.4	3.81	
	160408R-K	G	●	9.525	4.76	0.8	3.81	
	160402L-K	G	●	9.525	4.76	0.2	3.81	
	160404L-K	G	●	9.525	4.76	0.4	3.81	
	160408L-K	G	●	9.525	4.76	0.8	3.81	
MP  Ébauche moyenne	TNMG160404-MP	M	●	9.525	4.76	0.4	3.81	
	160408-MP	M	●	9.525	4.76	0.8	3.81	
	160412-MP	M	●	9.525	4.76	1.2	3.81	
Standard  Ébauche moyenne	TNMG160404	M	●	9.525	4.76	0.4	3.81	
	160408	M	●	9.525	4.76	0.8	3.81	
R/L  Ébauche moyenne	TNGG160402R	G	●	9.525	4.76	0.2	3.81	
	160404R	G	●	9.525	4.76	0.4	3.81	
	160408R	G	●	9.525	4.76	0.8	3.81	
	160402L	G	●	9.525	4.76	0.2	3.81	
	160404L	G	●	9.525	4.76	0.4	3.81	
	160408L	G	●	9.525	4.76	0.8	3.81	
FH  Usinage de finition	VNMG160402-FH	M	●	9.525	4.76	0.2	3.81	
	160404-FH	M	●	9.525	4.76	0.4	3.81	
	160408-FH	M	●	9.525	4.76	0.8	3.81	
R/L-F  Usinage de finition	VNGG160402R-F	G	●	9.525	4.76	0.2	3.81	
	160404R-F	G	●	9.525	4.76	0.4	3.81	
	160402L-F	G	●	9.525	4.76	0.2	3.81	
	160404L-F	G	●	9.525	4.76	0.4	3.81	

PLAQUETTES

● Plaquettes négatives (à trou)

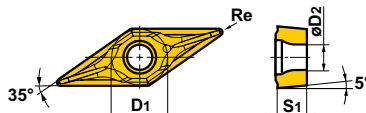
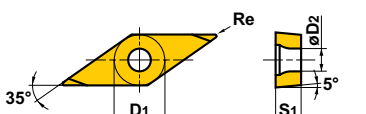
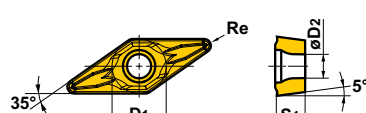
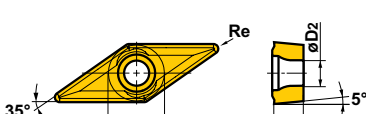
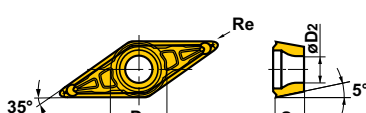
Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
LP  Semi-finition	VNMG160404-LP	M	●	9.525	4.76	0.4	3.81	
	160408-LP	M	●	9.525	4.76	0.8	3.81	
MP  Ébauche moyenne	VNMG160404-MP	M	●	9.525	4.76	0.4	3.81	
	160408-MP	M	●	9.525	4.76	0.8	3.81	
Standard  Ébauche moyenne	VNMG160404	M	●	9.525	4.76	0.4	3.81	
	160408	M	●	9.525	4.76	0.8	3.81	
FH  Usinage de finition	WNMG080404-FH	M	●	12.7	4.76	0.4	5.16	
	080408-FH	M	●	12.7	4.76	0.8	5.16	
FY  Usinage de finition	WNMG080404-FY	M	●	12.7	4.76	0.4	5.16	
	080408-FY	M	●	12.7	4.76	0.8	5.16	
LP  Semi-finition	NEW WNMG06T304-LP	M	●	9.525	3.97	0.4	3.81	
	NEW 06T308-LP	M	●	9.525	3.97	0.8	3.81	
	080404-LP	M	●	12.7	4.76	0.4	5.16	
	080408-LP	M	●	12.7	4.76	0.8	5.16	
SW  Semi-finition (Planage)	WNMG060404-SW	M	●	9.525	4.76	0.4	3.81	
	060408-SW	M	●	9.525	4.76	0.8	3.81	
	080404-SW	M	●	12.7	4.76	0.4	5.16	
	080408-SW	M	●	12.7	4.76	0.8	5.16	
	080412-SW	M	●	12.7	4.76	1.2	5.16	
SY  Semi-finition	WNMG080404-SY	M	●	12.7	4.76	0.4	5.16	
	080408-SY	M	●	12.7	4.76	0.8	5.16	

● : Article stocké.

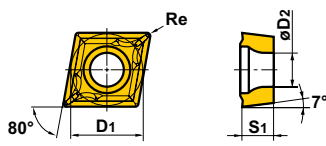
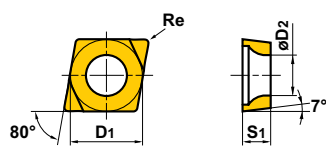
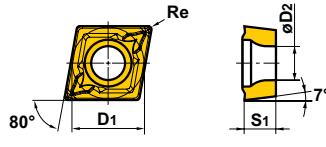
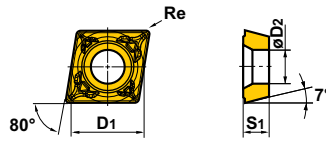
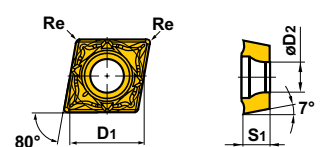
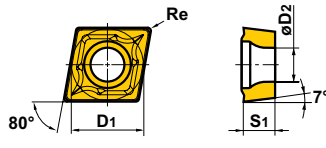
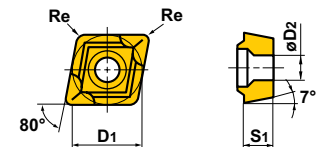
Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
MP  Ébauche moyenne	WNMG080404-MP	M	●	12.7	4.76	0.4	5.16	
	080408-MP	M	●	12.7	4.76	0.8	5.16	
	080412-MP	M	●	12.7	4.76	1.2	5.16	
Standard  Ébauche moyenne	WNMG080404	M	●	12.7	4.76	0.4	5.16	
	080408	M	●	12.7	4.76	0.8	5.16	

