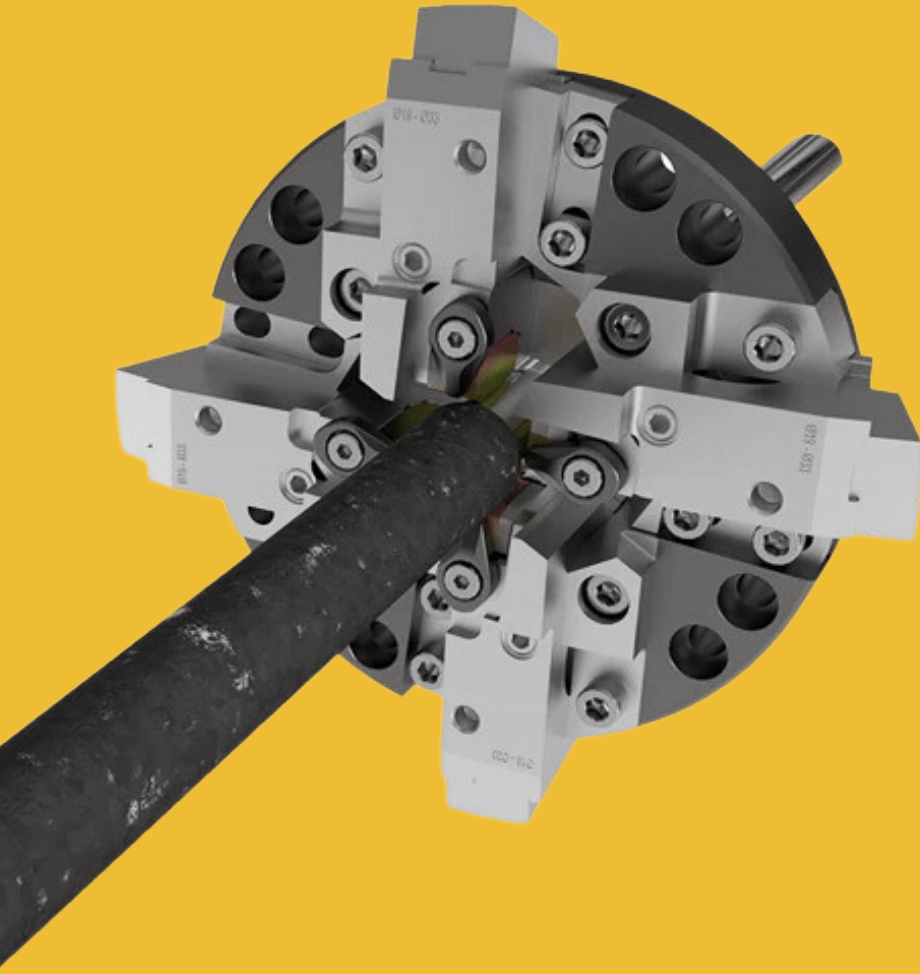




KABUK SOYMA UÇLARI BAR PEELING INSERTS

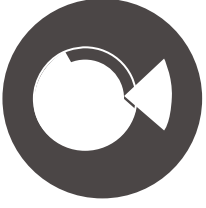
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 **EUROLOY**
CARBIDE TOOLS

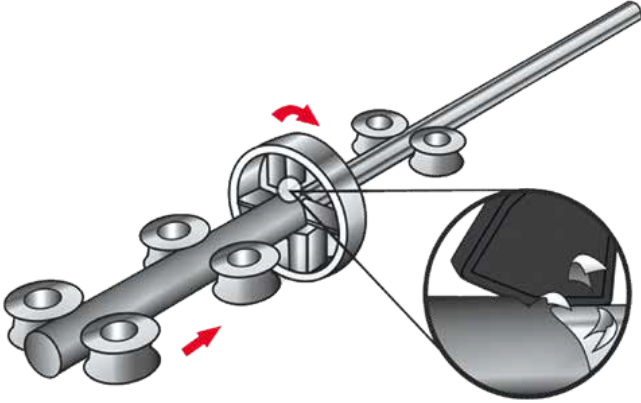
KABUK SOYMA UÇLARI

BAR PEELING INSERT



Kabuk soyulma, ham dövme bir boşluğun işleme yoluyla cilalı bir çubuğa dönüştürüldüğü işlemdir. Bu soyulma süreci sırasında yüzey çatlakları ve oksit tabakaları giderilir, böylece çubuğa mükemmel bir yuvarlaklık kazandırılır ve iyi bir yüzey ve boyut hassasiyeti sağlanır. Bu araçlarla işlenebilen malzemelerin yelpazesi geniştir ve tüm çeşitli çelik türlerinden dökme demir parçalara kadar uzanır.

