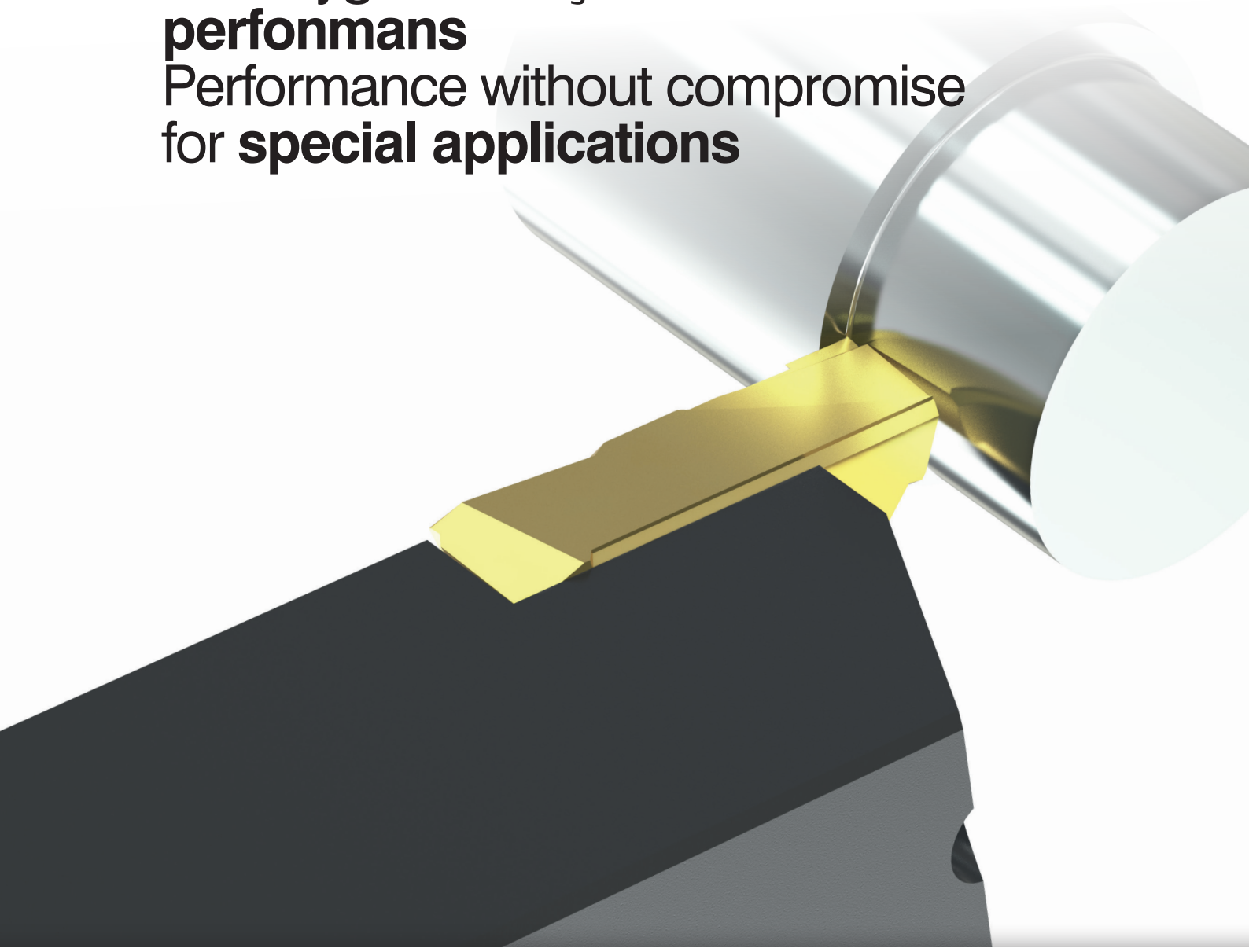
SIMTEK

En Yüksek
Talepler için
Makine Takımları

Özel uygulamar için **mükemmel perfonmans**
Performance without compromise for **special applications**



simturnFX
SIMTEK small part machining type FX

R20 TR-Edition

SIMTEK

En Yüksek
Talepler için
Makine Takımları

İletişim // Contact

Simtek İth. İhr. San. ve Tic. Ltd. Şti.
Yolören Mh 879. Sk No: 3
TR- 10300 Edremit / Balıkesir