PLAQUETTES

● Plaquettes positives 5° (à trou)

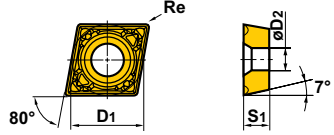
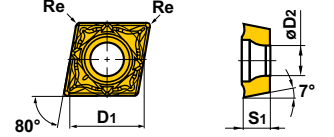
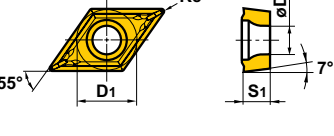
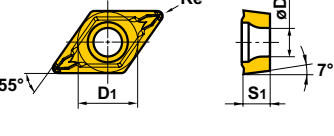
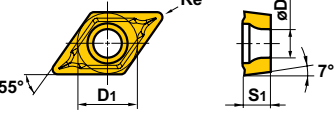
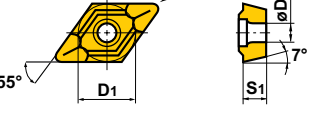
Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
NEW FP 	VBMT110302-FP	M	●	6.35	3.18	0.2	2.9	
	110304-FP	M	●	6.35	3.18	0.4	2.9	
	110308-FP	M	●	6.35	3.18	0.8	2.9	
	160404-FP	M	●	9.525	4.76	0.4	4.4	
	160408-FP	M	●	9.525	4.76	0.8	4.4	
Usinage en finition								
R/L-F 	VBGT110302R-F	G	●	6.35	3.18	0.2	2.85	
	110302L-F	G	●	6.35	3.18	0.2	2.85	
Usinage de finition								
NEW LP 	VBMT110304-LP	M	●	6.35	3.18	0.4	2.9	
	110308-LP	M	●	6.35	3.18	0.8	2.9	
	160404-LP	M	●	9.525	4.76	0.4	4.4	
	160408-LP	M	●	9.525	4.76	0.8	4.4	
Semi-finition								
NEW MP 	VBMT160404-MP	M	●	9.525	4.76	0.4	4.4	
	160408-MP	M	●	9.525	4.76	0.8	4.4	
Ébauche moyenne								
MV 	VBMT110304-MV	M	●	6.35	3.18	0.4	2.85	
	110308-MV	M	●	6.35	3.18	0.8	2.85	
	160404-MV	M	●	9.525	4.76	0.4	4.43	
	160408-MV	M	●	9.525	4.76	0.8	4.43	
Ébauche moyenne								
R/L-F 	WBG020102L-F	G	●	3.97	1.59	0.2	2.3	
	020104L-F	G	●	3.97	1.59	0.4	2.3	
	L30202L-F	G	●	4.76	2.38	0.2	2.3	
	L30204L-F	G	●	4.76	2.38	0.4	2.3	
Usinage de finition								
R/L-MV 	WBMTL30202L-MV	M	●	4.76	2.38	0.2	2.3	
	L30202R-MV	M	●	4.76	2.38	0.2	2.3	
	L30204L-MV	M	●	4.76	2.38	0.4	2.3	
	L30204R-MV	M	●	4.76	2.38	0.4	2.3	
Ébauche moyenne								

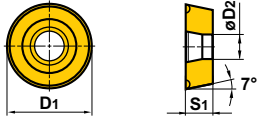
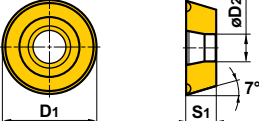
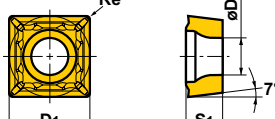
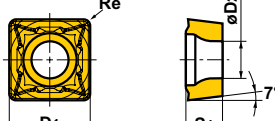
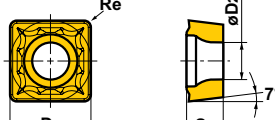
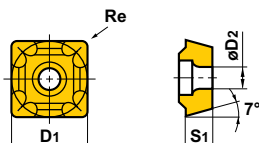
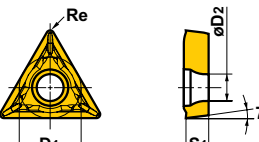
● Plaquettes positives 7° (à trou)

Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
NEW FP 	CCMT060202-FP	M	●	6.35	2.38	0.2	2.8	
	060204-FP	M	●	6.35	2.38	0.4	2.8	
	09T302-FP	M	●	9.525	3.97	0.2	4.4	
	09T304-FP	M	●	9.525	3.97	0.4	4.4	
	09T308-FP	M	●	9.525	3.97	0.8	4.4	
Usinage en finition								
L-F 	CCGT03S102L-F	G	●	3.97	1.39	0.2	2.0	
	03S104L-F	G	●	3.97	1.39	0.4	2.0	
	04T002L-F	G	●	4.76	1.79	0.2	2.4	
	04T004L-F	G	●	4.76	1.79	0.4	2.4	
Usinage de finition								
NEW LP 	CCMT060204-LP	M	●	6.35	2.38	0.4	2.8	
	060208-LP	M	●	6.35	2.38	0.8	2.8	
	09T304-LP	M	●	9.525	3.97	0.4	4.4	
	09T308-LP	M	●	9.525	3.97	0.8	4.4	
Semi-finition								
SV 	CCMH060202-SV	M	●	6.35	2.38	0.2	2.8	
	060204-SV	M	●	6.35	2.38	0.4	2.8	
Semi-finition								
SW 	CCMT060202-SW	M	●	6.35	2.38	0.2	2.8	
	060204-SW	M	●	6.35	2.38	0.4	2.8	
	09T302-SW	M	●	9.525	3.97	0.2	4.4	
	09T304-SW	M	●	9.525	3.97	0.4	4.4	
Semi-finition (Planage)								
NEW MP 	CCMT060204-MP	M	●	6.35	2.38	0.4	2.8	
	060208-MP	M	●	6.35	2.38	0.8	2.8	
	09T304-MP	M	●	9.525	3.97	0.4	4.4	
	09T308-MP	M	●	9.525	3.97	0.8	4.4	
	120404-MP	M	●	12.7	4.76	0.4	5.5	
	120408-MP	M	●	12.7	4.76	0.8	5.5	
	120412-MP		●	12.7	4.76	1.2	5.5	
Ébauche moyenne								
Standard 	CCMT060202	M	●	6.35	2.38	0.2	2.8	
	060204	M	●	6.35	2.38	0.4	2.8	
	080304	M	●	7.94	3.18	0.4	3.4	
	09T302	M	●	9.525	3.97	0.2	4.4	
	09T304	M	●	9.525	3.97	0.4	4.4	
	09T308	M	●	9.525	3.97	0.8	4.4	
	120404	M	●	12.7	4.76	0.4	5.5	
	120408	M	●	12.7	4.76	0.8	5.5	
Ébauche moyenne								

PLAQUETTES

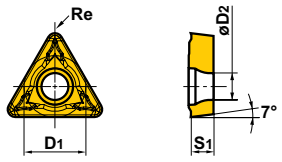
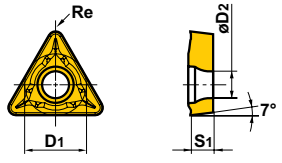
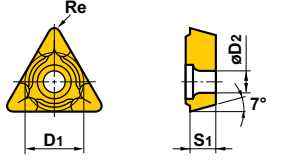
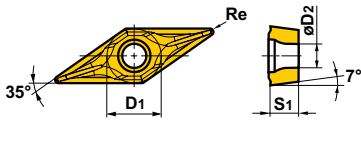
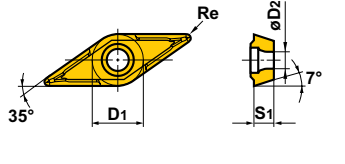
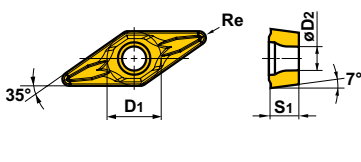
● Plaquettes positives 7° (à trou)

Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
MV 	CCMH060202-MV	M	●	6.35	2.38	0.2	2.8	
	060204-MV	M	●	6.35	2.38	0.4	2.8	
MW  Ébauche moyenne (Planage)	CCMT060204-MW	M	●	6.35	2.38	0.4	2.8	
	060208-MW	M	●	6.35	2.38	0.8	2.8	
	09T304-MW	M	●	9.525	3.97	0.4	4.4	
	09T308-MW	M	●	9.525	3.97	0.8	4.4	
NEW FP  Usinage en finition	DCMT070202-FP	M	●	6.35	2.38	0.2	2.8	
	070204-FP	M	●	6.35	2.38	0.4	2.8	
	11T302-FP	M	●	9.525	3.97	0.2	4.4	
	11T304-FP	M	●	9.525	3.97	0.4	4.4	
	11T308-FP	M	●	9.525	3.97	0.8	4.4	
NEW LP  Semi-finition	DCMT070204-LP	M	●	6.35	2.38	0.4	2.8	
	070208-LP	M	●	6.35	2.38	0.8	2.8	
	11T304-LP	M	●	9.525	3.97	0.4	4.4	
	11T308-LP	M	●	9.525	3.97	0.8	4.4	
NEW MP  Ébauche moyenne	DCMT070204-MP	M	●	6.35	2.38	0.4	2.8	
	070208-MP	M	●	6.35	2.38	0.8	2.8	
	11T304-MP	M	●	9.525	3.97	0.4	4.4	
	11T308-MP	M	●	9.525	3.97	0.8	4.4	
	150404-MP	M	●	12.7	4.76	0.4	5.5	
	150408-MP	M	●	12.7	4.76	0.8	5.5	
Standard  Ébauche moyenne	DCMT070202	M	●	6.35	2.38	0.2	2.8	
	070204	M	●	6.35	2.38	0.4	2.8	
	070208	M	●	6.35	2.38	0.8	2.8	
	11T302	M	●	9.525	3.97	0.2	4.4	
	11T304	M	●	9.525	3.97	0.4	4.4	
	11T308	M	●	9.525	3.97	0.8	4.4	
	150404	M	●	12.7	4.76	0.4	5.5	
	150408	M	●	12.7	4.76	0.8	5.5	
MV  Ébauche moyenne	DCMT070202-MV	M	●	6.35	2.38	0.2	2.8	
	070204-MV	M	●	6.35	2.38	0.4	2.8	
	070208-MV	M	●	6.35	2.38	0.8	2.8	
	11T302-MV	M	●	9.525	3.97	0.2	4.4	
	11T304-MV	M	●	9.525	3.97	0.4	4.4	
	11T308-MV	M	●	9.525	3.97	0.8	4.4	

