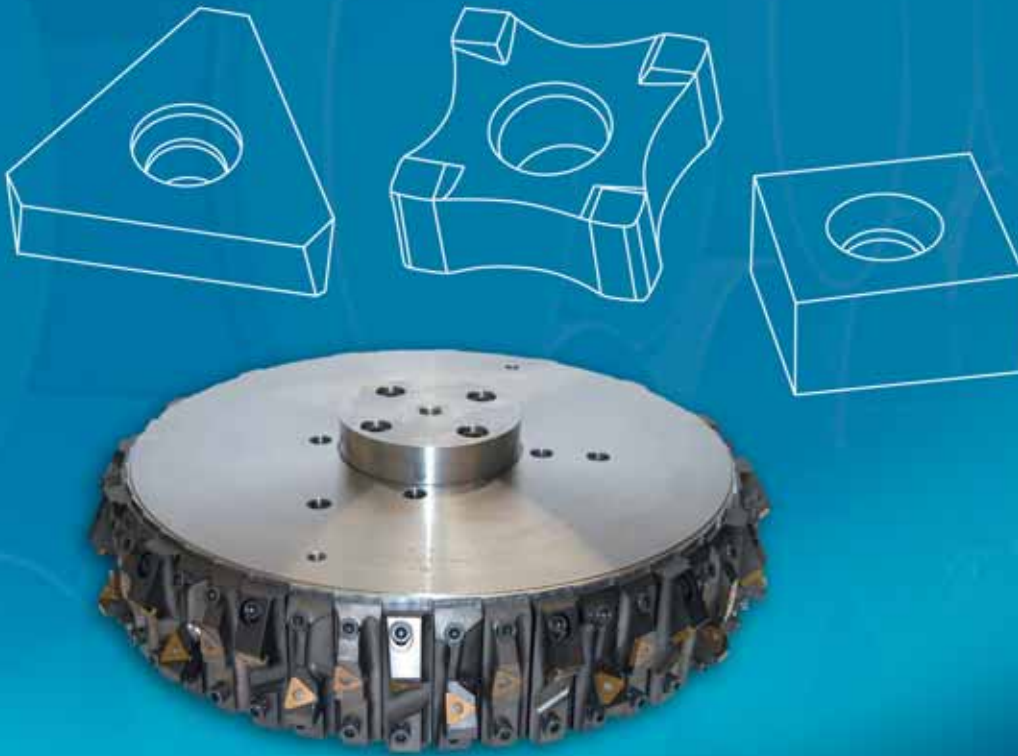


BOEHLERIT



Boru işleme uç ve takımları
Tube processing



in alliance with





Böhler Sert Maden ve Takım Sanayi ve Ticaret A.Ş. günümüz imalat sanayisinin önemli ara mamullerinden biri olan sert metal ürünlerin imalatını gerçekleştirmek amacıyla 1967 yılında Kartal/İstanbul'da kurulmuştur. Dünyada sert metal üretimini gerçekleştiren ilk iki firmadan birisi olan Boehlerit/Avusturya iştiraki ile faaliyete geçen Böhler Sert Maden, en son teknolojiye uygun üretim imkanları ve güçlü servis teşkilatı ile 40 yıldır ülkemizin yanısıra uluslararası pazarlarda da kalitesini kanıtlamıştır. Uzun bir süreden beri toplam kalite felsefesini benimseyen Böhler Sert Maden, müşterilerine sunmuş olduğu ürün ve karşılıklı olduğu hizmetlerle ilgili olarak ISO 9001:2000 Kalite Sistem Belgesine sahiptir.

Konusunda ülkemizin tek üretici firması olan BÖHLER SERT MADEN, demir-çelik endüstrisi başta olmak üzere endüstrinin birçok alanında ihtiyaç duyulan sert metal ürünlerin imalatını yapmaktadır. Özellikle çelik boru üretiminde kenar frezeleme, alın tornalama, iç/dış çapak alma operasyonlarında kullanılan sert metal kesici uçlar konusunda çok geniş ürün yelpazesine sahiptir.

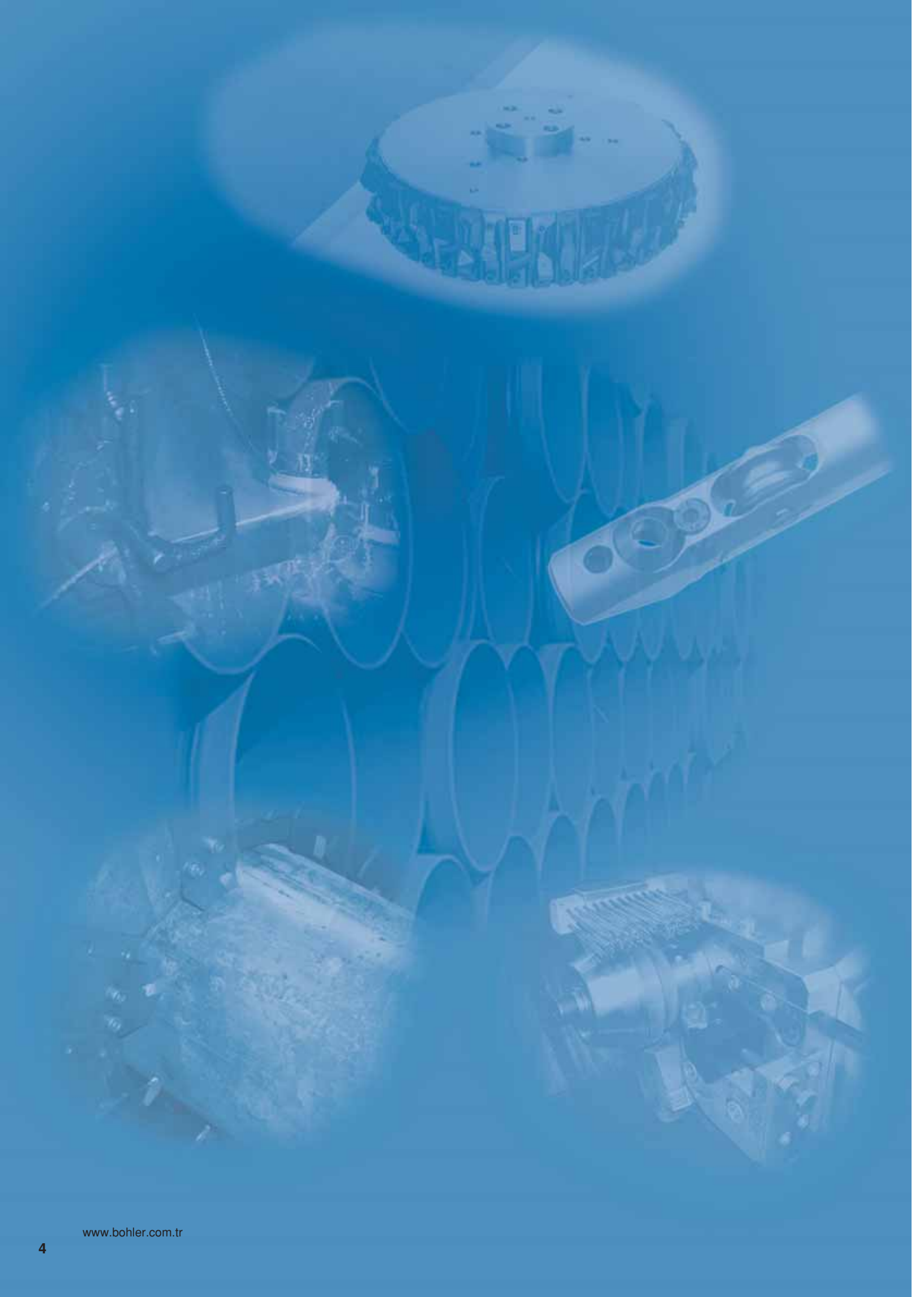
Böhler Sert Maden, üstün teknolojisi ve bilgi birikimi ile müşterilerinin standart dışı, özel imalat gerektiren ihtiyaçlarını da karşılayabilmektedir.

BÖHLER SERT MADEN, a subsidiary of Boehlerit/Austria, began producing carbide materials in 1967, in Kartal-İstanbul. In addition to the Turkish market we supply our products to many other countries like Austria, Germany, Romania, Hungary, Iran, Pakistan, Saudi Arabia, Jordan, Egypt, UAE, Taiwan etc.