Telefon +90 266 376 11 61
Fax +90 266 376 12 34
E-posta sales.tr@simtek.com
Web www.simtek.com/turkiye

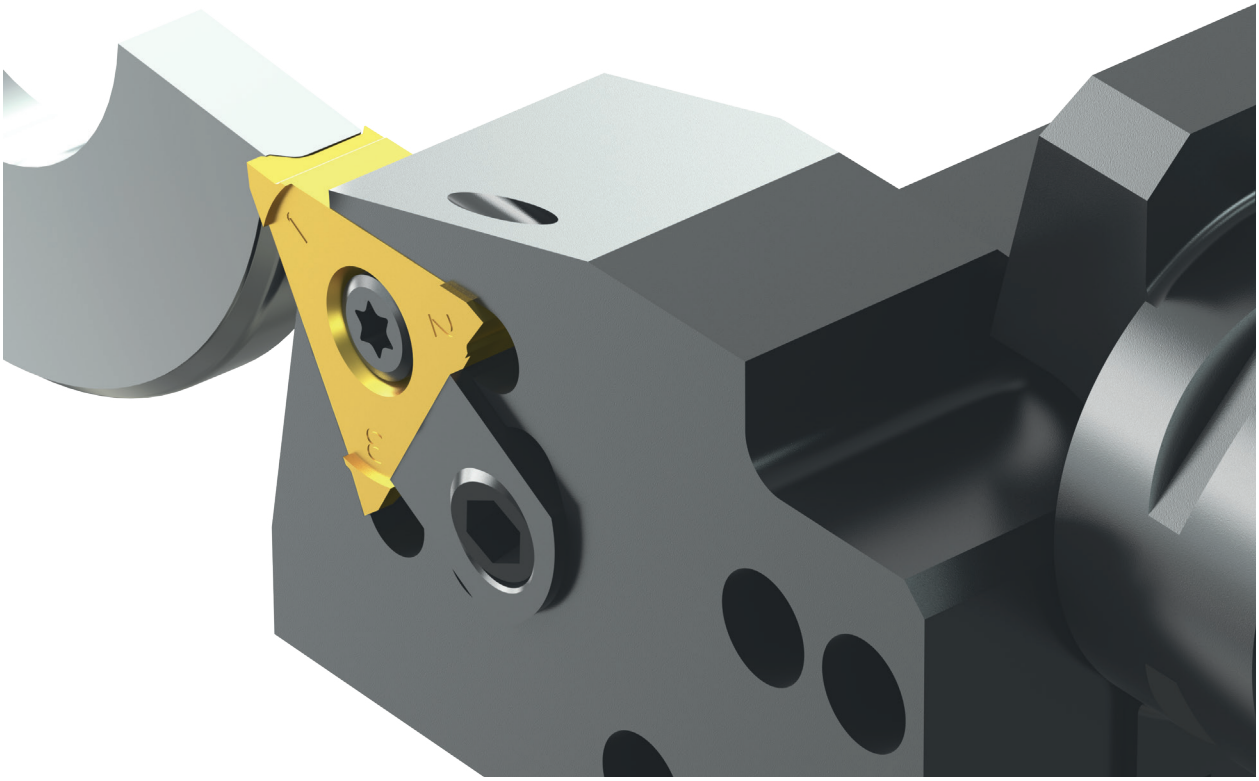
© 2020 SIMTEK AG | Christophstraße 18 | DE-72116 Mössingen | fon +49 7473 9517 - 100 | fax +49 7473 9517 - 77 | mail sales@simtek.com

