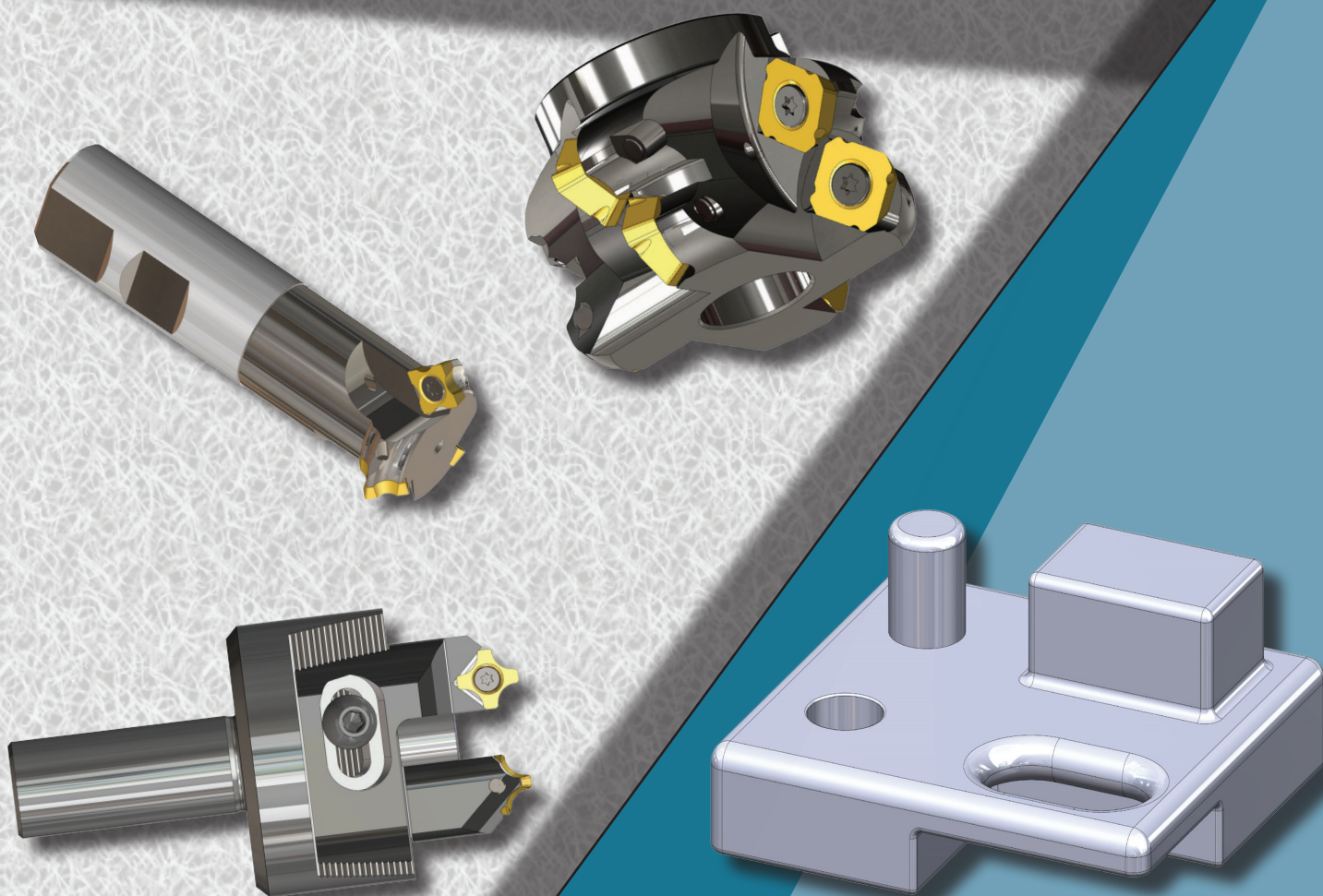


DAS THE RADIENPROGRAMM

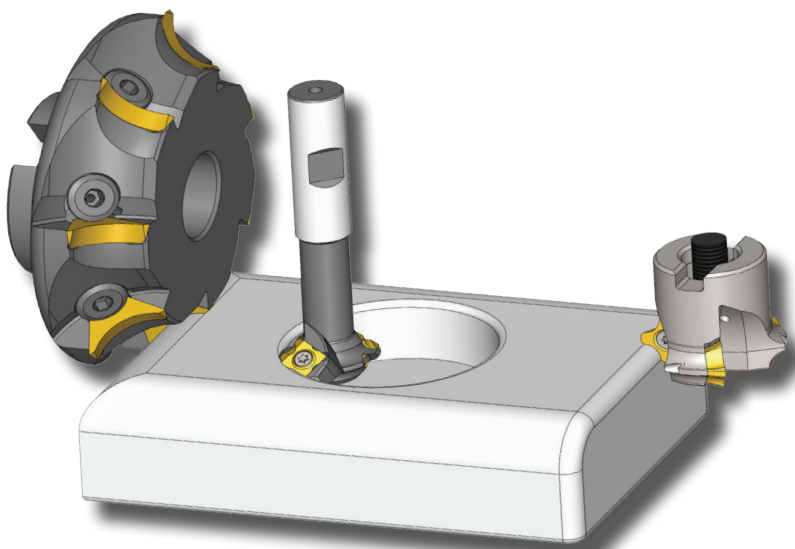
Serie 3016 - Serie 3017 - Serie 3018



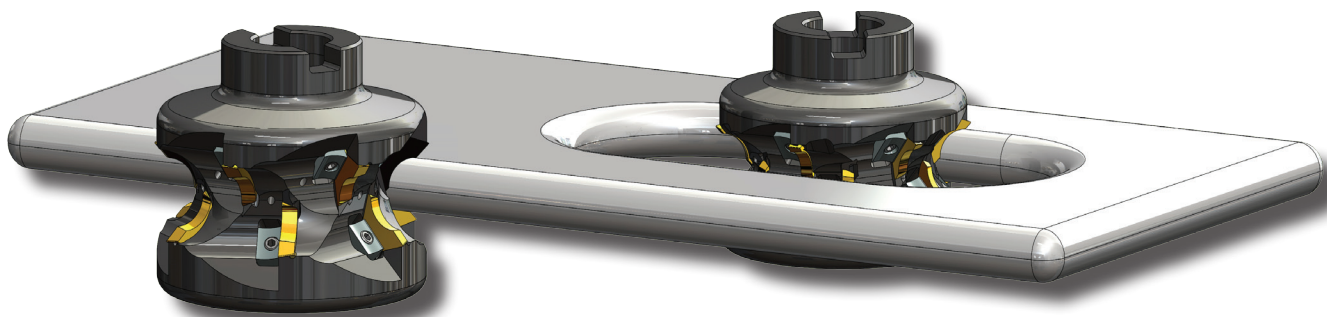
Anwendungen

applications

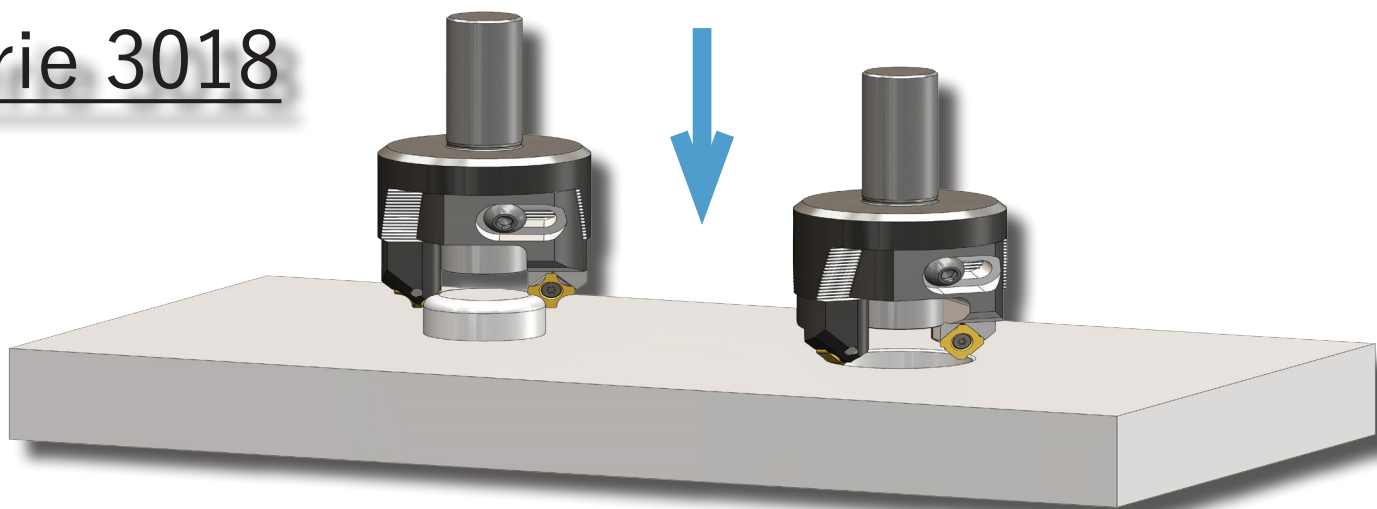
Serie 3016



Serie 3017

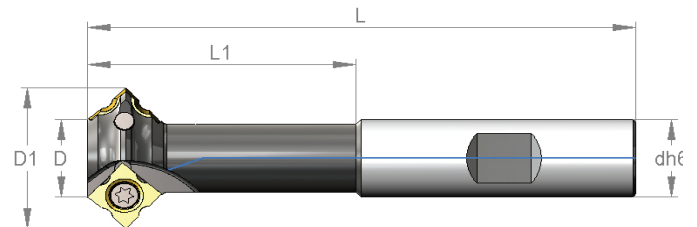
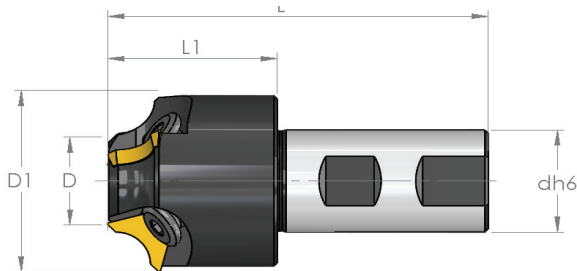


Serie 3018