Machine producers and industries for automotive, iron and steel, foundries, metal cutting, mining, ceramic, plastic, textile, wood etc. are all our customers and what BÖHLER SERT MADEN produces for them are as follows:






TOOLS AND INSERTS FOR TUBE MACHINING
INDEXABLE INSERTS
BRAZING CARBIDE TIPS
DRAWING DIES AND NIBS
HARD METAL RODS
BAR PEELING INSERTS

In addition to its standards based products, BÖHLER SERT MADEN being a mid-size firm, has the flexibility of providing custom solutions to its customers quickly and economically.



İçindekiler

Contents

	Kenar frezeleme	Sheet edge preparation	
	Freze Kafaları	Milling heads	6
	Freze Uçları	Milling inserts	7
	Kenar Kesme Uçları	Scarfig inserts	9
	Kaynak dikişi kazıma uçları	Weld seam scarfing	
	İç çapak	Internal	10
	Dış çapak	External	12
	Boru kesme	Tube parting	18
	Alın tornalama operasyonu	Tube and pipe end bevelling	
	Uçlar	Indexable inserts	19
	Kartuş sistemleri	Designation system for cartridges	20
	Et kalınlığı ve pah açısına göre takım seçimi	Choice of tool in relation to chamfer angle and wall thickness	21
	Kartuş ve yedek parçalar	Cartridges and spare parts	22
	Teknik bilgiler	Technical hints	
	Kaliteler	Grade overview	25
	Büyük çaplı boruların alın tornalama operasyonları için kesme değerleri	Cutting data recommendations for end bevelling of large tubes	26

Daha detaylı bilgi için lütfen bohler@bohler.com.tr adresine yazınız.
For more detailed information pls contact us via e-mail bohler@bohler.com.tr

Freze kafası

Milling Head



Kartuşları nötr pozisyonda bağlı olan freze sistemi sağ ve sol olmak üzere iki kafadan oluşur. Kartuşlar bağlanma pozisyonlarına göre istenen kaynak profilini alt, orta ve üst pahları frezelemek suretiyle oluşturur. Kaynak alt profilinin genişliğini ayarlamak için alt destek parçaları kullanılır. Değişik profiller elde edilmek istendiğinde aynı gövdeye yeni kartuşlar bağlamak mümkündür. Ayar yapmaya gerek olmayan bu değiştirme imkanı aynı zamanda hasar görmüş kartuşları yenilemek için de kullanılır.

System consisting of two milling heads (left and right) with cartridges in neutral position. Milling profile, angle of upper or lower chamfer, angle of root face and cutting geometry are defined with the form of the cartridges. Cutting profile can easily be modified by exchanging of cartridges. In case of damage, cartridges will be replaced without any adjustment work. Width of root face is adjustable by exchanging of distance pieces.

Örnek Kartuş

Milling Cartridge (example)



Kenar Profili

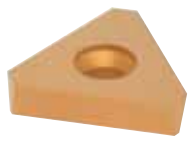
Edge Profile


I-Profil
I-profileX-Profil
X-profileY-Profil
Y-profileTulip-Profil
Tulip-profile

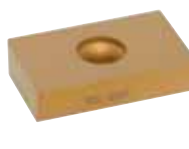
Freze Kafası

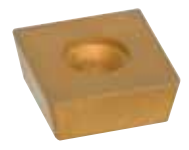
Milling Head



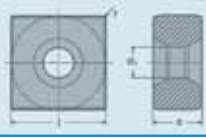
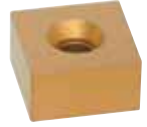
TPEW	Sipariş kodu Ordering Code								Kaliteler Grades			
		l	l ₁	d	s	d ₁	r	α	BC4345	BC4440	LCP37M	BS225
	TPEW 2807 (D-21-243)	28,58	18,00	16,50	7,00	5,5	1,2	11°				●
	TPEW 3106 (D-21-297)	31,00	22,69	17,90	6,35	6,6	0,0	11°	●	●		
	TPEW 3307 (BM35503)	33,50	23,35	19,05	7,00	6,6	1,2	11°		●		●
	TPNX 3307	33,50	23,35	19,05	7,00	6,6	1,2	11°			●	
	BSM-7927	33,00	23,35	19,05	7,00	6,6	1,2	11°		○	○	

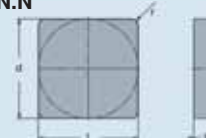

TPEX	Sipariş kodu Ordering Code								Kaliteler Grades		
		l	l ₁	d	s	d ₁	r	α	BC4345	BC4440	BS225
	TPEX 330716	33,00	27,45	19,05	7,00	6,6	1,6	11°		○	

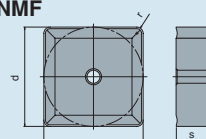
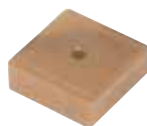
LPEX	Sipariş kodu Ordering Code							Kaliteler Grades		
		l	d	s	d ₁	r	α	BC4345	BC4440	BS225
	LPEX 130616 (D-21-852)	13,5	13,5	6,35	6,6	1,6	11°	●		
	LPEX 220616 (D-21-853)	22	19,05	6,35	6,6	1,6	11°	●		
	LPEX 300605 (D-21-1265)	30	19,05	6,35	6,6	0,5	11°	○	●	
	LPEX 320810 (BM44837)	32	20	8	6,6	1,0	10°		○	
	LPEX 360805 (D-21-642)	36	20	8	6,6	0,5	11°		●	
	LNEX 4014 (BSM-8977)	40	14	6,35	6,0	-	-		○	

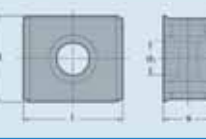
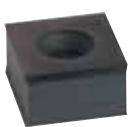
S..W	Sipariş kodu Ordering Code							Kaliteler Grades				
		l	d	s	d ₁	r	α	BC2250	BC2295	BC2430	BC4440	BS225
	SDEW 150620 (D-21-290)	15,88	15,88	6,35	5,5	2,0	15°		●			
	SPEW 190604 (D-21-415)	19,05	19,05	6,35	6,6	0,4	11°				●	●
	SPEW 250620 (D-21-414)	25	25	6,35	7,0	2,0	11°					
	SPGW 190612 (BSM-5745)	19,05	19,05	6,35	6,6	1,2	11°			●		
	SPUW 200808 (BSM-8979)	20,00	20,00	8,00	6,0	0,8	11°	○				

Stoktan teslim Available from stock : ●
Sipariş üzerine On request : ○




SN.X 	Sipariş kodu Ordering Code	l	d	s	d ₁	r	Kaliteler Grades					
							BC2245	BC2250	BC2450	BC2495	BC4440	
	SNUX 150804 (BM44063)	15,50	15,50	8,00	5,0	0,4						○
	SNEX 150704 (BM46098)	15,88	15,88	7,94	5,5	0,4	●				●	●
	SNUX 190704 (BM48117)	19,05	19,05	7,94	6,4	0,4	○					
	SNGQ 150704 (BSM-6016)	15,88	15,88	7,94	5,5	0,4		○				●
	SNGX 150704 (BSM-6279)	15,88	15,88	7,94	5,5	0,4		○	○			
	SNGX 190704 (BSM-7848)	19,05	19,05	7,94	6,4	0,4			○			○

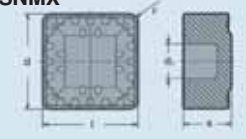
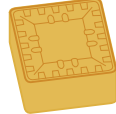
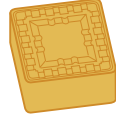

SN.N 	Sipariş kodu Ordering Code	l	d	s	r	Kaliteler Grades		
						BC2250	BC4440	BS240
	SNUN 190412	19,05	19,05	4,76	1,2	○		○
	SNUN 301012	30	30	10	1,2		○	○
	SNNN 150608 (MSU-10435)	15,88	15,88	6,35	0,8	○		
	SNNN 190612 (MSU-10430)	19,05	19,05	6,35	1,2	○		
	SNNN 250604 (MSU-10440)	25,40	25,40	6,35	0,4	○		

SNMF 	Sipariş kodu Ordering Code	l	d	s	r	Kaliteler Grades	
						BC2420	BC2450
	SNMF 190612 (MSU-10260)	19,05	19,05	6,35	1,2	○	●
	SNMF 250720 (MSU-10425)	25,4	25,4	7,94	2,0	○	●

