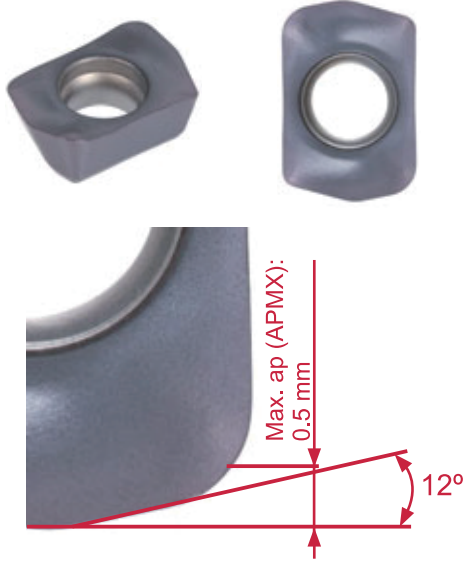


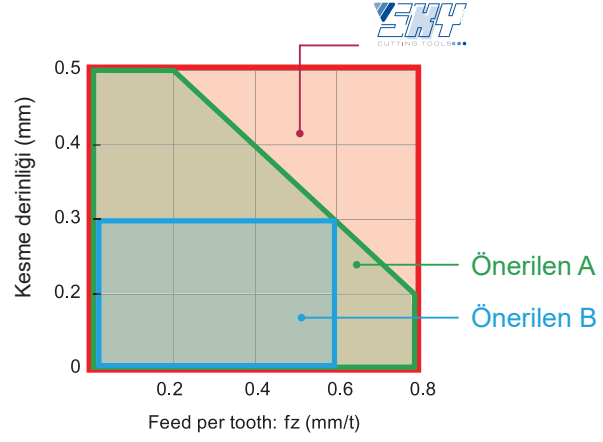


## Hızlı ilerleme uç ve takımları (LSMT-HM)

- Çok geçişli operasyonlarda yüksek verimlilik.
- Slot, interplasyon gibi, uzun erişim alanları.



### Kesme Aralığı



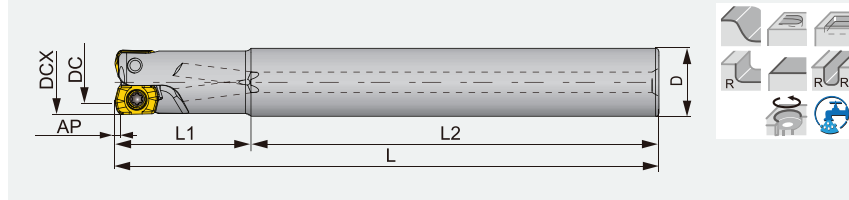
## STANDART KESME KOŞULLARI

ISO	Workpiece materials	Hardness	Priority	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)
<b>P</b>	Carbon steels (S45C / C45, S55C / C55, etc)	- 300HB	First choice	100 - 300	0.2 - 0.8
		- 300HB	For wear resistance	100 - 300	0.2 - 0.8
	Alloy steels (SCM440 / 42CrMo4, etc)	- 300HB	First choice	100 - 300	0.2 - 0.8
		- 300HB	For wear resistance	100 - 300	0.2 - 0.8
<b>M</b>	Prehardened steels (NAK80, PX5, etc)	30 - 40HRC	First choice	100 - 200	0.2 - 0.5
		30 - 40HRC	For impact resistance	100 - 200	0.2 - 0.5
<b>M</b>	Stainless steels (SUS304 / X5CrNi18-9, SUS316 / X5CrNiMo17-12-3, etc)	- 200HB	First choice	100 - 150	0.2 - 0.5
<b>K</b>	Gray cast irons (FC250 / 250 / GG25, FC300 / 300 / GG30, etc)	150 - 250HB	First choice	100 - 300	0.2 - 0.8
		150 - 250HB	For impact resistance	100 - 300	0.2 - 0.8
	Ductile cast irons (FCD600 / 600-3 / GGG60, etc)	150 - 250HB	First choice	80 - 200	0.2 - 0.8
		150 - 250HB	For impact resistance	80 - 200	0.2 - 0.8
<b>S</b>	Titanium alloy (Ti-6Al-4V, etc)	- 40HRC	First choice	30 - 60	0.1 - 0.3
		- 40HRC	For wear resistance	30 - 60	0.1 - 0.3
	Heat resistance alloy (Inconel, Hastelloy, etc)	- 40HRC	First choice	20 - 50	0.1 - 0.3
- 40HRC		For impact resistance	20 - 50	0.1 - 0.3	
<b>H</b>	Hardened steel	SKD61 / X40CrMoV5-1, etc	40 - 50HRC	First choice	80 - 150
		SKD11 / X153CrMoV12, etc	50-60HRC	First choice	50 - 70