Bar peeling is the machining process by which a raw forged blank is converted into a polished bar. During this peeling process, surface cracks and oxide layers are removed giving a perfect roundness with good surface and dimensional accuracy to the bar. The range of materials that can be machined with these tools is vast and goes from all kind of steels to cast iron parts.



İşlenmemiş çubuğun çapı 4mm'den başlayıp 400 mm'in üzerine çıkabilir.

The size of blank bar can go from 4 mm (157 inch) to over 400 mm (15.75 inch) in diameter.

Yüzey kalitesi ve boyutsal toleranslar da yüksektir, bu da daha sonraki aşamalarda daha az işleme gereksinimi doğurur.

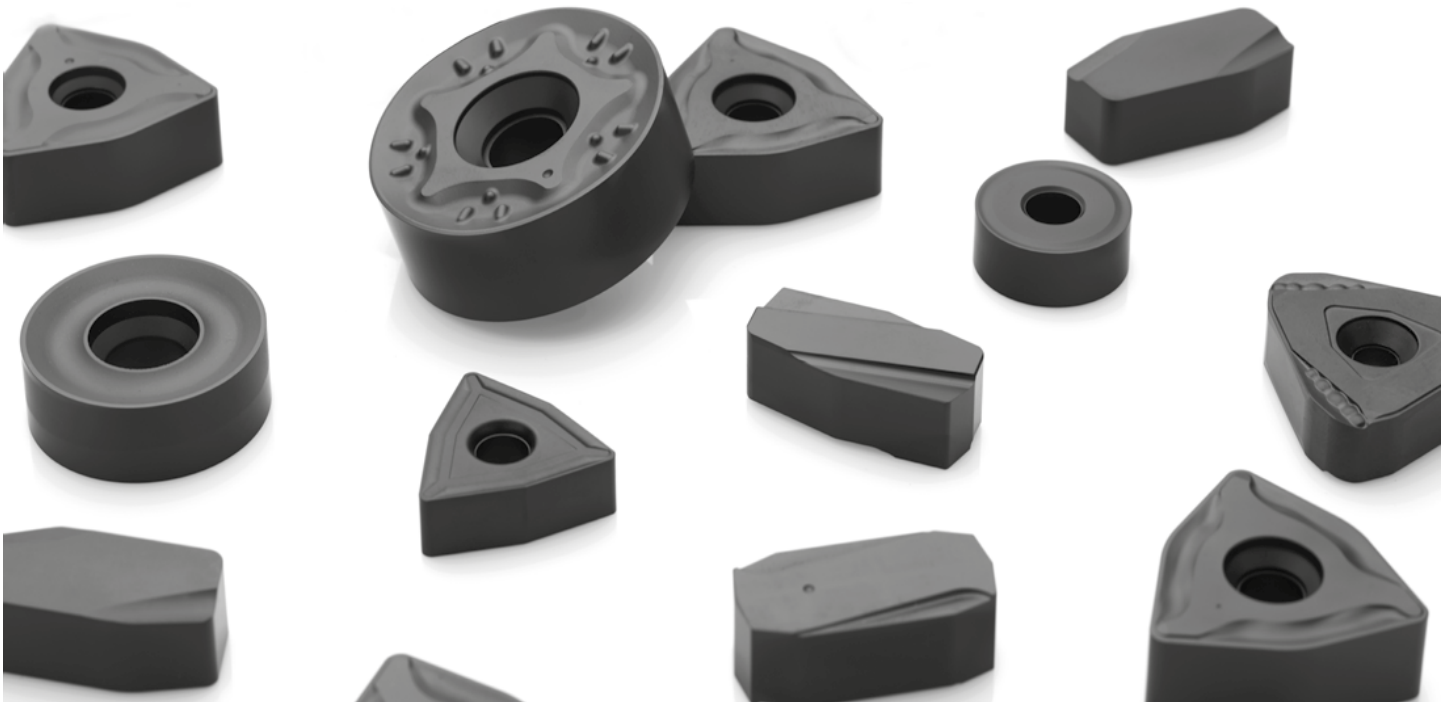
The surface quality and dimensional tolerances are also high, which leads to less machining at later stages.