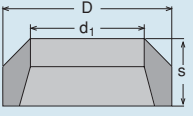

S..X 	Sipariş kodu Ordering Code	l	d	s	d ₁	Kaliteler Grades		
						BC2250	BC4440	BS225
	BM39288	18,30	18,30	10,0	6,6			●
	BM41737	20	17,40	10,0	6,6			○
	BM42871	30	18,30	10,0	6,6			○
	SXXK 1810 (BSM-5477)	18,30	18,30	10,0	6,6	○		●
	SXXK 1807 (BSM-7301)	18,30	18,30	7,94	6,6	○		○

● : Stoktan teslim Available from stock
 ○ : Sipariş üzerine On request

LNUX 	Sipariş kodu Ordering Code	l	d	s	d ₁	r	Kaliteler Grades			
							BC4345	BC4440	BS225	BS430
	LNUX-400924-BBM	40	25,4	9,52	9,2	2,4				●
	LNUX-400924-BB0	40	25,4	9,52	9,2	2,4				●

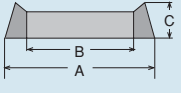

SNMX 	Sipariş kodu Ordering Code	l	d	s	d ₁	r	Kalite Grade
							LC235C
	SNMX-251224-BHF	25,4	25,4	12,8	9,12	2,4	○
	SNMX-381220-BHF	38,1	38,1	12,8	9,12	2,0	○
	SNMX-251224-BHM	25,4	25,4	12,8	9,12	2,4	○
	SNMX-251224-BHL	25,4	25,4	12,8	9,12	2,4	●

Stoktan teslim Available from stock : ●
Sipariş üzerine On request : ○

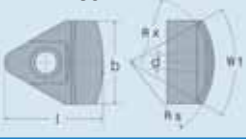

KU 	Sipariş kodu Ordering Code	\varnothing D	$\varnothing d_1$	s	Kaliteler Grades	
					BC2425	BS240
	KU0-CR4,5	8	4	4	○	●
	KU0-CR6,5	10	6	5	○	●
	KU1-CR7	13	6	5	○	●
	KU1-CR8	13	7	5	○	●
	KU1-CR9	13	8	5	○	●
	KU2-CR10	19	9	8	○	●
	KU2-CR11	19	10	8	○	●
	KU2-CR12	19	11	8	○	●
	KU3-CR14	22	12	10	○	●
	KU3-CR17	22	15	10	○	●
	KU4-CR20	30	15	12	○	○
	KU4-CR23	30	20	12	○	○
	KU5-CR25	35	22	12	○	○
	KU5-CR28	35	25	12	○	○
	KU6-CR34	45	30	15	○	○
	KU6-CR39	50	35	15	○	○
	KU8-CR46	55	40	18	○	○

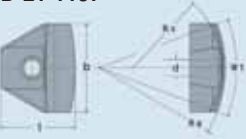

Ring tipi iç çapak alma uçlarının ALU formları için lütfen bizimle temasa geçiniz.
 For ALU type scarfing rings please contact us.

İç çapak alma uçları, Nelson tipi
 Internal weld seam scarfing rings for Nelson system

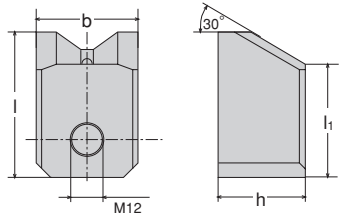
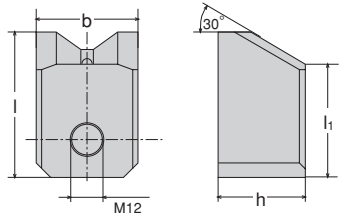
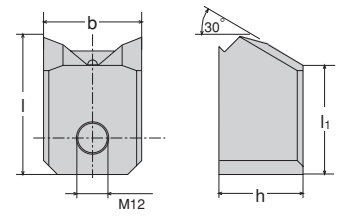
NSR 	Sipariş kodu Ordering Code							Kaliteler Grades	
		"A"		"B"		"C"		BC2495	BC4440
		mm mm	Zoll Inch	mm mm	Zoll Inch	mm mm	Zoll Inch		
	NSR 57	57,15	2.250	41,28	1.625	9,53	.375	○	○
	NSR 50	50,80	2.000	34,54	1.360	"	"	○	○
	NSR 44	44,45	1.750	31,75	1.250	"	"	○	○
	NSR 38	38,10	1.500	25,40	1.000	"	"	○	○
	NSR 31	31,75	1.250	22,23	.875	"	"	○	○
	NSR 25	25,40	1.000	15,88	.625	"	"	○	○
	NSR 21	21,59	.850	14,27	.562	7,92	.312	○	○
	NSR 17	17,15	.675	11,10	.437	6,35	.250	○	○
	NSR 13	13,46	.530	9,14	.360	4,78	.188	○	○
	NSR 11	11,13	.438	7,49	.295	3,96	.156	○	○
	NSR 10	10,16	.400	6,35	.250	"	"	○	○

● : Stoktan teslim Available from stock
 ○ : Sipariş üzerine On request

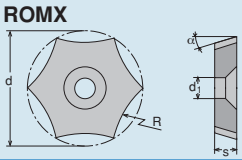

D-21-1138 	Sipariş kodu Ordering Code	W1 °	R x	R s	b	l	d	Kalite Grade
								BC4333
	D-21-1138-R20	77,36	20	20	25	29,5	6,6	●
	D-21-1138-R25	60,00	"	20	"	"	"	●
	D-21-1138-R30	49,24	"	30	"	"	"	●
	D-21-1138-R35	41,85	"	35	"	"	"	●
	D-21-1138-R50	28,95	40	50	"	"	"	●
	D-21-1138-R70	20,57	"	70	"	"	"	●
	D-21-1138-R75	19,18	"	75	"	"	"	●
	D-21-1138-R80	17,97	"	80	"	"	"	●
	D-21-1138-R85	16,91	"	85	"	"	"	●
	D-21-1138-R90	15,96	"	90	"	"	"	●
	D-21-1138-R95	15,12	"	95	"	"	"	●
	D-21-1138-R100	14,36	"	100	"	"	"	●

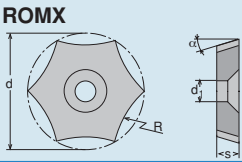
D-21-1107 	Sipariş kodu Ordering Code	W1 °	R x	R s	b	l	d	Kalite Grade
								BC4333
	D-21-1107-R35	60,00	35	35	35	29,5	6,6	●
	D-21-1107-R50	40,97	"	50	"	"	"	●
	D-21-1107-R70	28,95	"	70	"	"	"	●

İç çapak alma uçları için kartuşlar
Cartridges for scarfing bits

	Sipariş kodu Ordering Code	b	l	h	l ₁	Stok Stock	Kesme ucu Cutting bit
	D-62-001	25	40	24	32	●	D-21-1138
	D-62-005	35	50	30	39	●	
	D-62-006	35	50	30	39	●	D-21-1107

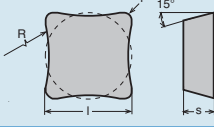

Stoktan teslim Available from stock : ●
Sipariş üzerine On request : ○

						Kalite Grade	
	Sipariş kodu Ordering Code	d	s	d ₁	R	α	BC4422
	ROMX-2404-R10 (DET3)	24,40	4,76	5,35	10,16	18°	●
	ROMX-2404-R13 (DET5)	13,54	..	●
	ROMX-2404-R16 (DET7)	16,51	..	●
	ROMX-2404-R21 (DET8)	21,80	..	●
	ROMX-2404-R27 (DET9)	27,51	..	●
	ROMX-2404-R38 (DET10)	38,89	..	●
	ROMX-2404-R47 (DET11)	47,63	..	●
	ROMX-2404-R60 (DET12)	60,33	..	●
	ROMX-2404-R73 (DET13)	73,03	..	●
	ROMX-2404-R85 (DET14)	85,73	..	●
ROMX-2404-R98 (DET15)	98,43	..	●	

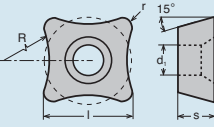
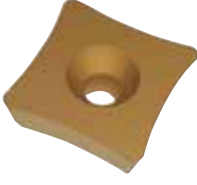
				
	Radyus R Radius R		Boru çapı Tube diameter	
	mm	inch	mm	inch
ROMX-2404-R10	10,16	0,400	15,88 ve altı	under 5/8
ROMX-2404-R13	13,54	0,533	15,88 - 22,23	5/8 - 7/8
ROMX-2404-R16	16,51	0,658	22,23 - 31,75	7/8 - 1 1/4
ROMX-2404-R21	21,80	0,858	31,75 - 41,28	1 1/4 - 1 5/8
ROMX-2404-R27	27,51	1,083	41,28 - 50,80	1 5/8 - 2
ROMX-2404-R38	38,89	1,531	50,80 - 73,00	2 - 2 7/8
ROMX-2404-R47	47,63	1,875	73,00 - 92,08	2 7/8 - 3 5/8
ROMX-2404-R60	60,33	2,375	92,08 - 117,48	3 5/8 - 4 5/8
ROMX-2404-R73	73,03	2,875	117,48 - 142,88	4 5/8 - 5 5/8
ROMX-2404-R85	85,73	3,375	142,88 - 168,28	5 5/8 - 6 5/8
ROMX-2404-R98	98,43	3,875	168,28 - 193,68	6 5/8 - 7 5/8

Dış çapak alma takımları için sayfa 13'e bakınız.
For tool holders please see page 13.