simturn, simcut ve simmill SIMTEK AG nin Türkiye'de, Avrupa Birliğinde ve ABD'de tescilli ticari markalarıdır. SIMTEK, SIMTEK AG'nin Türkiye'de, Avrupa Birliğinde, ABD'de, Singapur'da ve Filipinlerde tescilli ticari markasıdır. Tüm hakları saklıdır. SIMTEK AG ya da bağlı firmaları katalog içerisinde yer alan bilgilerin doğruluğunu garanti etmemektedir. Kataloğun veya içerisinde yer alan bilgilerin, kısmen yahut tamamen kullanmak, yazılı izne tabi olup aksi halde ilgililer hakkında yasal yollara başvurulacaktır. Standart ürünlerimiz için güncelleme, düzenleme ve ilave yapabilme hakkımız saklıdır.// simturn, simcut and simmill are registered trademarks of SIMTEK AG in the European Union, Turkey and USA. SIMTEK is a registered trademark of SIMTEK AG in the European Union, Turkey, USA, Singapore and the Philippines. All rights reserved. SIMTEK AG or its affiliates do not guarantee the accuracy of the information in the catalogue. Using the catalogue or the information in it partly or wholly can only be done with a written consent, otherwise legal action will be taken against those concerned. We reserve the right to update, edit and make amendments for our standard products. „QR Code" is a registered trademark of DENSO WAVE INCORPORATED.

Takım sistemine genel bakış
The Tool System Overview

Lütfen sayfadaki genel kullanım talimatlarını okuyun
Please read the general instructions for use on page 33

Özel uygulamalar için mükemmel performans
Performance without compromise for special applications



Standart kesici uçları 5. sayfadan itibaren bulabilirsiniz // Standard cutting inserts as of page 5

simturn FX takım sistemi, en yüksek hassasiyet, tekrarlanabilirlik ve performansa yönelik özel istekleriniz için ilk tercihtir.

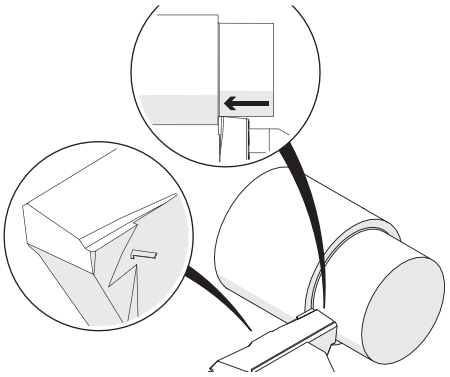
Standart ve özel uygulamalar için üç kesicili, hassas taşlanmış ve değiştirilebilir karbür kesici uçlar. Çok çeşitli standart takım tutucuların yanısıra ihtiyaçlarınız doğrultusunda size özel takım sistemleri.

These systems are the first choice for individual needs towards highest precision, repeatability, performance and stability without compromise.

Triple-edged, fully ground and indexable carbide cutting insert for standard and special applications. Wide range of standard toolholders and a matching special solution in case there is no standard given.

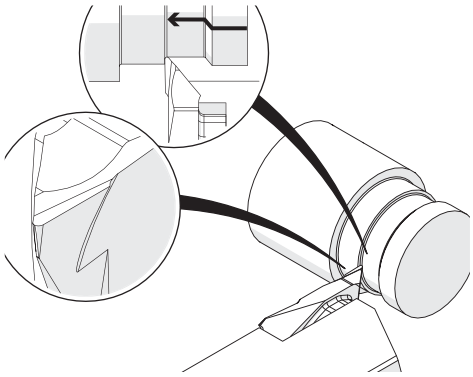
Standart uygulamalar
Standard Applications