Amacımız, aynı zamanda üretkenliğinizi artırmak (maksimum talaş hacmini kaldırarak) ve aynı zamanda yüzey kalite gereksinimlerinizi karşılamak veya aşmaktır. Bu nedenle bar soyulma programımız, her müşteri ihtiyacına özel standart araçları ve aynı zamanda özel özel çözümleri içeren geniş bir yelpazeyi kapsar.

Bu broşür, üretim olanaklarımızın sadece küçük bir bölümünü içermektedir. Lütfen bu broşürde sunulmayan diğer olası geometrilerle ilgili olarak bizimle iletişime geçmekten çekinmeyin.

Our aim is at the same time improving your productivity (by removing maximal chips volume) and at the same time attending or surpassing your surface quality requirements. This is why our bar peeling program is vast comprising both standard tools and also special custom-made solutions to every customer needs.

This flyer has only a small portion of our possible range of production. Please don't hesitate to contact us regarding other possible geometries that we may have although not presented in this brochure.



KABUK SOYMA UÇLARI

BAR PEELING INSERT



KOD ANAHTAR
CODE KEY

L	N	G	F	20	10	35	-	PM
1	2	3	4	5	6	7		8

1 - Uç Şekli / Insert Shape

I	J	L	R	S
T	U	W	X	

3 - Tolerans / Tolerances

sembol symbol	m (mm)	d (mm)	s (mm)
A	±0.005	±0.025	±0.025
F	±0.005	±0.013	±0.025
C	±0.013	±0.025	±0.025
H	±0.013	±0.013	±0.025
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
J	±0.005	±0.05~±0.13	±0.025
K*	±0.013	±0.05~±0.13	±0.025
L*	±0.025	±0.05~±0.13	±0.025
M*	±0.08~±0.20	±0.05~±0.13	±0.13
N*	±0.08~±0.20	±0.05~±0.13	±0.025
U*	±0.13~±0.38	±0.08~0.25	±0.13

*Kural olarak, bu kesici uçların kenarları sinterlenmiştir.
Tolerans kesici uç boyutuna göre değişir, m sınıfının doğruluğu için sağdaki tabloya bakın.
As a rule the sides of these inserts are as sintered.
Tolerance differs with insert size, for the accuracy of class m, refer to the table on the right

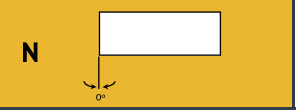
8 - Talaş Kırıcı / Chip Breaker

Palbit geometrilerine göre talaş kırıcı Chip breaker according to Palbit geometries	
PF	HM
KF	RR
PM	HL

4 - Uç Tipi / Insert type

sembol symbol	Tip Type	Delik Tipi Type of hole	Talaş Kırıcı Chipbreaker	Şekil Shape
W	Delikli With hole	Yuvarlak delik Bir havşa Round hole one countersink (40°~60°)	Talaş Kırıcı olmadan Without chipbreaker	
T	Delikli With hole		Tek taraflı talaş kırıcı Chipbreaker on one side	
Q	Delikli With hole	Yuvarlak delik Bir havşa Round hole one countersink (40°~60°)	Talaş Kırıcı olmadan Without chipbreaker	
U	Delikli With hole		Çift taraflı talaş kırıcı Chipbreaker on both sides	
B	Delikli With hole	Yuvarlak delik Bir havşa Round hole one countersink (70°~90°)	Talaş Kırıcı olmadan Without chipbreaker	
H	Delikli With hole		Tek taraflı talaş kırıcı Chipbreaker on one side	
C	Delikli With hole		Talaş Kırıcı olmadan Without chipbreaker	
J	Delikli With hole		Çift taraflı talaş kırıcı Chipbreaker on both sides	
A	Delikli With hole	Yuvarlak delik Bir havşa Round hole one countersink	Talaş Kırıcı olmadan Without chipbreaker	
M	Delikli With hole		Tek taraflı talaş kırıcı Chipbreaker on one side	
G	Delikli With hole		Çift taraflı talaş kırıcı Chipbreaker on both sides	
N	Deliksiz Without hole	--	Talaş Kırıcı olmadan Without chipbreaker	
R	Deliksiz Without hole	--	Tek taraflı talaş kırıcı Chipbreaker on one side	
F	Deliksiz Without hole	--	Çift taraflı talaş kırıcı Chipbreaker on both sides	
X	-	-	--	İstek üzerine On request