Serie 3016 - Ausführungen

Serie 3016 - executions



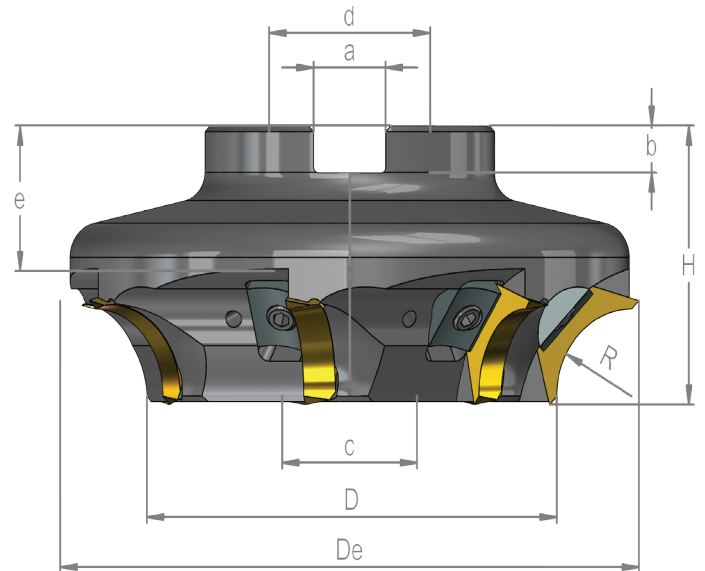
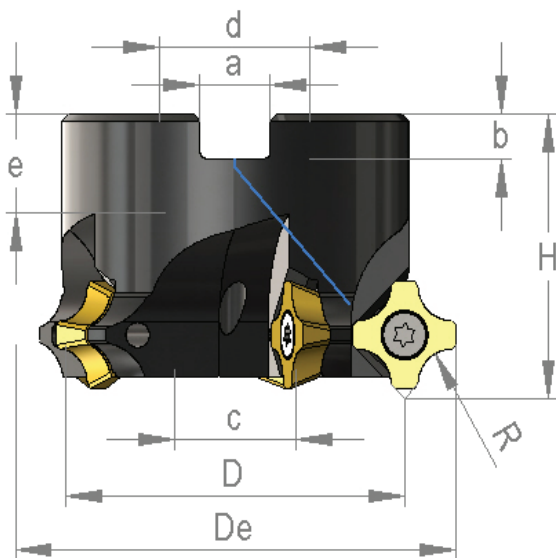
Order Code:		Dimension (mm)						Insert 	Screw 	Key 
		D	D1	L	L1	dh6	Z			
3016-012 W-W		12	23,7	100	50	16	1	SCXT 09T3 R..	M-VT40-6 3,0 Nm	M-BT15
3016-012 WL		12	23,7	200	50	16	1			
3016-016 W-W		16	28,8	100	50	16	2			
3016-016 WL		16	28,8	200	50	16	2			
3016-025 W-W		25	40,3	100	45	25	3			
3016-025 WL		25	40,3	200	45	25	3			
3016-025 W-W-12		25	40,5	100	45	25	3	SEXT 1204 R.. SEXT 1204 RR..	M-VT45 5,0 Nm	M-BT20
3016-025 WL-12		25	40,5	200	45	25	3			
3016-032 W-W		32	45	100	45	25	3			
3016-032 WL		32	45	200	45	25	3	XPKN 2204 R..	M-CVB55	M-CL2
3016-005 W-W		5	32,3	91	35	25	1			
3016-032 W-W-22		32	61	110	49	32	3			