● : Stoktan teslim Available from stock
○ : Sipariş üzerine On request

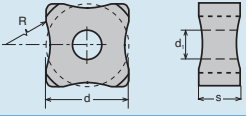
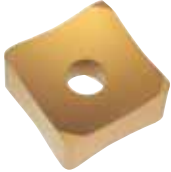
SDUN 190412-R 							Kalite Grad
	Sipariş kodu Ordering Code	l	s	r	R	BC2425	
	SDUN 190412-R15	19,05	4,76	1,2	15	○	
	SDUN 190412-R19	19	○	
	SDUN 190412-R20	20	○	
	SDUN 190412-R25	25	○	
	SDUN 190412-R32	32	○	
	SDUN 190412-R39	39	○	
	SDUN 190412-R45	45	○	
	SDUN 190412-R48	48	○	
	SDUN 190412-R64	64	○	
	SDUN 190412-R80	80	○	

Dış çapak alma takımları ile ilgili olarak lütfen bizimle temasa geçiniz.
For tool holders please contact us.

SDUW 250920-R 							Kalite Grad	
	Sipariş kodu Ordering Code	l	d	s	r	d ₁	R	BC2425
	SDUW 250920-R00	25,4	25,4	9,00	2,0	12	0	○
	SDUW 250920-R20	20	●
	SDUW 250920-R25	25	●
	SDUW 250920-R35	35	●
	SDUW 250920-R40	40	○
	SDUW 250920-R45	45	●
	SDUW 250920-R50	50	○
	SDUW 250920-R55	55	●
	SDUW 250920-R60	60	○
	SDUW 250920-R65	65	●
	SDUW 250920-R70	70	○
	SDUW 250920-R80	80	○
	SDUW 250920-R85	85	●
	SDUW 250920-R100	100	○
	SDUW 250920-R110	110	○
	SDUW 250920-R120	120	●
	SDUW 250920-R160	160	●
	SDUW 250920-R200	200	●
SDUW 250920-R250	250	○	

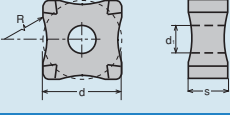
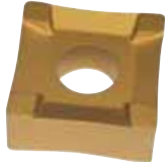
Dış çapak alma takımları ile ilgili olarak lütfen bizimle temasa geçiniz.
For tool holders please contact us.

● : Stoktan teslim Available from stock
○ : Sipariş üzerine On request

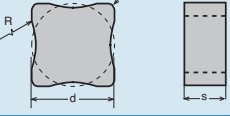

SNMX-15/19/25 	Sipariş kodu Ordering Code	d	s	d ₁	R	Kalite Grad
						BC2425
	SNMX 1507-22-R00	15,87	7,94	6,35	0	○
	SNMX 1507-22-R07	7	○
	SNMX 1507-22-R09	9	●
	SNMX 1507-22-R10	10	●
	SNMX 1507-22-R13	13	●
	SNMX 1507-22-R15	15	●
	SNMX 1507-22-R18	18	●
	SNMX 1507-22-R20	20	●
	SNMX 1507-22-R22	22	●
	SNMX 1507-22-R24	24	●
	SNMX 1507-22-R25	25	●
	SNMX 1507-22-R27	27	●
	SNMX 1507-22-R30	30	●
	SNMX 1507-22-R35	35	●
	SNMX 1507-22-R40	40	●
	SNMX 1507-22-R42	42	●
	SNMX 1507-22-R45	45	●
	SNMX 1507-22-R50	50	●
	SNMX 1507-22-R55	55	●
	SNMX 1507-22-R60	60	●
	SNMX 1507-22-R65	65	●
	SNMX 1507-22-R70	70	●
	SNMX 1507-22-R75	75	●
	SNMX 1907-22-R00	19,05	7,94	6,35	0	○
	SNMX 1907-22-R10	10	○
	SNMX 1907-22-R12	12	○
	SNMX 1907-22-R15	15	●
	SNMX 1907-22-R20	20	○
	SNMX 1907-22-R25	25	●
	SNMX 1907-22-R35	35	●
	SNMX 1907-22-R45	45	○
	SNMX 1907-22-R55	55	●
	SNMX 1907-22-R60	60	○
	SNMX 2512-22-R00	25,40	12,70	9,00	0	○
	SNMX 2512-22-R25	25	●
SNMX 2512-22-R35	35	●	
SNMX 2512-22-R40	40	●	
SNMX 2512-22-R50	50	●	
SNMX 2512-22-R65	65	●	
SNMX 2512-22-R80	80	●	
SNMX 2512-22-R90	90	○	
SNMX 2512-22-R100	100	●	
SNMX 2512-22-R120	120	○	
SNMX 2512-22-R200	200	○	
SNMX 2512-22-R250	250	○	

Dış çapak alma takımları için sayfa 17'ye bakınız.
For tool holders please see page 17.

Stoktan teslim Available from stock : ●
Sipariş üzerine On request : ○

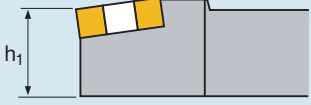
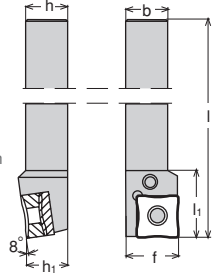
SNMG-15/19/25 						Kalite Grad	
	Sipariş kodu Ordering Code	l	d	s	d ₁	R	BC2425
	SNMG 1507-R13	15,87	15,87	7,94	5,20	13	●
	SNMG 1507-R18	18	●
	SNMG 1507-R22	22	●
	SNMG 1507-R27	27	●
	SNMG 1507-R35	35	●
	SNMG 1507-R45	45	●
	SNMG 1507-R60	60	●
	SNMG 1907-R12	19,05	19,05	7,94	8	12	●
	SNMG 1907-R15	15	●
	SNMG 1907-R20	20	●
	SNMG 1907-R25	25	●
	SNMG 1907-R35	35	●
	SNMG 1907-R55	65	●
	SNMG 1907-R75	75	●
	SNMG 2512-R85	25,4	25,4	11,2	9,12	85	●

Dış çapak alma takımları için sayfa 17'ye bakınız.
For tool holders please see page 17.

SNGN 					Kalite Grad	
	Sipariş kodu Ordering Code	d	s	r	R	BC2425
	SNGN 150708 R40	15,87	7,94	0,8	40	●
	SNGN 150708 R70	70	●
	SNGN 150708 R100	100	●

Dış çapak alma takımları ile ilgili olarak lütfen bizimle temasa geçiniz.
For tool holders please contact us.