Sayfa itibarı ile
As of Page
16



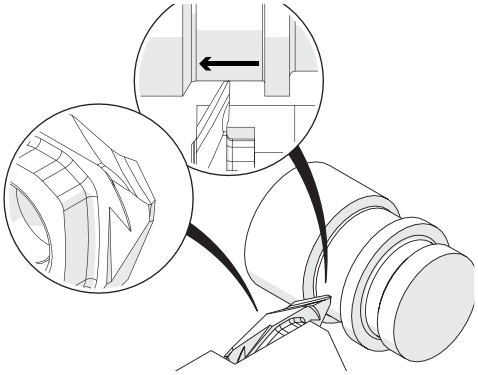
Tornalama
Turning

Sayfa
Page
18



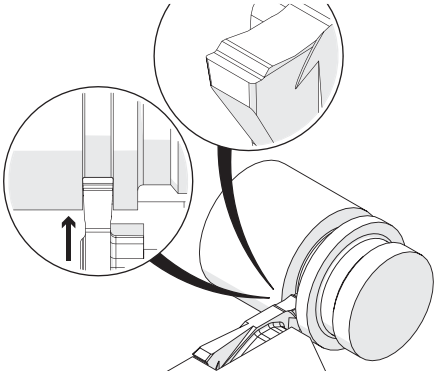
Tornalama ve Profil tornalama
Turning and Profiling

Sayfa
Page
19



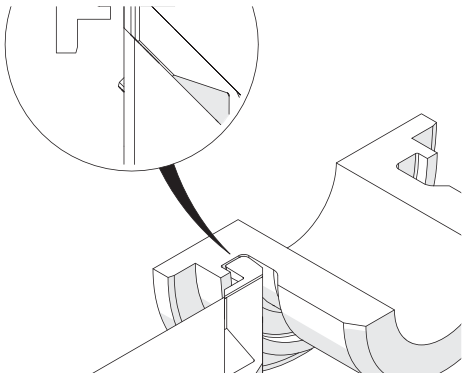
Geri tornalama
Back Turning

Sayfa itibarı ile
As of Page
21



Kanal açma ve Profil tornalama
Grooving and Profiling

Sayfa
Page
25



Diş sonu boşaltma
Face Thread Reliefs

Dış çap uygulamalar için A tipi takım tutucu

6,0 mm'ye kadar form genişlikleri bulunan, dış çap uygulamalar için takım tutucu.

Toolholder, External Applications, Type A

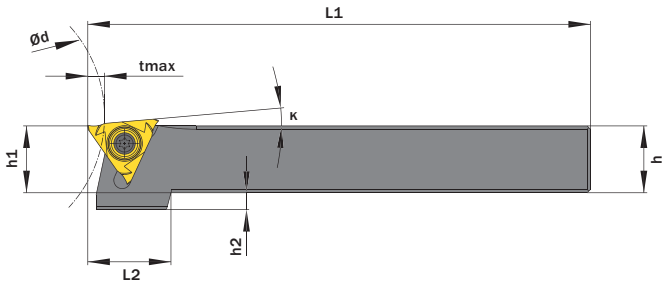
Toolholder for external applications and form widths up to 6,0 mm.

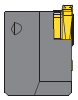
Sıkma torku (vida) // Tightening torque (Screw)

"F M5x11,5 T20R": 6,0 Nm
"F M5x12 T20R": 6,0 Nm
"F M5x13 T20R": 6,0 Nm

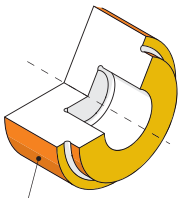
TW ST R Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/619** veya ziyaret edin // or visit





tmax depends on workpiece diameter (Ød)	tmax
Bis Ø63,0 mm / up to Ø2.480"	5,5 mm / 0.217"
Bis Ø80,0 mm / up to Ø3.150"	5,0 mm / 0.197"
Bis Ø100,0 mm / up to Ø3.937"	5,0 mm / 0.197"
Bis Ø160,0 mm / up to Ø6.299"	4,5 mm / 0.177"
Bis Ø200,0 mm / up to Ø7.874"	4,0 mm / 0.158"