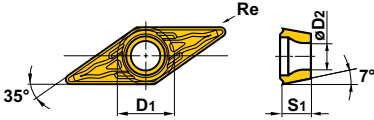
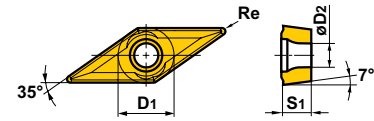
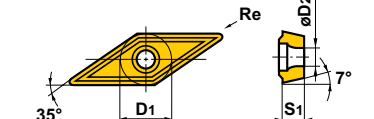
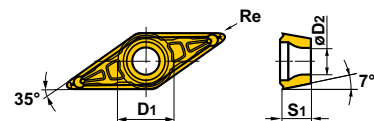
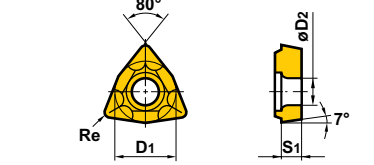
Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
Standard  Ébauche moyenne	RCMT0602M0	M	●	6	2.38	-	2.8	
	0803M0	M	●	8	3.18	-	3.4	
Standard  Ébauche moyenne	RCMX1003M0	M	●	10	3.18	-	3.6	
	1204M0	M	●	12	4.76	-	4.2	
NEW FP  Usinage de finition	SCMT09T304-FP	M	●	9.525	3.97	0.4	4.4	
	09T308-FP	M	●	9.525	3.97	0.8	4.4	
NEW LP  Semi-finition	SCMT09T304-LP	M	●	9.525	3.97	0.4	4.4	
	09T308-LP	M	●	9.525	3.97	0.8	4.4	
NEW MP  Ébauche moyenne	SCMT09T304-MP	M	●	9.525	3.97	0.4	4.4	
	09T308-MP	M	●	9.525	3.97	0.8	4.4	
	120404-MP	M	●	12.7	4.76	0.4	5.5	
	120408-MP	M	●	12.7	4.76	0.8	5.5	
Standard  Ébauche moyenne	SCMT09T304	M	●	9.525	3.97	0.4	4.4	
	09T308	M	●	9.525	3.97	0.8	4.4	
	120404	M	●	12.7	4.76	0.4	5.5	
	120408	M	●	12.7	4.76	0.8	5.5	
NEW FP  Usinage de finition	TCMT090202-FP	M	●	5.56	2.38	0.2	2.5	
	090204-FP	M	●	5.56	2.38	0.4	2.5	
	110202-FP	M	●	6.35	2.38	0.2	2.8	
	110204-FP	M	●	6.35	2.38	0.4	2.8	
	16T304-FP	M	●	9.525	3.97	0.4	4.4	

PLAQUETTES

● Plaquettes positives 7° (à trou)

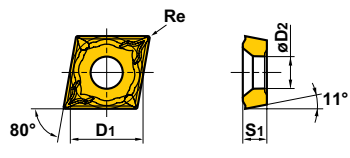
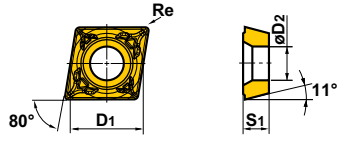
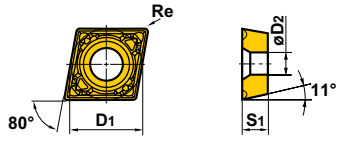
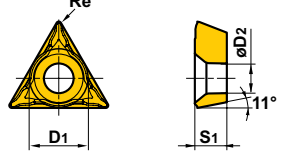
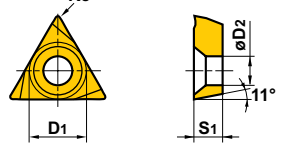
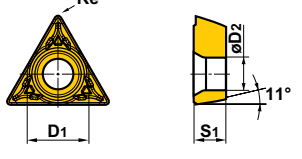
Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
NEW LP  Semi-finition	TCMT090204-LP	M	●	5.56	2.38	0.4	2.5	
	090208-LP	M	●	5.56	2.38	0.8	2.5	
	110204-LP	M	●	6.35	2.38	0.4	2.8	
	110208-LP	M	●	6.35	2.38	0.8	2.8	
	16T304-LP	M	●	9.525	3.97	0.4	4.4	
	16T308-LP	M	●	9.525	3.97	0.8	4.4	
NEW MP  Ébauche moyenne	TCMT090204-MP	M	●	5.56	2.38	0.4	2.5	
	090208-MP	M	●	5.56	2.38	0.8	2.5	
	110204-MP	M	●	6.35	2.38	0.4	2.8	
	110208-MP	M	●	6.35	2.38	0.8	2.8	
	130304-MP	M	●	7.94	3.18	0.4	3.4	
	16T304-MP	M	●	9.525	3.97	0.4	4.4	
	16T308-MP	M	●	9.525	3.97	0.8	4.4	
	16T312-MP	M	●	9.525	3.97	1.2	4.4	
Standard  Ébauche moyenne	TCMT080204	M	●	4.76	2.38	0.4	2.3	
	090204	M	●	5.56	2.38	0.4	2.5	
	110202	M	●	6.35	2.38	0.2	2.8	
	110204	M	●	6.35	2.38	0.4	2.8	
	110208	M	●	6.35	2.38	0.8	2.8	
	130302	M	●	7.94	3.18	0.2	3.4	
	130304	M	●	7.94	3.18	0.4	3.4	
	16T304	M	●	9.525	3.97	0.4	4.4	
	16T308	M	●	9.525	3.97	0.8	4.4	
NEW FP  Usinage de finition	VCMT110302-FP	M	●	6.35	3.18	0.2	2.8	
	110304-FP	M	●	6.35	3.18	0.4	2.8	
	160404-FP	M	●	9.525	4.76	0.4	4.4	
	160408-FP	M	●	9.525	4.76	0.8	4.4	
FV  Usinage de finition	VCMT080202-FV	M	●	4.76	2.38	0.2	2.42	
	080204-FV	M	●	4.76	2.38	0.4	2.42	
NEW LP  Semi-finition	VCMT110304-LP	M	●	6.35	3.18	0.4	2.8	
	110308-LP	M	●	6.35	3.18	0.8	2.8	
	160404-LP	M	●	9.525	4.76	0.4	4.4	
	160408-LP	M	●	9.525	4.76	0.8	4.4	