● : Stoktan teslim Available from stock
○ : Sipariş üzerine On request

						Stok Stock		Kesici uç Indexable inserts	Sayfa Page	
	h = h ₁	b	l	l ₁	f	R	L			
<p>PSFNR / L PXFNR / L 90°</p> <p>Sağ yan resim verilmiştir. Right hand version R as drawn, left hand version L mirrorlike.</p> 	Sipariş kodu Ordering Code									
	PXFNR/L 2525 M15	25	25	150		32	●	○	SNMX 1507-22	15
	PXFNR/L 2525 M19	150		32	●	○	SNMX 1907-22	15
	PXFNR/L 2525 S25	250	40	35	●	○	SNMX 2512-22	15
	PSFNR/L 2525 M15	25	25	150	-	32	●	○	SNMG 1507	16
	PSFNR/L 2525 M19	150	-	32	●	○	SNMG 1907	16
	PSFNR/L 2525 S25	250	40	35	●	○	SNMG 2512	16

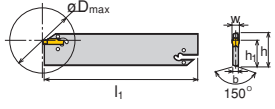
Kater yedekleri Spare parts		Sipariş kodu Ordering kodu					
Kesme kenar boyu Cutting edge length	Kater Tool Holder	Altılık Shim	Levyeye Leve	Altılık vidası Fixation screw	Altılık pimi Shim pin	Pim anahtarı Assembly punch	Allen anahtar Key
15	PXFNR / L	AX-2215	D02-15145	A03-08235	E01-07205	V10-20000	V01- A0030
..	PSG NR / L	AS-1507
19	PXFNR / L	AX-2219	D02-19210	A03-10270	E01-11011	V10-30000	V01- A0040
..	PSG NR / L	AS-1907
25	PXFNR / L	AX-2225	D02-23250	A03-12360	E01-15212	V10-50000	V01- A0050
..	PSG NR / L	AS-2512


Sipariş Örneği: 1 adet PXFNR 2525 M15
Order Example: 1 off PXFNR 2525 M15

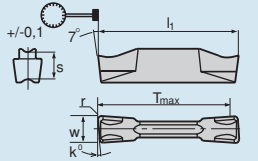

Anahtarsız teslim edilir
Delivery without key

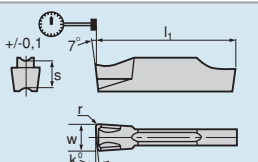
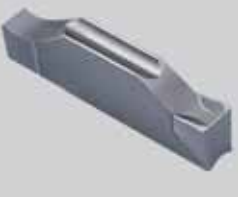
Stoktan teslim Available from stock : ●
Sipariş üzerine On request : ○

Kesme laması PB (Parting Blade)	Sipariş kodu Ordering code	h	l ₁	h ₁	b	w	D _{max}	Stok Stock	Uç Indexable insert
PB 32-.	PB 32-4	32	150	24,8	3 2	3,2-4 3	100	●	E LCMR...GM
	PB 32-5	"	"	"	4 0	4,2-5 3	120	●	S
	PB 32-6	"	"	"	5 2	5,2-6 3	120	●	

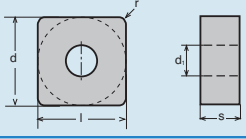
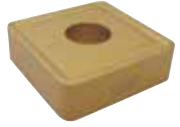


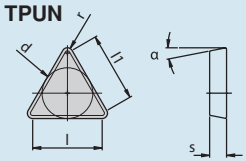
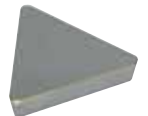
Kater yedekleri Spare parts	Sipariş kodu Ordering code
	VO7- y
	E1230

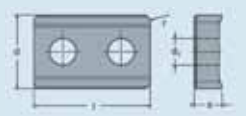

	Sipariş kodu Ordering code	w +/- 0,05	r	k	l ₁	s	T _{max}	Kaliteler Grades						
								LC232F	LC242W	LC442W	LCM02	LDP091	LW612	
ED LCMR...N0 GM 	ED LCMR 4.00-0.3N0 GM	4,0	0,30	0°	20	4,7	19	●	●					
	ED LCMR 5.00-0.3N0 GM	5,0	0,30	0°	25	5,2	24	●	●					
	ED LCMR 6.00-0.3N0 GM	6,0	0,30	0°	25	5,2	24	●	●					

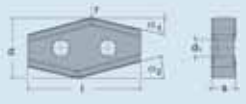

	Sipariş kodu Ordering code	w +/- 0,05	r	k	l ₁	s	T _{max}	Kaliteler Grades						
								LC232F	LC242W	LC442W	LCM02	LDP091	LW612	
ES LCMR...N0 GM 	ES LCMR 4.00-0.3N0 GM	4,0	0,30	0°	20	4,7	50	●	●					
	ES LCMR 5.00-0.3N0 GM	5,0	0,30	0°	25	5,2	60	●	●					
	ES LCMR 6.00-0.3N0 GM	6,0	0,30	0°	25	5,2	60	●	●					

● : Stoktan teslim Available from stock
○ : Sipariş üzerine On request

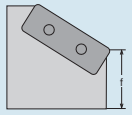
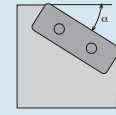
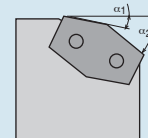
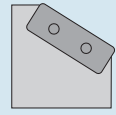
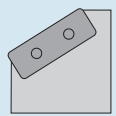
SNMM 	Sipariş kodu Ordering code	l	d	s	d ₁	r	Kaliteler Grade				
							BC2425	BC2450	BC2510	LC225K	BS430
	SNMM-250724-BBM	25,4	25,4	7,94	9,2	2,4					●
	SNMM-250724-MR	"	"	"	"	"	●		●		
	SNMT 381132	38,1	38,1	11,2	9,2	3,2				○	
	SXMT 190612 (BSM-7170A)	19,05	19,05	6,35	6,60	1,2		●			
	SPMT 120408-SN	12,70	12,70	4,76	5,50	0,8		●			

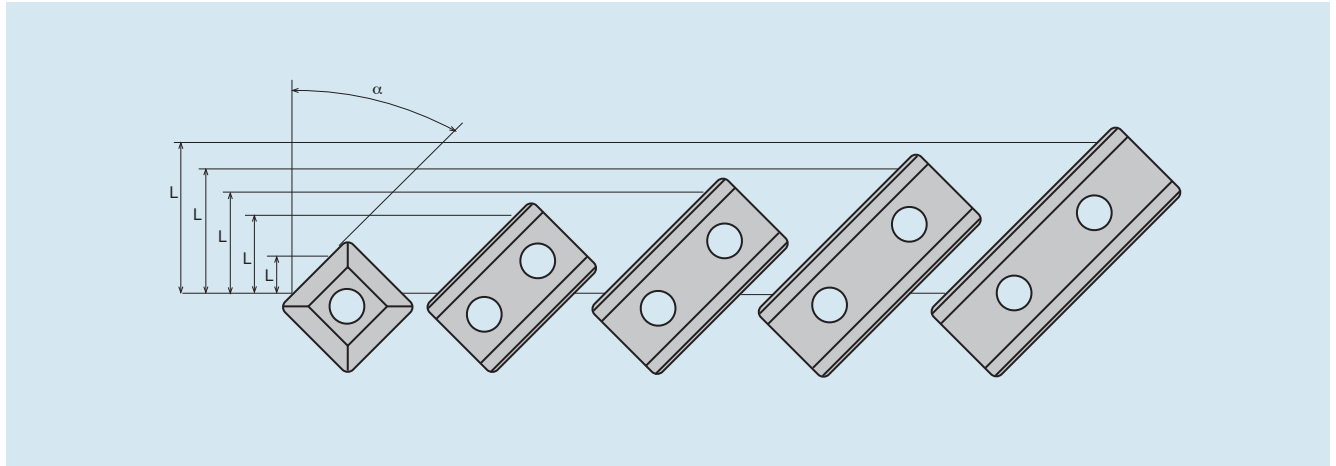
TPUN 	Sipariş kodu Ordering code	l	l ₁	d	s	d ₁	r	α	Kaliteler Grade			
									BC2425	BC2510	BC4440	BS240
	TPUN 330620-T	33	26,07	19,5	6,35	-	2	11		●		●
	TPUN 450720-T	45	38,11	26	7,94	-	2	11	○			○

LNUX 	Sipariş kodu Ordering code	l	d	s	d ₁	r	Kaliteler Grade				
							BC4335	BC4345	BC4440	BS240	BS430
	LNUX-400924-BBO	40	25,4	9,52	9,2	2,4					●
	LNUX-400924-BBM	"	"	"	"	"					●
	LNUX-400924-BBL	"	"	"	"	"					●
	LNUX-400924-BBF	"	"	"	"	"					●
	LNUX-501224-BBO	50	"	12,7	"	"					○
	LNUX-501224-BBM	"	"	"	"	"					○
	LNUX-501224-BBL	"	"	"	"	"					●
	LNUX-601224-BBL	60	"	"	"	"					●
LNUX-701224-BBL	70	"	"	"	"		●				