Öncelikli kullanım alanı
Mainly designed for these surfaces
Uca bağlı olarak ekstra kullanım alanı
Also possible depending on insert/fixation type

Görseldeki çizim/Drawing shows: TF3.50.2020.A.12.00 R

κ	h mm	b mm	L1 mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	f mm	f1 mm	h1 js14 mm	h2 mm	L2 mm	Vida Screw	Vida anahtarı Screw driver	Connectcode www.simtek.com/ccode
▼ h = 12,0 mm													
0°	12,0	12,0	100,0	**TF3.01.1212.A.10.00 R/L**	R AXU9 L AXU8	12,4	6,9	12,0	9,0	24,0	FM5x11,5T20R	T20R	R TF3.R.01.00 L TF3.L.01.00
▼ h = 15,875													
0°	15,875	15,875	125,0	**TF3.01.0.625.A.12.00 R**	A33K	16,28	10,77	15,875	9,12	24,0	FM5x12T20R	T20R	**TF3.R.01.00**
▼ h = 16,0 mm													
0°	16,0	16,0	125,0	**TF3.01.1616.A.12.00 R/L**	R AWC5 L AWC4	16,4	10,9	16,0	9,0	24,0	FM5x13T20R	T20R	R TF3.R.01.00 L TF3.L.01.00
0°	16,0	16,0	125,0	**TF3.01.1616.A.12.08 R/L**	R AZF5 L AZF4	16,4	8,55	16,0	9,0	24,0	FM5x13T20R	T20R	R TF3.R.01.08 L TF3.L.01.08
5°	16,0	16,0	125,0	**TF3.51.1616.A.12.00 R/L**	R ASBB L ASBA	16,4	10,9	16,0	9,0	24,0	FM5x13T20R	T20R	R TF3.R.51.00 L TF3.L.51.00
▼ h = 20,0 mm													
0°	20,0	20,0	125,0	**TF3.01.2020.A.12.00 R/L**	R AWC7 L AWC6	20,4	14,9	20,0	5,0	24,0	FM5x13T20R	T20R	R TF3.R.01.00 L TF3.L.01.00
0°	20,0	20,0	125,0	**TF3.01.2020.A.12.08 R/L**	R AWNU L AWNV	20,4	12,55	20,0	5,0	24,0	FM5x13T20R	T20R	R TF3.R.01.08 L TF3.L.01.08
0°	20,0	20,0	125,0	**TF3.01.2020.A.12.10 R/L**	R AWNX L AWNW	20,4	9,6	20,0	5,0	24,0	FM5x13T20R	T20R	R TF3.R.01.10 L TF3.L.01.10
5°	20,0	20,0	125,0	**TF3.50.2020.A.12.00 R/L**	R AS58 L ATXZ	20,4	14,9	20,0	5,0	26,5	FM5x13T20R	T20R	R TF3.R.50.00 L TF3.L.50.00
5°	20,0	20,0	125,0	**TF3.51.2020.A.12.00 R/L**	R ASBD L ASBC	20,4	14,9	20,0	5,0	24,0	FM5x13T20R	T20R	R TF3.R.51.00 L TF3.L.51.00
▼ h = 25,0 mm													
0°	25,0	25,0	150,0	**TF3.01.2525.A.15.00 R/L**	R AWC9 L AWC8	25,4	19,9	25,0	-	-	FM5x13T20R	T20R	R TF3.R.01.00 L TF3.L.01.00
0°	25,0	25,0	150,0	**TF3.01.2525.A.15.08 R/L**	R AZ5C L AZ5D	25,4	17,55	25,0	-	-	FM5x13T20R	T20R	R TF3.R.01.08 L TF3.L.01.08
5°	25,0	25,0	150,0	**TF3.50.2525.A.15.00 R/L**	R AS57 L ATX0	25,4	19,9	25,0	-	-	FM5x13T20R	T20R	R TF3.R.50.00 L TF3.L.50.00
5°	25,0	25,0	150,0	**TF3.51.2525.A.15.00 R/L**	R ASBF L ASBE	25,4	19,9	25,0	-	-	FM5x13T20R	T20R	R TF3.R.51.00 L TF3.L.51.00
▼ h = 25,4 mm													
0°	25,4	25,4	150,0	**TF3.01.1.000.A.15.00 R**	A3X7	25,8	20,3	25,4	-	-	FM5x13T20R	T20R	**TF3.R.01.00**
▼ h = 32,0 mm													
5°	32,0	25,0	150,0	**TF3.50.3225.A.15.00 R/L**	R AS8G L AS8H	25,4	19,9	32,0	-	-	FM5x13T20R	T20R	R TF3.R.50.00 L TF3.L.50.00