## TAKIM ÇAPLARI

### Cylindrical type holder for high-feed milling, screw-on

GAMP = +4°, GAMF = -21° ~ -17°



Sipariş Kodu	Stok	Ölçüler (mm)						Uç	Vida	Anahtar	Ağırlık (kg)
		D	DC	L	L1	ap	Z				
EXLS02M08C08LH16R01	●	8	4.29	75	16	0.5	1	LSMT- 0202ZER- HM-SKY-4115-4125	M2*4	T-6	0.03
EXLS02M10C10LH20R02	●	10	6.28	80	20		2				0.05
EXLS02M12C12LH20R03	●	12	8.31	80	20		3				0.07
EXLS02M16C16LH30R05	●	16	12.31	100	30		5				0.15

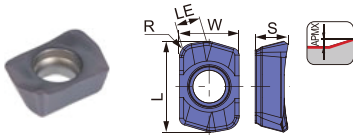
## UÇ TİPİ

LSMT-HM (High feed)

● continuous

● light Interruption

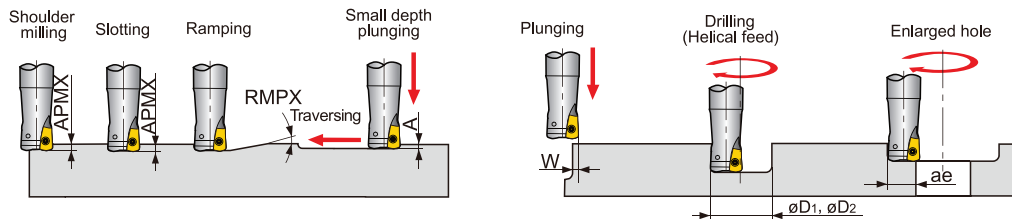
⊕ Interruption



	Steel	Stainless Steel	Cast Iron	Non-ferrous Metal	Heat-resistant Alloy, TiAlloy	High Hardness Materials
P	● ● ● ⊕					
M		● ● ● ●				
K			● ●			
N				● ●		
S						
H						

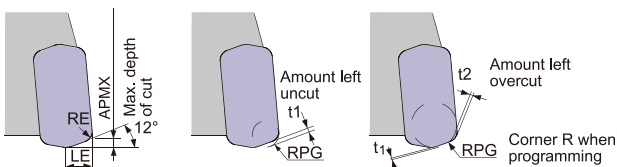
Model	OrderingCode	Dimensions(mm)					Coated PVD	
		L	LE	S	W	R	SKY4115	SKY4125
LSMT0202ZER-HM		6.4	1.7	2.3	4.2	1	●	●

## UYGULAMALAR



Designation	DC	Max. depth of cut APMX	Max. ramping angle RMPX	Max. plunging depth A	Max. cutting width in plunging W	Min. machining øD1 D2 e	Max. machining ø a	Max. cutting width in enlarged hole
E/HXLS02M008...	8	0.5	4°	0.2	2	10	15	5.9
E/HXLS02M010...	10	0.5	3.3°	0.2	2	14	19	7.9
E/HXLS02M012...	12	0.5	2°	0.2	2	18	23	9.9
E/HXLS02M016...	16	0.5	1.3°	0.2	2	26	31	13.9

### Tool geometry on programming



### LSMT02...-HM

Corner R when programming: RPG	Amount left uncut t1 (mm)	Amount left overcut t2(mm)
1.0 *Recommend	0.162	0
1.5	0.07	0.14
2	0	0.34