Orderexample: 3016-012 W-W

W-W = coolant bores

Serie 3016 - Ausführungen

Serie 3016 - executions



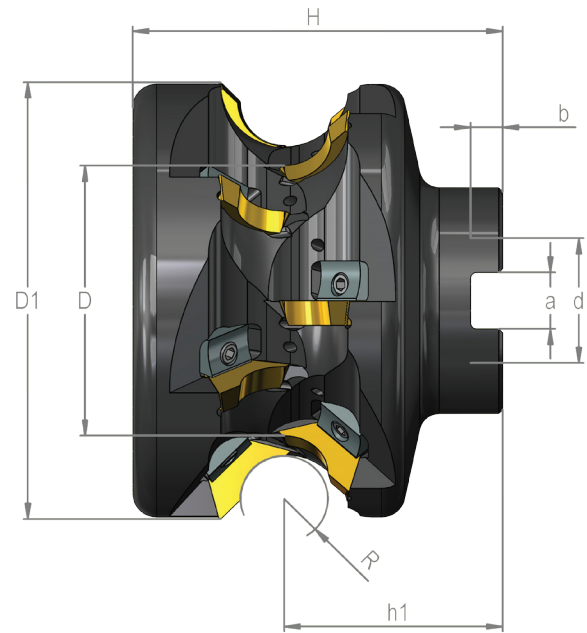
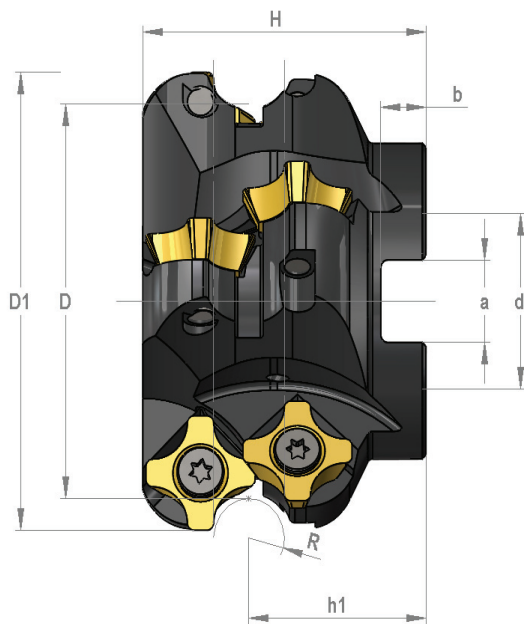
Order Code:		Dimension (mm)									Insert 	Screw 	Key 	clamping wedge
		D	De	d	c	e	a	b	H	Z				
3016 M-W D32		32	45	16	14	18	8,4	5,6	40	3	SEXT 1204 R.. SEXT 1204 RR..	M-VT45 5,0 Nm	M-BT20	
3016 M-W D40		40	53	16	14	18	8,4	5,6	40	4				
3016 M-W D50		50	63	22	18	20	10,4	6,3	48	5				
3016 M-W D63		63	92,5	22	18	20	10,4	6,3	48	6	XPKN 2204 R..	M-MS 1162	5003	M-SK 1355
3016 M-W D80		80	115,8	32	27	25	14,4	8	48	7	XPKN 3106 R..	M-MS 1162	5003	M-SK 1355