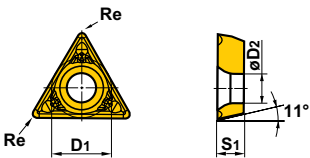
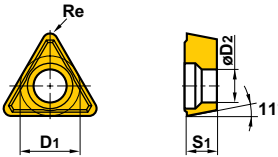
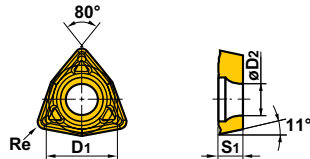
● : Article stocké.

Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
SV  Semi-finition	VCMT080202-SV	M	●	4.76	2.38	0.2	2.42	
	080204-SV	M	●	4.76	2.38	0.4	2.42	
NEW MP  Ébauche moyenne	VCMT160404-MP	M	●	9.525	4.76	0.4	4.4	
	160408-MP	M	●	9.525	4.76	0.8	4.4	
	160412-MP	M	●	9.525	4.76	1.2	4.4	
Standard  Ébauche moyenne	VCMT110304	M	●	6.35	3.18	0.4	2.8	
	160404	M	●	9.525	4.76	0.4	4.4	
	160408	M	●	9.525	4.76	0.8	4.4	
MV  Ébauche moyenne	VCMT080202-MV	M	●	4.76	2.38	0.2	2.42	
	080204-MV	M	●	4.76	2.38	0.4	2.42	
Standard  Ébauche moyenne	WCMT020102	M	●	3.97	1.59	0.2	2.3	
	020104	M	●	3.97	1.59	0.4	2.3	
	L30202	M	●	4.76	2.38	0.2	2.3	
	L30204	M	●	4.76	2.38	0.4	2.3	
	040202	M	●	6.35	2.38	0.2	2.8	
	040204	M	●	6.35	2.38	0.4	2.8	
	06T304	M	●	9.525	3.97	0.4	4.4	
	06T308	M	●	9.525	3.97	0.8	4.4	

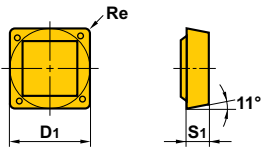
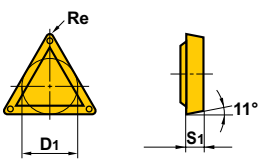
PLAQUETTES

● Plaquettes positives 11° (à trou)

Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
FV 	CPMH080202-FV	M	●	7.94	2.38	0.2	3.5	
	080204-FV	M	●	7.94	2.38	0.4	3.5	
	090302-FV	M	●	9.525	3.18	0.2	4.5	
	090304-FV	M	●	9.525	3.18	0.4	4.5	
	090308-FV	M	●	9.525	3.18	0.8	4.5	
Usinage en finition								
SV 	CPMH080202-SV	M	●	7.94	2.38	0.2	3.5	
	080204-SV	M	●	7.94	2.38	0.4	3.5	
	090302-SV	M	●	9.525	3.18	0.2	4.5	
	090304-SV	M	●	9.525	3.18	0.4	4.5	
	090308-SV	M	●	9.525	3.18	0.8	4.5	
Semi-finition								
MV 	CPMH080204-MV	M	●	7.94	2.38	0.4	3.5	
	080208-MV	M	●	7.94	2.38	0.8	3.5	
	090304-MV	M	●	9.525	3.18	0.4	4.5	
	090308-MV	M	●	9.525	3.18	0.8	4.5	
Ébauche moyenne								
FV 	TPMH080202-FV	M	●	4.76	2.38	0.2	2.4	
	080204-FV	M	●	4.76	2.38	0.4	2.4	
	090202-FV	M	●	5.56	2.38	0.2	2.9	
	090204-FV	M	●	5.56	2.38	0.4	2.9	
	110302-FV	M	●	6.35	3.18	0.2	3.4	
	110304-FV	M	●	6.35	3.18	0.4	3.4	
	110308-FV	M	●	6.35	3.18	0.8	3.4	
	160302-FV	M	●	9.525	3.18	0.2	4.4	
	160304-FV	M	●	9.525	3.18	0.4	4.4	
	160308-FV	M	●	9.525	3.18	0.8	4.4	
Usinage de finition								
L-FS 	TPGH080202L-FS	G	●	4.76	2.38	0.2	2.4	
	080204L-FS	G	●	4.76	2.38	0.4	2.4	
	090202L-FS	G	●	5.56	2.38	0.2	2.9	
	090204L-FS	G	●	5.56	2.38	0.4	2.9	
	110302L-FS	G	●	6.35	3.18	0.2	3.4	
	110304L-FS	G	●	6.35	3.18	0.4	3.4	
	160304L-FS	G	●	9.525	3.18	0.4	4.4	
	160308L-FS	G	●	9.525	3.18	0.8	4.4	
Usinage de finition								
SV 	TPMH080202-SV	M	●	4.76	2.38	0.2	2.4	
	080204-SV	M	●	4.76	2.38	0.4	2.4	
	090202-SV	M	●	5.56	2.38	0.2	2.9	
	090204-SV	M	●	5.56	2.38	0.4	2.9	
	110302-SV	M	●	6.35	3.18	0.2	3.4	
	110304-SV	M	●	6.35	3.18	0.4	3.4	
	110308-SV	M	●	6.35	3.18	0.8	3.4	
	160302-SV	M	●	9.525	3.18	0.2	4.4	
	160304-SV	M	●	9.525	3.18	0.4	4.4	
	160308-SV	M	●	9.525	3.18	0.8	4.4	
Semi-finition								

Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
MV 	TPMH080202-MV	M	●	4.76	2.38	0.2	2.4	
	080204-MV	M	●	4.76	2.38	0.4	2.4	
	090202-MV	M	●	5.56	2.38	0.2	2.9	
	090204-MV	M	●	5.56	2.38	0.4	2.9	
	090208-MV	M	●	5.56	2.38	0.8	2.9	
	110302-MV	M	●	6.35	3.18	0.2	3.4	
	110304-MV	M	●	6.35	3.18	0.4	3.4	
	110308-MV	M	●	6.35	3.18	0.8	3.4	
	160304-MV	M	●	9.525	3.18	0.4	4.4	
Ébauche moyenne	160308-MV	M	●	9.525	3.18	0.8	4.4	
Standard 	TPMX110304	M	●	6.35	3.18	0.4	3.5	
	110308	M	●	6.35	3.18	0.8	3.5	
MV 	WPMT040202-MV	M	●	6.35	2.38	0.2	2.8	
	040204-MV	M	●	6.35	2.38	0.4	2.8	
	060304-MV	M	●	9.525	3.18	0.4	4.4	
	060308-MV	M	●	9.525	3.18	0.8	4.4	
Ébauche moyenne								

● Plaquettes positives 11° (non percées)

Forme	Référence	Classe	Stock	Dimensions (mm)				Géométrie
			MP3025	D1	S1	Re	D2	
Standard 	SPMR090304	M	●	9.525	3.18	0.4	-	
	090308	M	●	9.525	3.18	0.8	-	
	120304	M	●	12.7	3.18	0.4	-	
	120308	M	●	12.7	3.18	0.8	-	
Semi-finition à Ébauche moyenne								
Standard 	TPMR090202	M	●	5.56	2.38	0.2	-	
	090204	M	●	5.56	2.38	0.4	-	
	090208	M	●	5.56	2.38	0.8	-	
	110302	M	●	6.35	3.18	0.2	-	
	110304	M	●	6.35	3.18	0.4	-	
	110308	M	●	6.35	3.18	0.8	-	
	160304	M	●	9.525	3.18	0.4	-	
	160308	M	●	9.525	3.18	0.8	-	
	160312	M	●	9.525	3.18	1.2	-	
Semi-finition à Ébauche moyenne								

CONDITIONS DE COUPE RECOMMANDÉES

Plaquettes négatives (outils de tournage externes)

Matière à usiner		Dureté	Mode de coupe		Brise-copeaux	Vitesse de coupe (m/min)	Avance (mm/tr)	Profondeur de coupe (mm)
P	Acier doux (E28, XC10 etc.)	≤180HB	Coupe générale	Usinage de finition	FY	275—420	0.09—0.23	0.20—0.80
				Semi-finition	SY	250—385	0.16—0.33	0.50—1.20
	Acier carbone, Acier allié (Xc42, 42CD4 etc.)	180—280HB	Coupe stable	Usinage de finition	R/L-F	210—325	0.05—0.15	0.10—0.50
				Semi-finition	LP	195—295	0.10—0.40	0.30—2.00
				Semi-finition	SW	195—295	0.10—0.50	0.30—2.50
				Semi-finition	R/L-K	195—295	0.08—0.20	0.30—1.20
				Ébauche moyenne	MP	175—270	0.16—0.50	0.30—4.00
				Ébauche moyenne	Standard	175—270	0.25—0.60	1.50—5.00
				Ébauche moyenne	D/G	175—270	0.15—0.32	0.40—2.00
			Coupe générale	Usinage de finition	FH	210—325	0.08—0.20	0.20—1.00
Ébauche moyenne	LP	195—295		0.10—0.40	0.30—2.00			