Sipariş örneği // Order example: **TF3.01.2020.A.12.00 R** (R = Sağ model // Right hand version)

Dış çap uygulamalar için D tipi kranklı takım tutucu

Dış çap uygulamalar için, 45 ° ve 90 ° kranklı takım tutucu.

Toolholder, For External Application, Cranked, Type D

Toolholder for external applications. 45° and 90° cranked style.

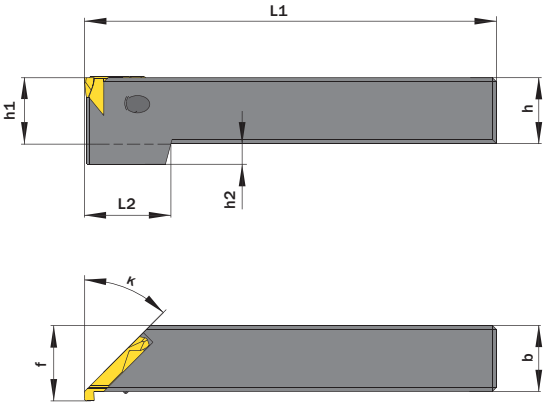
Sıkma torku (vida) // Tightening torque (Screw)

"F M5x13 T20R": 6,0 Nm
"M M5x0,5x7,5 T20R": 6,0 Nm

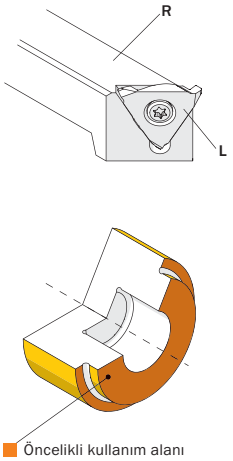
TW ST R Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/940** veya ziyaret edin // or visit

Lütfen sol kesici için sağ taraf takım tutucuyu kullanın ya da tam tersi
Please use right hand toolholder with left hand insert and vice versa



TF3.51.2020.D.90.12.00 R



Öncelikli kullanım alanı
Mainly designed for these surfaces
Uca bağlı olarak ekstra kullanım alanı
Also possible depending on insert type