Orderexample: 3016 M-W D32

M-W = coolant bores

Serie 3017 - Ausführungen

Serie 3017 - executions



Order Code:		Dimension (mm)									Insert	Screw	Key	Clamping wedge
		D	D1	d	a	b	H	h1	Z	Zeff				
3017 M-W D50		50	61,7	22	10,4	6,3	40	25	8	4	SEXT 1204 R R.. SEXT 1204 L R..	M-VT45 5,0 Nm	M-BT20	
3017 M-W D80		80	105	32	14,4	8	75	50	12	6	XPKN 2204 R R.. XPKN 2204 L R..	M-MS 1162	5003	M-SK 1355
3017 M-W D80-31		80	112,7	32	14,4	8	85	55	12	6	XPKN 3106 R R.. XPKN 3106 L R..	M-MS 1162	5003	M-SK 1355

Orderexample: 3017 M-W D80 M-W = coolant bores

Delivery: including screws and clamping wedges

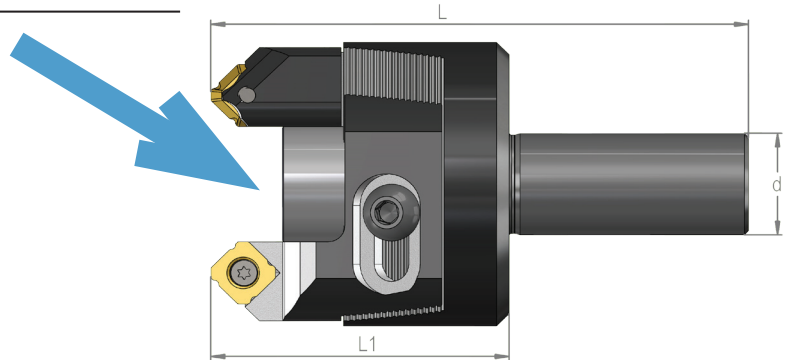
Serie 3018 - Ausführungen

Serie 3018 - executions

Adjustment cylinder for bores and pins

Assembly:

1. open cassettes
2. change cylinder to desired diameter
3. cassette on cylinder stop
4. tighten the cassette



Order Code:		Dimensions			Insert: 	screw: 	key: 	cassette: 
		L	L1	d				
3018 W-W D50		128	71	25	SEXT 1204 R R.. SEXT 1204 L R..	M-VT45 5,0 Nm	M-BT20	M-FN 450

Orderexample: 3018 W-W D50

Delivery incl. cassettes and screws

Execution:		Radius:	key:
3018 SI 25		R1 - R5	5004
3018 SI 26		R1 - R5	5004
3018 SI 27		R1 - R5	5004
3018 SI 28		R1 - R5	5004
3018 SI 29		R1 - R5	5004
3018 SI 30		R1 - R5	5004
3018 SI 31		R1 - R5	5004
3018 SI 32		R1 - R5	5004
3018 SI 33		R1 - R5	5004
3018 SI 34		R1 - R5	5004
3018 SI 35		R1 - R5	5004
3018 SI 36		R1 - R5	5004
3018 SI 37		R1 - R5	5004
3018 SI 38		R1 - R5	5004
3018 SI 39		R1 - R5	5004
3018 SI 40		R1 - R5	5004
3018 SI 41		R1 - R5	5004
3018 SI 42		R1 - R5	5004
3018 SI 43		R1 - R5	5004
3018 SI 44		R1 - R5	5004
3018 SI 45		R1 - R5	5004
3018 SI 46		R1 - R5	5004
3018 SI 47		R1 - R5	5004
3018 SI 48		R1 - R5	5004
3018 SI 49		R1 - R5	5004
3018 SI 50		R1 - R5	5004

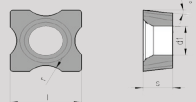
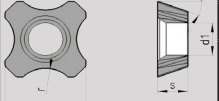
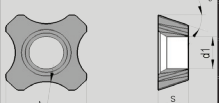
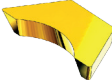
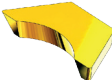
Orderexample: 3018 SI 36
Adjustment range bore Ø25-50