2 - Boşluk Açısı Clearance Angle



5 - Kesici Kenar Uzunluğu (In) Length of Cutting Edge (In)

İkincil kesme kenarının uzunluğu mm olarak belirtilir. The length of the secondary cutting edge is indicated in mm	
13 mm	25 mm
14 mm	27 mm
15 mm	28 mm
17 mm	38 mm
20 mm	44 mm
22 mm	50 mm

6 - Kalınlık / Thickness (S)

İkincil kesme kenarının uzunluğu mm olarak belirtilir. The length of the secondary cutting edge is indicated in mm	
08 = 8,00 mm	
09 = 9,52 mm	
10 = 10,00 mm	
12 = 12,00 mm	
12 = 12,70 mm	
13 = 13,00 mm	
14 = 14,00 mm	
18 = 18,00 mm	

7 - Talaş Derinliği Depth of Cut (ap)

Maksimum kesme derinliği Maximum depth of cut	
20 = 2,00 mm	
25 = 2,50 mm	
35 = 3,50 mm	
40 = 4,00 mm	
80 = 8,00 mm	

KABUK SOYMA UÇLARI

BAR PEELING INSERT

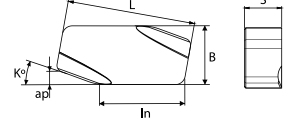
Uç Çeşitleri

Inserts Range



INGR Dikdörtgen 90° Negatif

INGR Rectangular 90° Negative



			P		M		K		Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
	Kalite Kodu Grade Code		L7	L8	L8	P1	L6		L	In	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P		L	In	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	INGR 221240-PM	INGR 221240-PM	⊗	○	○	○	○		38,25	22,00	17,5	12,00	4,00	20,00	2,00	0,40	4,00	3,50	1,00	8,00

⊗ Stok Var-İlk Tercih
Stock Item-First Choice

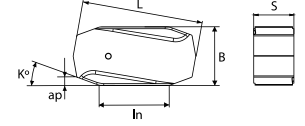
⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request



JNGF Dikdörtgen 90° Negatif

JNGF Rectangular 90° Negative



			P		M		K		Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
	Kalite Kodu Grade Code		L7	L8	L8	P1	L6		L	In	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P		L	In	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	JNGF 201220-PM	JNGF 201220-PM	○	⊗	⊗				36,90	20,00	18,00	12,35	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00
	JNGF 201220-PM SP1	JNGF 201220-PM SP1	○						36,30	20,00	18,00	12,45	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00
	JNGF 201220-PM SP2	JNGF 201220-PM SP2	⊗	⊗	⊗				36,50	20,00	18,00	12,45	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00
	JNGF 271220-PM	JNGF 271220-PM	○						36,90	27,00	18,00	12,45	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00

⊗ Stok Var-İlk Tercih
Stock Item-First Choice

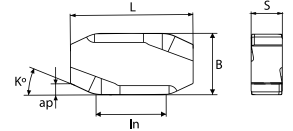
⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request



LNGF Dikdörtgen 90° Negatif

LNGF Rectangular 90° Negative



			P		M		K		Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
	Kalite Kodu Grade Code		L7	L8	L8	P1	L6		L	In	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P		L	In	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	LNGF 201035-PM	LNGF 201035-PM	⊗	○	○	○	○		40,00	20,00	20,00	10,00	3,50	25	2,00	0,80	3,50	2,50	1,00	6,50
	LNGF 201235-PM	LNGF 201235-PM	⊗	○	○	○	○		40,00	20,00	20,00	12,00	3,50	25	2,00	0,80	3,50	2,50	1,00	6,50