Plaquettes positives 7° (porte-outils SP, outils de tournage externes)

Matière à usiner		Dureté	Mode de coupe		Brise-copeaux	Vitesse de coupe (m/min)	Avance (mm/tr)	Profondeur de coupe (mm)
P	Acier doux (E28, XC10 etc.)	≤ 180HB	Coupe stable	Usinage de finition	R/L-F	230—350	0.05—0.12	0.10—1.50
				Semi-finition	MV, Standard	190—295	0.08—0.30	0.30—2.00
		Coupe générale	Usinage de finition	FP, FV	230—350	0.04—0.20	0.20—0.90	
			Semi-finition	LP	230—350	0.06—0.25	0.20—1.00	
			Ébauche moyenne	MP	190—295	0.08—0.30	0.30—2.00	
	Acier carbone, Acier allié (XC42, 42CD4 etc.)	180—280HB	Coupe stable	Usinage de finition	R/L-F	170—260	0.05—0.12	0.10—0.50
				Semi-finition	SV	170—260	0.06—0.25	0.20—1.00
				Ébauche moyenne	MV, Standard	140—215	0.08—0.30	0.30—2.00
				Ébauche moyenne	MW	140—215	0.10—0.35	0.80—2.50
			Coupe générale	Usinage de finition	FP, FV	170—260	0.04—0.20	0.20—0.90
				Semi-finition	LP	170—260	0.06—0.25	0.20—1.00
				Semi-finition	SW	170—260	0.06—0.24	0.20—1.50
				Ébauche moyenne	MP	140—215	0.08—0.30	0.30—2.00
	Acier carbone, Acier allié (SNCM439 etc.)	280—350HB	Coupe générale	Ébauche moyenne	MP	100—155	0.08—0.30	0.30—2.00

Plaquettes positives 11° (porte-outils MC, outils de tournage externes)

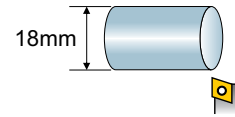
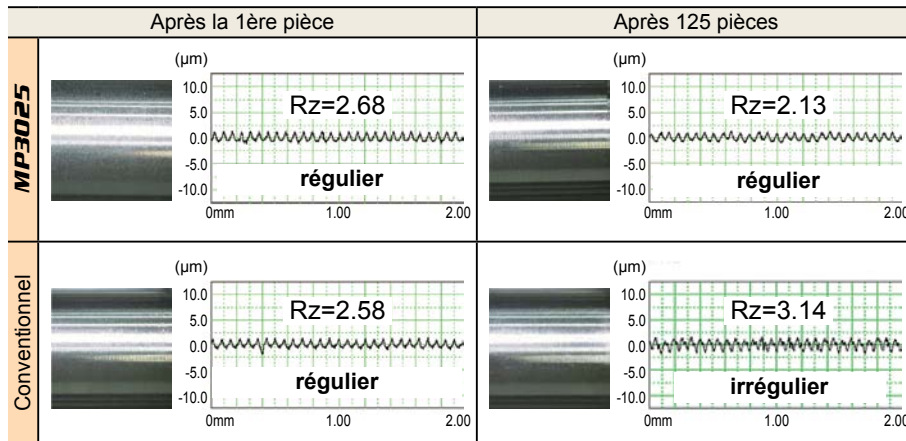
Paramètres recommandés pour les usinages à l'outil à coupe orthogonale								
Matière à usiner		Dureté	Mode de coupe		Brise-copeaux	Vitesse de coupe (m/min)	Avance (mm/tr)	Profondeur de coupe (mm)
P	Acier doux (E28, XC10 etc.)	≤180HB	Coupe générale	Semi-finition/Ébauche moyenne	Standard	190—295	0.08—0.30	0.30—2.00
	Acier carbone, Acier allié (Xc42 42CD4 etc.)	180—280HB	Coupe générale	Semi-finition/Ébauche moyenne	Standard	140—215	0.08—0.30	0.30—2.00

Plaquettes positives 5°/7° (barres d'alésage)

Matière à usiner		Dureté	Mode de coupe		Brise-copeaux	Vitesse de coupe (m/min)	Avance (mm/tr)	Profondeur de coupe (mm)
P	Acier doux (E28, XC10 etc.)	≤180HB	Coupe générale	Usinage de finition	FP, FV	230—350	0.04—0.20	0.20—0.90
				Semi-finition	LP	230—350	0.06—0.25	0.20—1.00
				Ébauche moyenne	MP, MV, Standard	190—295	0.08—0.30	0.30—2.00
	Acier carbone, Acier allié (XC42, 42CD4 etc.)	180—280HB	Coupe générale	Usinage de finition	FP	170—260	0.04—0.20	0.20—0.90
				Semi-finition	LP	170—260	0.06—0.25	0.20—1.00
				Ébauche moyenne	MP	140—215	0.08—0.30	0.30—2.00
	Acier carbone, Acier allié (35CD4 etc.)	280—350HB	Coupe générale	Usinage de finition	FP	120—185	0.04—0.20	0.20—0.90
				Semi-finition	LP	120—185	0.06—0.25	0.20—1.00
				Ébauche moyenne	MP	100—155	0.08—0.30	0.30—2.00

★ Les conditions de coupe recommandées pour les plaquettes positives 5° et 7° peuvent varier en fonction du porte-à-faux. Avant d'alésier, veuillez prendre connaissance des conditions de coupe recommandées pour les barres d'alésage.