Execution:		Radius:	key:
3018 SA 18		R1 - R5	5004
3018 SA 19		R1 - R5	5004
3018 SA 20		R1 - R5	5004
3018 SA 21		R1 - R5	5004
3018 SA 22		R1 - R5	5004
3018 SA 23		R1 - R5	5004
3018 SA 24		R1 - R5	5004
3018 SA 25		R1 - R5	5004
3018 SA 26		R1 - R5	5004
3018 SA 27		R1 - R5	5004
3018 SA 28		R1 - R5	5004
3018 SA 29		R1 - R5	5004
3018 SA 30		R1 - R5	5004
3018 SA 31		R1 - R5	5004
3018 SA 32		R1 - R5	5004
3018 SA 33		R1 - R5	5004
3018 SA 34		R1 - R5	5004
3018 SA 35		R1 - R5	5004
3018 SA 36		R1 - R5	5004
3018 SA 37		R1 - R5	5004
3018 SA 38		R1 - R5	5004
3018 SA 39		R1 - R5	5004
3018 SA 40		R1 - R5	5004
3018 SA 41		R1 - R5	5004
3018 SA 42		R1 - R5	5004
3018 SA 43		R1 - R5	5004

Orderexample: 3018 SA 28
Adjustment range pin Ø18-43

Wendeplatten

Inserts

	Form Figure	Dimensions					Designation	screw	key		coated grades					
		l	d	s	d1	r					PTT20	PTV28	PTT35	PAP28	MTM10	KTE20
 SCXT ..		9,52		3,97		1,0	SCXT 09T3 R1	M-VT40-6	M-BT 15			■	■	■		■
		9,52		3,97		2,0	SCXT 09T3 R2	M-VT40-6	M-BT 15			■	■	■		■
		9,52		3,97		3,0	SCXT 09T3 R3	M-VT40-6	M-BT 15			■		■		■
 SEXT ..		12,70		4,76		1,0	SEXT 1204 R1	M-VT 45	M-BT 20			■	■	■		■
		12,70		4,76		2,0	SEXT 1204 R2	M-VT 45	M-BT 20			■	■	■		■
		12,70		4,76		3,0	SEXT 1204 R3	M-VT 45	M-BT 20			■	■	■		■
		12,70		4,76		4,0	SEXT 1204 R4	M-VT 45	M-BT 20			■	■	■		■
		12,70		4,76		5,0	SEXT 1204 R5	M-VT 45	M-BT 20			■	■	■		■
		12,70		4,76		1,0	SEXT 1204 RR1	M-VT 45	M-BT 20		■	■	■		■	
		12,70		4,76		2,0	SEXT 1204 RR2	M-VT 45	M-BT 20		■	■	■		■	
		12,70		4,76		3,0	SEXT 1204 RR3	M-VT 45	M-BT 20		■	■	■		■	
		12,70		4,76		4,0	SEXT 1204 RR4	M-VT 45	M-BT 20		■	■	■		■	
		12,70		4,76		5,0	SEXT 1204 RR5	M-VT 45	M-BT 20		■	■	■		■	
 SEXT ..		12,70		4,76		1,0	SEXT 1204 L R1	M-VT 45	M-BT 20			■	■	■		■
		12,70		4,76		2,0	SEXT 1204 L R2	M-VT 45	M-BT 20			■	■	■		■
		12,70		4,76		3,0	SEXT 1204 L R3	M-VT 45	M-BT 20			■	■	■		■
		12,70		4,76		4,0	SEXT 1204 L R4	M-VT 45	M-BT 20			■	■	■		■
		12,70		4,76		5,0	SEXT 1204 L R5	M-VT 45	M-BT 20			■	■			■
 XPKN ..		21,00		4,76		6,0	XPKN 2204 R R6					□	■			□
		21,00		4,76		7,0	XPKN 2204 R R7					□	■			□
		21,00		4,76		8,0	XPKN 2204 R R8					□	■			□
		21,00		4,76		10,0	XPKN 2204 R R10					□	■			□
		25,35		6,35		11,0	XPKN 3106 R R11						■	□		
		25,35		6,35		12,0	XPKN 3106 R R12						■	□		
		25,35		6,35		13,0	XPKN 3106 R R13						■	□		
		25,35		6,35		14,0	XPKN 3106 R R14						■	□		
		25,35		6,35		15,0	XPKN 3106 R R15						■	□		
 XPKN ..		21,00		4,76		6,0	XPKN 2204 L R6					□	■			□
		21,00		4,76		7,0	XPKN 2204 L R7					□	■			□
		21,00		4,76		8,0	XPKN 2204 L R8					□	■			□
		21,00		4,76		10,0	XPKN 2204 L R10					□	■			□
		25,35		6,35		11,0	XPKN 3106 L R11						■	□		
		25,35		6,35		12,0	XPKN 3106 L R12						■	□		
		25,35		6,35		13,0	XPKN 3106 L R13						■	□		
		25,35		6,35		14,0	XPKN 3106 L R14						■	□		
		25,35		6,35		15,0	XPKN 3106 L R15						■	□		