⊗ Stok Var-İlk Tercih
Stock Item-First Choice

⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request

KABUK SOYMA UÇLARI

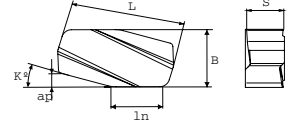
BAR PEELING INSERT

Uç Çeşitleri

Inserts Range

UNGF Dikdörtgen 90° Negatif

UNGF Rectangular 90° Negative



			P		M		K		Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
	Kalite Kodu Grade Code		L7	L8	L8	P1	L6													
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P	L	ln	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max	
	UNGF 171240-PM	UNGF 171240-PM	○	⊗	⊗	○	○	36,50	17,00	18,00	12,00	4,00	15	1,50	0,35	4,00	2,00	1,00	5,00	

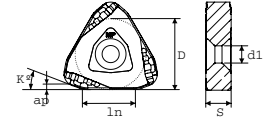
⊗ Stok Var-İlk Tercih
Stock Item-First Choice

⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request

TNMJ Üçgensel 60° Negatif

TNMJ Triangular 60° Negative



			P		M		K	Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
	Kalite Kodu Grade Code		L7	L8	L8	P1	L6												
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P	L	ln	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	TNMJ 201025-PM	TNMJ 201025-PM	○	⊗	⊗	○	○	28,60	20,00	10,00	7,00	2,50	20	1,00	0,70	2,50	3,00	1,00	5,50
	TNMJ 201425-PM	TNMH 2015425-PM	○	⊗	⊗	○	○	28,60	20,00	14,00	7,00	2,50	20	1,00	0,70	2,50	3,00	1,00	5,50

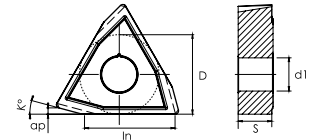
⊗ Stok Var-İlk Tercih
Stock Item-First Choice

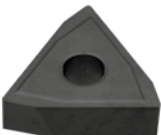
⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request

TNGM Üçgensel 60° Negatif

TNGM Triangular 60° Negative



			P		M		K	Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
			L7	L8	L8	P1	L6												
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P	L	ln	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	TNGM 220812-PM	TNGM 220812-PM	○	⊗	⊗	○	○	19,05	22,00	8,00	7,96	1,20	15	0,70	0,20	1,30	14,00	5,00	18,00

⊗ Stok Var-İlk Tercih
Stock Item-First Choice

⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request

KABUK SOYMA UÇLARI

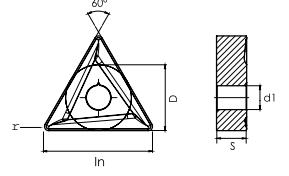
BAR PEELING INSERT

Uç Çeşitleri

Inserts Range

TNMM Üçgensel 60° Negatif

TNMM Triangular 60° Negative



			P		M		K	Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
	Kalite Kodu Grade Code		L7	L8	L8	P1	L6												
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P	L	In	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	TNMM 441116-HL	TNMM 441116-HL	○	⊗	⊗	○	○	25,40	44,00	11,35	9,20	1,60	-	12,00	2,00	25,00	0,80	0,50	1,60

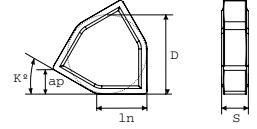
⊗ Stok Var-İlk Tercih
Stock Item-First Choice

⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request

XNGF Özel 85° Negatif

XNGF Special 85° Negative



			P		M		K	Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
	Kalite Kodu Grade Code		L7	L8	L8	P1	L6												
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P	L	In	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	XNGF 150980-PF	XNGF 150980-PF	○	○	○	⊗	○	28,58	15,00	8,88	-	8,00	30	3,00	1,00	4,50	6,00	4,00	12,00

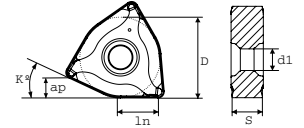
⊗ Stok Var-İlk Tercih
Stock Item-First Choice

⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request

XNMJ Özel 85° Negatif

XNMJ Special 85° Negative



			P		M		K	Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
	Kalite Kodu Grade Code		L7	L8	L8	P1	L6												
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P	L	In	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	XNMJ 151380-PM	XNMJ 151380-PM	○	⊗	⊗	⊗	○	31,75	15,00	13,00	9,00	8,00	25	3,00	1,00	6,50	6,00	4,00	12,00
	XNMJ 151380-HM	XNMJ 151380-HM	○	⊗	⊗	⊗	○	31,75	15,00	13,00	9,00	8,00	25	3,00	1,00	6,50	6,00	4,00	12,00

⊗ Stok Var-İlk Tercih
Stock Item-First Choice

⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request

KABUK SOYMA UÇLARI

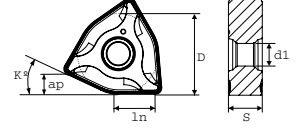
BAR PEELING INSERT

Uç Çeşitleri

Inserts Range

XNGJ Özel 85° Negatif

XNGJ Special 85° Negative



			P		M		K	Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
			L7	L8	L8	P1	L6												
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P	L	ln	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	XNGJ 151380-RR	XNGJ 151380-RR	○	○	○	⊗	○	31,75	15,00	13,00	9,00	8,00	25	3,00	1,00	6,50	6,00	4,00	12,00

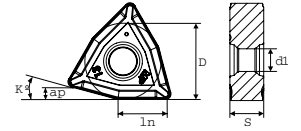
⊗ Stok Var-İlk Tercih
Stock Item-First Choice

⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request

WNGJ Özel 75° Negatif

WNGJ Special 75° Negative



			P		M		K	Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
			L7	L8	L8	P1	L6												
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P	L	ln	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	WNGJ 130950-PM	WNGJ 130950-PM						22,23	13,00	9,56	7,93	5,00	15	3,00	0,50	5,00	6,00	3,00	11,00

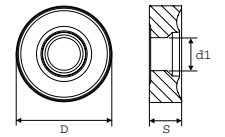
⊗ Stok Var-İlk Tercih
Stock Item-First Choice

⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request

RNMX Yuvarlak R° Negatif

RNMX Round R° Negative



			P		M		K	Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions					
			L7	L8	L8	P1	L6												
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P	L	ln	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	RNMX 318200-PM	RNMX 381200-PM	○	○	○	⊗	○	38,10	-	12,70	13,00	-	-	4,00	2,00	8,00	2,00	1,00	4,00
	RNMX 5018MO-PM	RNMX 5018MO-PM	○	○	○	⊗	○	50,00	-	18,00	12,70	-	-	6,00	2,00	12,00	3,50	2,50	6,50
	RNMX 5018MO-RR	RNMX 5018MO-RR	○	○	○	⊗	○	5,00	-	18,00	12,70	-	-	6,00	2,00	12,00	6,00	4,00	10,50

⊗ Stok Var-İlk Tercih
Stock Item-First Choice

⊗ Stok Var
Stock Item

○ Talep üzerine mevcuttur
Available under request

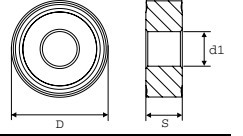
KABUK SOYMA UÇLARI

BAR PEELING INSERT

Uç Çeşitleri

Inserts Range

 RNMG Round R° Negatif
RNMG Yuvarlak R° Negatif



			P	M	K	Boyut Dimensions (mm)						Kesme Koşulları Cutting Conditions							
	Kalite Kodu Grade Code		L7	L8	L8													P1	L6
	ISO Referans ISO Reference	ANSI Referans ANSI Reference	TCT115P	TCT125P	TCT125	TCT228P	TCT220P	L	In	B	S	ap	K	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	RNMG 250900-KF	RNMG 860-KF	○	○	○	○	⊗	25,40	-	9,52	9,12	-	-	5,00	2,50	10,00	1,00	0,25	2,50

 Stok Var-İlk Tercih
Stock Item-First Choice

 Stok Var
Stock Item

 Talep üzerine mevcuttur
Available under request



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