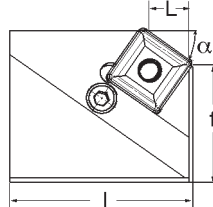
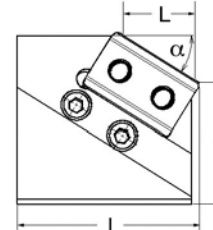
LNUX-05 	Sipariş kodu Ordering code	l	d	s	d ₁	r	α ₁	α ₂	Kaliteler Grade				
									BC4335	BC4345	BC4440	BS240	BS430
	LNUX-200900-BBO	40	29,2	9,52	9,2	5,0	10°	7°				●	
	LNUX-241200-BBO	50	29,2	12,7	9,2	5,0	10°	7°				●	
	LNUX-251200-BBO	50	32	12,7	9,2	10,0	12°	15°				●	
	LNUX-301200-BBO	60	32	12,7	9,2	10,0	13°	15°				●	

Stoktan teslim Available from stock : ●
Sipariş üzerine On request : ○





K Takım tipi Type of tool	4 Kesme kenar boyu, mm Length of cutting edge in mm	1 f-ölçüsü, mm Measure f in mm	45° Pah açısı α Approach angle α	L Kesme yönü Direction of cut																																																				
K = Kartuş = Cartridge	<table border="1"> <thead> <tr> <th>mm</th> <th>(Kesici Uç) (Indexable insert)</th> </tr> </thead> <tbody> <tr><td>0 = 15,88</td><td>(SNM 150624</td></tr> <tr><td>1 = 19,05</td><td>(SNM 190624</td></tr> <tr><td>2 = 25,4</td><td>(LNU 180440 *</td></tr> <tr><td></td><td>(SNM 250724)</td></tr> <tr><td>3 = 30</td><td>(LNU 150700 *</td></tr> <tr><td>3,8 = 38,1</td><td>(SNM 381224)</td></tr> <tr><td>4 = 40</td><td>(LNU 200900 *</td></tr> <tr><td>4 = 40</td><td>(LNUX 400924)</td></tr> <tr><td>5 = 50</td><td>(LNU 251200 *</td></tr> <tr><td></td><td>(LNU 501224)</td></tr> <tr><td>6 = 60</td><td>(LNU 601200 *</td></tr> <tr><td></td><td>(LNU 601224)</td></tr> <tr><td>7 = 70</td><td>(LNU 701224</td></tr> </tbody> </table> <p>* : Tulip profil Tulip profile)</p>	mm	(Kesici Uç) (Indexable insert)	0 = 15,88	(SNM 150624	1 = 19,05	(SNM 190624	2 = 25,4	(LNU 180440 *		(SNM 250724)	3 = 30	(LNU 150700 *	3,8 = 38,1	(SNM 381224)	4 = 40	(LNU 200900 *	4 = 40	(LNUX 400924)	5 = 50	(LNU 251200 *		(LNU 501224)	6 = 60	(LNU 601200 *		(LNU 601224)	7 = 70	(LNU 701224	 <p>1 = 48 mm 2 = 50 mm</p>	 <p>α° :</p> <table border="1"> <tbody> <tr><td>0</td></tr> <tr><td>2</td></tr> <tr><td>4</td></tr> <tr><td>6</td></tr> <tr><td>7</td></tr> <tr><td>8</td></tr> <tr><td>10</td></tr> <tr><td>15</td></tr> <tr><td>22</td></tr> <tr><td>25</td></tr> <tr><td>27</td></tr> <tr><td>30</td></tr> <tr><td>32</td></tr> <tr><td>35</td></tr> <tr><td>37</td></tr> <tr><td>40</td></tr> <tr><td>45</td></tr> <tr><td>50</td></tr> </tbody> </table>  <p>$\alpha^\circ_1/\alpha^\circ_2$</p> <table border="1"> <tbody> <tr><td>10/30</td></tr> <tr><td>10/37,5</td></tr> <tr><td>14/33</td></tr> <tr><td>17/60</td></tr> <tr><td>23/55</td></tr> <tr><td>28/60</td></tr> </tbody> </table>	0	2	4	6	7	8	10	15	22	25	27	30	32	35	37	40	45	50	10/30	10/37,5	14/33	17/60	23/55	28/60	<p>L</p>  <p>R</p> 
mm	(Kesici Uç) (Indexable insert)																																																							
0 = 15,88	(SNM 150624																																																							
1 = 19,05	(SNM 190624																																																							
2 = 25,4	(LNU 180440 *																																																							
	(SNM 250724)																																																							
3 = 30	(LNU 150700 *																																																							
3,8 = 38,1	(SNM 381224)																																																							
4 = 40	(LNU 200900 *																																																							
4 = 40	(LNUX 400924)																																																							
5 = 50	(LNU 251200 *																																																							
	(LNU 501224)																																																							
6 = 60	(LNU 601200 *																																																							
	(LNU 601224)																																																							
7 = 70	(LNU 701224																																																							
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10/37,5																																																								
14/33																																																								
17/60																																																								
23/55																																																								
28/60																																																								



Kartuş Cartridge	K-2 R/L	K-4 R/L	K-5 R/L	K-6 R/L	K-7 R/L
Kesici uç Indexable insert	SNMM 25	LNU 40	LNU 50	LNU 60	LNU 70
Açı Chamfer	X = Maksimum et kalınlığı L = Maximum Wall Thickness X				
$\alpha = 0^\circ$	16,0	32,0	40,0	50,0	60,0
$\alpha = 2^\circ$	"	"	"	"	"
$\alpha = 3^\circ$	"	"	"	"	"
$\alpha = 4^\circ$	"	"	"	49,5	"
$\alpha = 5^\circ$	15,5	"	"	"	59,5
$\alpha = 6^\circ$	"	"	"	"	"
$\alpha = 7^\circ$	"	"	39,5	"	"
$\alpha = 10^\circ$	"	31,5	39,5	49,0	59,0
$\alpha = 15^\circ$	"	31,0	38,5	48,0	58,0
$\alpha = 20^\circ$	15,0	30,0	37,5	46,5	56,0
$\alpha = 22^\circ$	15,0	29,5	37,0	46,0	55,0
$\alpha = 25^\circ$	14,5	29,0	36,0	45,0	54,0
$\alpha = 27^\circ$	14,0	28,5	35,5	44,0	53,0
$\alpha = 30^\circ$	14,0	27,5	34,5	43,0	51,0
$\alpha = 32^\circ$	13,5	27,0	34,0	42,0	50,0
$\alpha = 35^\circ$	13,0	26,0	32,5	40,5	48,0
$\alpha = 37^\circ$	12,5	25,5	32,0	39,5	47,0
$\alpha = 40^\circ$	12,0	24,5	30,5	37,5	45,0
$\alpha = 45^\circ$	11,0	22,5	28,0	34,5	41,0

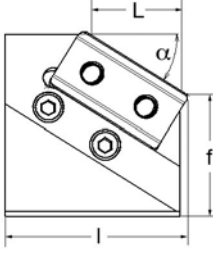
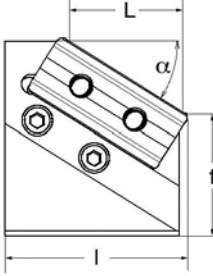
	Sipariş kodu Ordering code	α	f	l	L	Stok Stock		Kesici uç Indexable inserts	Sayfa Pag
						R	L		
K-2...  Sol yan resim verilmiştir. Left hand version shown, right hand version mirrorlike.	K-2-2-0°-R/L	0°	50	72	16,0	●	●	SNMM 25...	15
	K-2-2-2°-R/L	2°	16,0	○	○		
	K-2-2-4°-R/L	4°	16,0	○	○		
	K-2-2-7°-R/L	7°	15,5	○	○		
	K-2-2-10°-R/L	10°	15,5	○	○		
	K-2-1-15°-R/L	15°	48	72	15,5	○	○		
	K-2-1-25°-R/L	25°	14,5	○	○		
	K-2-1-27°-R/L	27°	14,0	○	○		
	K-2-1-30°-R/L	30°	14,0	○	●		
	K-2-1-32°-R/L	32°	13,5	○	●		
	K-2-1-35°-R/L	35°	13,0	○	●		
	K-2-1-37°-R/L	37°	12,5	○	●		
	K-2-1-40°-R/L	40°	12,0	○	○		
	K-2-1-45°-R/L	45°	11,0	●	○		
	K-2-1-50°-R/L	50°		○	○		
K-2-1-60°-R/L	60°		○	○			
K-4...  Sol yan resim verilmiştir. Left hand version shown, right hand version mirrorlike.	K-4-2-0°-R/L	0°	50	72	32,0	●	●	LNU 40... X	15
	K-4-2-2°-R/L	2°	○	○		
	K-4-2-4°-R/L	4°	○	○		
	K-4-2-6°-R/L	6°	○	●		
	K-4-2-7°-R/L	7°	○	○		
	K-4-2-10°-R/L	10°	31,5	○	●		
	K-4-1-12,5°-R/L	12,5°	48	72		○	●		
	K-4-1-15°-R/L	15°	31,0	○	●		
	K-4-1-17,5°-R/L	17,5°		○	●		
	K-4-1-22°-R/L	22°	29,5	○	●		
	K-4-1-27°-R/L	27°	28,5	○	●		
	K-4-1-30°-R/L	30°	27,5	○	●		
	K-4-1-32°-R/L	32°	27,0	○	●		
	K-4-1-35°-R/L	35°	26,0	○	●		
	K-4-1-37°-R/L	37°	25,5	○	●		
K-4-1-40°-R/L	40°	24,5	○	●			
K-4-1-45°-R/L	45°	22,5	●	●			