Comparaison des états de surface

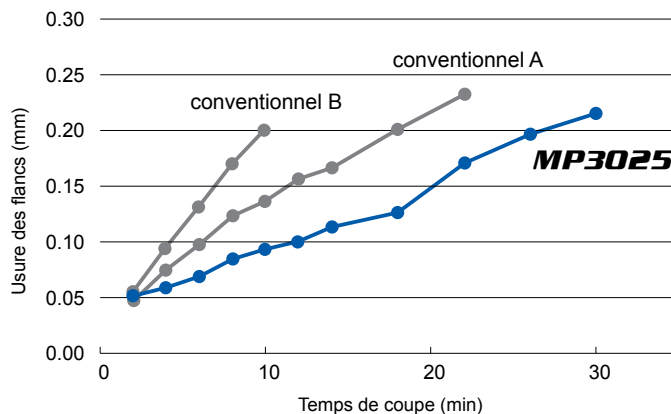


<Condition de coupe>

Pièce à usiner : XC42
Plaquettes : DCMT11T304
Vitesse de coupe : $vc=150$ m/min
Profondeur de coupe : $ap=1,0$ mm
Avance : $f=0,07$ mm/tour
Coupe lubrifiée

La nuance MP3025 a conservé un état de surface de haute qualité après 125 pièces.

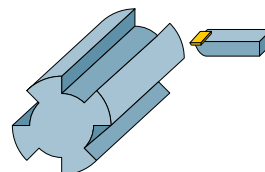
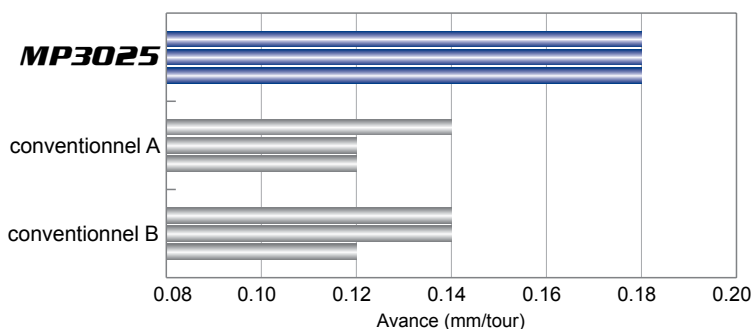
Comparaison de la résistance à l'usure



<Condition de coupe>

Pièce à usiner : Xc42
Plaquettes : CNMG120408-
Vitesse de coupe : $vc=250$ m/min
Profondeur de coupe : $ap=1,0$ mm
Avance : $f=0,15$ mm/tour
Coupe lubrifiée

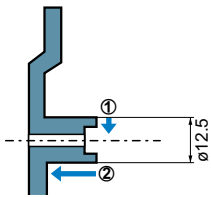
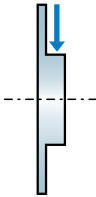
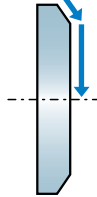
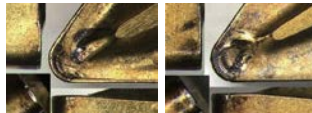
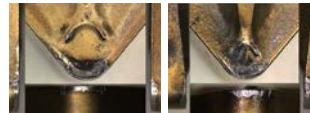
Comparaison de la résistance à la rupture

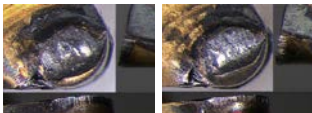


<Condition de coupe>

Pièce à usiner : 42CD4
Plaquettes : CNMG120408-
Vitesse de coupe : $vc=200$ m/min
Profondeur de coupe : $ap=1,0$ mm
Coupe à sec

Exemples d'application

Plaquette	WNMG080408-LP (MP3025)	DNMG150404-LP (MP3025)	WNMG080408-LP (MP3025)
Pièce	Pignon (JIS-SPHC) 	Pièces de moteur (25CD4) 	E28 
Conditions de coupe	Vitesse de coupe (m/min)	98	200
	Avance (mm/min)	0.2	0.12
	Profondeur de coupe (mm)	0.35	0.3
Arrosage	Coupe lubrifiée	Coupe lubrifiée	Coupe à sec
Résultats	Conventionnel MP3025  MP3025 présente une meilleure résistance à l'usure que le Cermet conventionnel et allonge la durée de vie entre les changements d'outils.	Conventionnel MP3025  MP3025 double la durée de vie des outils et le brise-copeaux LP atténue les vibrations pendant l'usinage.	Conventionnel MP3025  MP3025 a permis de multiplier la durée de vie de l'outil par deux avec un usinage à sec.

Plaquette	TNGG160404L-F (MP3025)
Pièce	XC42 
Conditions de coupe	Vitesse de coupe (m/min)
	Avance (mm/min)
	Profondeur de coupe (mm)
Arrosage	Coupe lubrifiée
Résultats	Conventionnel MP3025  Comparée à des produits conventionnels, la nuance MP3025 a présenté moins d'usure et, de ce fait, allongé la durée de vie de l'outil.



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