For machining on pins: Left-hand indexable insert
For machining on bores: Right-hand indexable insert

TYP 3016 - 3017

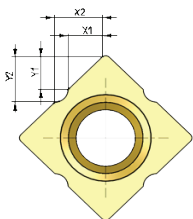
Vc (m/min)																			Öl	Emulsion	MMS	Trocken	Druckluft	
	Alu Kunst- stoff	Alu	Alu Guss	Stahl < 500 N	Stahl < 750 N	Stahl < 900 N	Stahl < 1100 N	Stahl < 1400 N	Stahl < 55 HRC	Stahl < 60 HRC	Stahl < 65 HRC	Stahl < 67 HRC	Stahl < 70 HRC	INOX < 900 N	INOX > 900 N	GG(G)	TITAN	Graphit GFK CFK						
ISO-Code	N	N	N	P	P	P	P	P	H	H	H	H	H	M	M	K	S	N						
PTV28					180	180	160	120													■		■	
PTT35					180	180	160	120						120	100					■			■	
PAP28																								
MTM10																	140						■	
KTE20	400	400	300																		■		■	
K10																								
fz	0,1-0,15																		 geeignet  bedingt geeignet					

TYP 3018

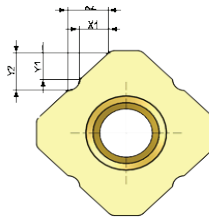
Vc (m/min)																			Öl	Emulsion	MMS	Trocken	Druckluft		
	Alu Kunst- stoff	Alu	Alu Guss	Stahl < 500 N	Stahl < 750 N	Stahl < 900 N	Stahl < 1100 N	Stahl < 1400 N	Stahl < 55 HRC	Stahl < 60 HRC	Stahl < 65 HRC	Stahl < 67 HRC	Stahl < 70 HRC	INOX < 900 N	INOX > 900 N	GG(G)	TITAN	Graphit GFK CFK							
	N	N	N	P	P	P	P	P	H	H	H	H	H	M	M	K	S	N							
					180	180	160	120													■		■		
					180	180	160	120						120	100						■		■		
																140							■		
	400	400	300																		■		■		
	0,05-0,08																				■ geeignet	 bedingt geeignet			

Depending on the application condition, the cutting data can be corrected upwards or downwards.

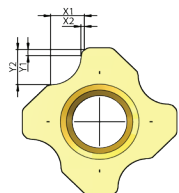
Parameter / parameters



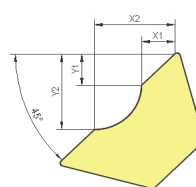
	X1	X2	Y1	Y2
SCXT 09T3 R1	2,59	3,59	2,59	3,59
SCXT 09T3 R2	2,09	4,09	2,09	4,09
SCXT 09T3 R3	1,59	4,59	1,59	4,59



	X1	X2	Y1	Y2
SEXT 1204 R1	2,49	3,49	2,49	3,49
SEXT 1204 R2	1,99	3,99	1,99	3,99
SEXT 1204 R3	1,49	4,49	1,49	4,49
SEXT 1204 R4	0,99	4,99	0,99	4,99
SEXT 1204 R5	0,49	5,49	0,49	5,49



	X1	X2	Y1	Y2
SEXT 1204 RR1	0,34	1,34	0,63	1,63
SEXT 1204 RR2	0,34	2,34	0,63	2,63
SEXT 1204 RR3	0,34	3,34	0,63	3,63
SEXT 1204 RR4	0,34	4,34	0,63	4,63
SEXT 1204 RR5	0,34	5,34	0,63	5,63



	X1	X2	Y1	Y2
XPKN 2204 R6	4,26	10,26	4,26	10,26
XPKN 2204 R7	3,76	10,76	3,76	10,76
XPKN 2204 R8	3,26	11,26	3,26	11,26
XPKN 2204 R10	2,26	12,26	2,26	12,26
XPKN 3106 R11	3,46	14,46	3,46	14,46
XPKN 3106 R12	2,96	14,96	2,96	14,96
XPKN 3106 R13	2,46	15,46	2,46	15,46
XPKN 3106 R14	1,96	15,96	1,96	15,96
XPKN 3106 R15	1,46	16,46	1,46	16,46