- Stoktan teslim On Stock
○ Sipariş üzerine (ayrıca özel açılı kartuşlar için) On request (and other chamfer angles)






Kartuş yedekleri Spare parts		Sipariş kodu Ordering code					
Kesici uç Indexable insert	Kesme boyu Cutting length	 Altık Shim	 Leve Leve r	 Altık vidası Fixation screw	 Rohrstift Shim pin		
SNMM 25..	25	B01-S-2463	D02-23250	D-22-013	E01-15212		
LNU 40..	40	D-20-037	D02-23250	D-22-013	E01-15212		

X
Sipariş örneği 1 adet K-2-2-0°-R
Ordering example: 1 off K-2-2-0°-R

Anahtarsız teslim edilir
Delivery without key

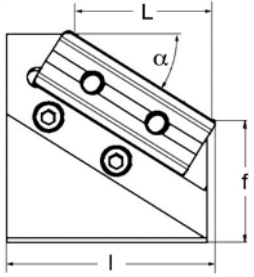
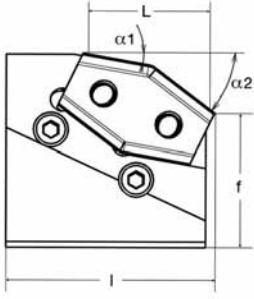
	Sipariş kodu Ordering code	α	f	l	L	Stok Stock		Kesici uç Indexable inserts	Sayfa P. no
						R	L		
K-5...  Sol yan resim verilmiştir. Left hand version shown, right hand version mirrorlike.	K-5-2-0°-R/L	0°	50	72	40,0	●	●	LNU 50... X	15
	K-5-2-2°-R/L	2°	"	"	40,0	○	○		
	K-5-2-3°-R/L	3°	"	"	40,0	○	○		
	K-5-2-6°-R/L	6°	"	"	40,0	○	○		
	K-5-2-8°-R/L	8°	"	"	39,5	○	○		
	K-5-1-10°-R/L	10°	48	"	39,5	○	○		
	K-5-1-12°-R/L	12°	"	"		○	○		
	K-5-1-15°-R/L	15°	"	"	38,5	○	●		
	K-5-1-20°-R/L	20°	"	"	37,5	○	○		
	K-5-1-22°-R/L	22°	"	"	37,0	○	○		
	K-5-1-25°-R/L	25°	"	"	36,0	○	○		
	K-5-1-27°-R/L	27°	"	"	35,5	○	●		
	K-5-1-30°-R/L	30°	"	"	34,5	○	●		
	K-5-1-32°-R/L	32°	"	"	34,0	○	●		
	K-5-1-35°-R/L	35°	"	"	32,5	○	●		
K-5-1-37°-R/L	37°	"	"	32,0	○	●			
K-5-1-45°-R/L	45°	"	"	28,0	○	●			
K-6...  Sol yan resim verilmiştir. Left hand version shown, right hand version mirrorlike.	K-6-2-0°-R/L	0°	50	72		●	●	LNU 60... X	15
	K-6-1-10°-R/L	10°	48	72	49,0	○	○		
	K-6-1-15°-R/L	15°	"	"	48,0	○	○		
	K-6-1-25°-R/L	25°	"	"	45,0	○	○		
	K-6-1-30°-R/L	30°	"	"	43,0	○	○		
	K-6-1-32°-R/L	32°	"	"	42,0	○	○		
	K-6-1-35°-R/L	35°	"	"		○	●		
	K-6-1-37°-R/L	37°	"	"	39,5	○	○		
	K-6-1-45°-R/L	45°	"	"	34,5	○	○		

- Stoktan teslim On Stock
○ Sipariş üzerine (ayrıca özel açılı kartuşlar için) On request (and other chamfer angles)






Kartuş yedekleri Spare parts		Sipariş kodu Ordering code					
Kesici uç Indexable insert	Kesme boyu Cutting length	 Altlık Shim	 Leve Lever	 Altlık vidası Fixation screw	 Vida DIN 7991 Screw DIN 7991	 Vida DIN 7984 Screw DIN 7984	
LNU 50..	50	D-20-038	D02-23250	D-22-013	M5x10-8.8		
LNU 60.. X	60	D-20-068	D02-23250	D-22-013		M5x10-8.8	

Sipariş örneği 1 adet K-5-2-2°-R
Ordering example: 1 off K-5-2-2°-R

Anahtarsız teslim edilir
Delivery without key

	Sipariş kodu Ordering code	α	f	l	L	Stok Stock		Kesici uç Indexable inserts	Sayfa Pag
						R	L		
K-7...  Sol yan resim verilmiştir. Left hand version shown, right hand version mirrorlike.	K-7-2-0°-R/L	0°	50	82		●	●	LNU 70... X	15
	K-7-1-30°-R/L	30°	48	82		○	●		
	K-7-1-32°-R/L	32°	48	82		○	●		
		α_1/α_2	f	l	L				
K-.-. α_1/α_2-L  Sol yan resim verilmiştir. Left hand version shown, right hand version mirrorlike.	K-4-1-13°/30°-L	13°/30°	48	72		○		LNU 2009..	15
	K-5-1-13°/30°-L	13°/30°	48	72		○		LNNU 2512..	15
	K-5-1-10°/37,5°-L	10°/37,5°	46,9	72		●		LNNU 2512..	15
	K-6-1-10°/37,5°-L	10°/37,5°	46,9	72		○		LNNU 3012.. X	15

- Stoktan teslim On Stock
○ Sipariş üzerine (ayrıca özel açılı kartuşlar için) On request (and other chamfer angles)

Kartuş yedekleri Spare parts		Sipariş kodu Ordering code					
Kesici uç Indexable insert	Kesme boyu Cutting length	 Altlık Shim	 Levye Lever	 Altlık vidası Clamping screw	 Altlık pimi Shim pin	 Vida DIN 7984 Screw DIN 7984	
LNUX 70..	70	D-20-057	D02-23250	D-22-013		M5x10-8.8	
LNUX 2009..	40		D02-23250	D-22-013			
LNUX 2512..	50		D02-23250	D-22-013			
LNUX 30..	60		D02-23250	D-22-013			

Sipariş örneği 1 adet K-7-2-0°-L
Ordering example: 1 off K-7-2-0°-L

Anahtarsız teslim edilir
Delivery without key

Kalite Grade	ISO	Uygulama alanı Range of applications	Malzeme grupları Group of materials						Uygulama Application					
			P Çelik Steel	M Paslanmaz çelik Stainless	K Gri dökme demir Grey cast iron	N Demir dışı malzemeler Nonferrous metals	S Yüksek sıcaklığa dayanıklı malzemeler High temperature materials	H Sert malzemeler Hard materials	T Tornalama Turning	M Frezeleme Milling	D Kazıma Scarring	S Diş çekme Threading	G Kanal açma Grooving	P Kesme Parting
LC235C	HC-P35		■						●					
	HC-M35			□					●					
LC238H	HC-P38			■						●	●			
LC242W	HC-P40		■											●
	HC-M30			□										●
LCP37M	HC-P40		■											●
	HC-M40			□										●
LC442W	HC-P40		■											●
	HC-M40			□										●
BS225	HW-P25		■							●				
BS240	HW-P40		■							●	●			
BS430	HW-M30		■	□						●	●			
BC2165	HC-P15		■							●	●			
	HC-K15				□					●	●			
BC2245	HC-P25		■							●				
BC2250	HC-P25		■							●				
BC2295	HC-P25		■							●				
BC2420	HC-P40		■							●	●	●		
BC2425	HC-P 30		■							●		●		
	HC-M30			□						●		●		
BC2430	HC-P40		■							●				
BC2450	HC-P40		■								●			
BC2495	HC-P40		■							●	●			
BC2510	HC-P45		■							●	●			
BC4333	HC-M30		■	□						●		●		
BC4335	HC-M30		■	□							●	●		
BC4345	HC-M30		■	□							●	●		
BC4422	HC-M40		■	□						●	●	●		
BC4440	HC-M40		■	□							●			

Ana uygulama
Application peak

ISO 513'e göre uygulama alanı
Full range to ISO 513

■ Temel uygulama
Main application

□ İlave uygulamalar
Further applications

Standart kalite
Standard grade

Kod dönüşümü / Code conversion

Ti240=BC2425 / Ti44=BC2430 / BK355=BC2510 / BK525=BC2250 / BK540=BC2450 / BK540T=BC2420 / BK544=BC2410 / R421=BC2165 / VA431=BC4335
VA490=BC4422 / VA582=BC4440 / VA583=BC4345 / VA621=BC2245 / VA652=BC2495 / VA904=BC2295 / VA1071=BC4333

Boru dış çapı inç	Kesme Hızı m/dk	Devir rpm	İlerleme mm/dk min.	İlerleme mm/dk max.	Kesme Hızı m/dk	Devir rpm	İlerleme mm/dk min.	İlerleme mm/dk max.	Kesme Hızı m/dk	Devir rpm	İlerleme mm/dk min.	İlerleme mm/dk max.
Od pipe diameter inch	Cutting speed m/min.	Revolution r.p.m.	Feed mm/min min.	Feed mm/min max.	Cutting speed m/min.	Revolution r.p.m.	Feed mm/min min.	Feed mm/min max.	Cutting speed m/min.	Revolution r.p.m.	Feed mm/min min.	Feed mm/min max.
St37(B), Çelik Steel St37 (B)												
	Et kalınlığı, inç Wall thickness inch 0,375 / 0,500 / 0,625 / 0,750				Et kalınlığı, inç Wall thickness inch 0,875 / 1,000				Et kalınlığı, inç Wall thickness inch 1,250 / 1,500			
24	139,8	73	33	40	120,6	63	22	28				
26	139,0	67	30	37	120,3	58	20	26				
28	138,5	62	28	34	120,6	54	19	24				
30	138,8	58	26	32	119,7	50	17	22	100,5	42	10	15
32	140,4	55	25	30	120,0	47	16	21	99,6	39	10	14
34	138,4	51	23	28	119,4	44	15	20	100,4	37	9	13
36	140,8	49	22	27	120,7	42	14	19	100,5	35	9	12
38	139,5	46	21	26	118,3	39	13	17	100,1	33	8	12
40	140,4	44	20	24	118,1	37	13	17	98,9	31	8	11
42	140,8	42	19	23	120,6	36	13	16	100,5	30	7	10
44	140,4	40	18	22	119,4	34	12	15	98,3	28	7	10
46	139,5	38	17	21	121,1	33	12	15	99,1	27	7	9
48	137,9	36	16	20	118,7	31	11	14	99,6	26	6	9
50	139,6	35	16	19	119,7	30	10	13	99,7	25	6	9
52	141,0	34	15	19	120,3	29	10	12	99,6	24	6	8
54	137,9	32	14	18	120,6	28	10	12	99,1	23	6	8
56	138,5	31	14	17	120,6	27	9	12	98,3	22	5	8
58	138,8	30	13	17	120,3	26	9	12	97,2	21	5	7
60	138,8	29	13	16	119,7	25	9	11	96,0	20	5	7
62	138,5	28	13	15	118,7	24	8	11	98,9	20	5	7
64	137,9	27	12	15	117,5	23	8	10	97,0	19	5	7
St50 (x50), Çelik Steel St50 (X50)												
	Et kalınlığı, inç Wall thickness inch 0,375 / 0,500 / 0,625 / 0,750				Et kalınlığı, inç Wall thickness inch 0,875 / 1,000 / 1,250				Et kalınlığı, inç Wall thickness inch 1,500			
24	120,6	63	25	32	99,6	52	13	18				
26	120,3	58	23	29	99,6	48	12	17				
28	120,6	54	22	27	100,5	45	11	16				
30	119,7	50	20	25	100,5	42	10	15	81,4	34	8	12
32	120,0	47	19	24	99,6	39	10	14	79,2	31	8	11
34	119,4	44	18	22	100,4	37	9	13	81,4	30	7	10
36	120,7	42	17	21	100,5	35	9	12	80,4	28	7	10
38	118,3	39	16	20	100,1	33	8	12	81,9	27	7	9
40	118,1	37	15	19	98,9	31	8	11	79,8	25	6	9
42	120,6	36	14	18	100,5	30	7	10	80,4	24	6	8
44	119,4	34	14	17	98,3	28	7	10	80,7	23	6	8
46	121,1	33	13	17	99,1	27	7	9	80,7	22	5	8
48	118,7	31	12	16	99,6	26	6	9	80,4	21	5	7
50	119,7	30	12	15	99,7	25	6	9	79,8	20	5	7
52	120,3	29	12	15	99,6	24	6	8	78,8	19	5	7
54	120,6	28	11	14	99,1	23	6	8	81,9	19	5	7
56	120,6	27	11	14	98,3	22	5	8	80,4	18	4	6
58	120,3	26	10	13	97,2	21	5	7	78,7	17	4	6
60	119,7	25	10	13	96,0	20	5	7	81,4	17	4	6
62	118,7	24	10	12	98,9	20	5	7	79,2	16	4	6
64	117,5	23	9	12	97,0	19	5	7	81,7	16	4	6

Boru dış çapı inç	Kesme Hızı m/dk	Devir rpm	İlerleme mm/dk min.	İlerleme mm/dk max.	Kesme Hızı m/dk	Devir rpm	İlerleme mm/dk min.	İlerleme mm/dk max.	Kesme Hızı m/dk	Devir rpm	İlerleme mm/dk min.	İlerleme mm/dk max.
Od pipe diameter inch	Cutting speed m/min.	Revolution r.p.m.	Feed mm/min min.	Feed mm/min max.	Cutting speed m/min.	Revolution r.p.m.	Feed mm/min min.	Feed mm/min max.	Cutting speed m/min.	Revolution r.p.m.	Feed mm/min min.	Feed mm/min max.
St60 (X60), Çelik Steel St60 (X60)												
	Et kalınlığı, inç Wall thickness inch 0,375 / 0,500 / 0,625 / 0,750 / 0,875				Et kalınlığı, inç Wall thickness inch 1,000 / 1,250 / 1,500							
24	99,6	52	21	26	80,4	42	11	15				
26	99,6	48	19	24	80,9	39	10	14				
28	100,5	45	18	23	80,4	36	9	13				
30	100,5	42	16	21	81,4	34	8	12				
32	99,6	39	15	20	79,2	31	8	11				
34	100,4	37	14	19	81,4	30	7	10				
36	100,5	35	13	18	80,4	28	7	10				
38	100,1	33	12	17	81,9	27	7	9				
40	98,9	31	12	16	79,8	25	6	9				
42	100,5	30	11	15	80,4	24	6	8				
44	98,3	28	11	14	80,7	23	6	8				
46	99,1	27	11	14	80,7	22	5	8				
48	99,6	26	10	13	80,4	21	5	7				
50	99,7	25	10	13	79,8	20	5	7				
52	99,6	24	9	12	78,8	19	5	7				
54	99,1	23	9	12	81,9	19	5	7				
56	98,3	22	9	11	80,4	18	4	6				
58	97,2	21	8	11	78,7	17	4	6				
60	96,0	20	8	10	81,4	17	4	6				
62	98,9	20	8	10	79,2	16	4	6				
64	97,0	19	8	10	81,7	16	4	6				

**BÖHLER SERT MADEN VE
TAKIM SANAYİ VE TİCARET A.Ş.**

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