Görseldeki çizim/Drawing shows: TF3.00.1616.D.45.10.00 R

h mm	b mm	κ	L1 mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	f mm	h1 js14 mm	h2 mm	L2 mm	Vida Screw	Vida anahtarı Screw driver	Connectcode www.simtek.com/ccode
▼ κ = 45°												
15,875	15,875	45°	100,0	**TF3.00.062S.D.45.10.00 R**	A4XF	18,2	15,875	5,13	21,0	M M5x0,5x7,5 T20R	T20R	**TF3.R.45.00.03**
19,05	19,05	45°	125,0	**TF3.00.075S.D.45.12.00 R**	A4P9	21,36	19,05	5,95	21,0	M M5x0,5x7,5 T20R	T20R	**TF3.R.45.00.03**
25,4	25,4	45°	150,0	**TF3.00.100S.D.45.15.00 R**	A4QB	27,7	25,4	-	-	M M5x0,5x7,5 T20R	T20R	**TF3.R.45.00.03**
16,0	16,0	45°	100,0	**TF3.00.1616.D.45.10.00 R/L**	R AYJZ L A4PN	18,3	16,0	5,0	21,0	M M5x0,5x7,5 T20R	T20R	R TF3.R.45.00.03 L TF3.L.45.00.03
20,0	20,0	45°	125,0	**TF3.00.2020.D.45.12.00 R/L**	R AYJ0 L A4PQ	22,3	20,0	5,0	21,0	M M5x0,5x7,5 T20R	T20R	R TF3.R.45.00.03 L TF3.L.45.00.03
25,0	25,0	45°	150,0	**TF3.00.2525.D.45.15.00 R/L**	R AYJY L A4PT	27,3	25,0	-	-	M M5x0,5x7,5 T20R	T20R	R TF3.R.45.00.03 L TF3.L.45.00.03
▼ κ = 90°												
25,4	25,4	90°	150,0	**TF3.51.100S.D.90.15.00 R/L**	R A4TB L A4TD	32,4	25,4	-	-	F M5x13 T20R	T20R	R TF3.L.51.00 L TF3.R.51.00
20,0	20,0	90°	125,0	**TF3.51.2020.D.90.12.00 R/L**	R AUDW L AU6Q	27,0	20,0	-	-	F M5x13 T20R	T20R	R TF3.L.51.00 L TF3.R.51.00
25,0	25,0	90°	150,0	**TF3.51.2525.D.90.15.00 R/L**	R AT76 L AT77	32,0	25,0	-	-	F M5x13 T20R	T20R	R TF3.L.51.00 L TF3.R.51.00

Sipariş örneği // Order example: **TF3.00.2020.D.45.12.00 R** (R = Sağ model // Right hand version)

simturnFX
SIMTEK small part machining type FX

Dış çap uygulamalar için A tipi, ayarlanabilir soğutma sıvısı nozullu takım tutucu

Uygulamaya göre optimize edilmiş soğutma için; ayarlanabilir soğutma sıvısı nozulu ve beslemesi için üç bağlantı dişi içeren, dış çap uygulamalar için takım tutucu.

Toolholder, External Applications, Type A, with Adjustable Coolant Nozzle

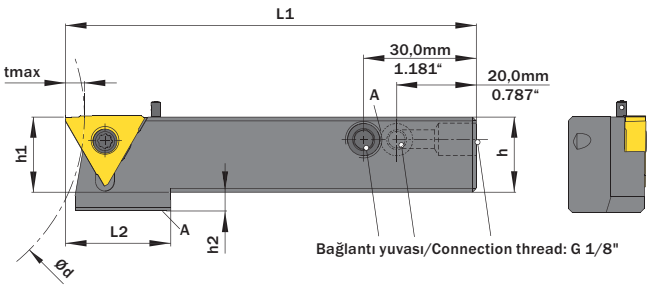
Toolholder for external applications. With adjustable coolant nozzle for an optimized cooling according to the application and three usable connection threads for the coolant supply.

Sıkma torku (vida) // Tightening torque (Screw)

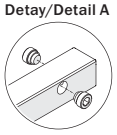
"F M5x11,5 T20R": 6,0 Nm
"F M5x13 T20R": 6,0 Nm

TW ST | R | Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/1192** veya ziyaret edin // or visit



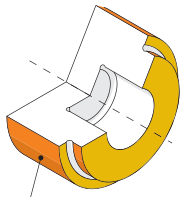
Detay/Detail A



Görseldeki çizim/Drawing shows: TF3.01.2020.A.10.00 CG R

tmax depends on Workpiece diameter (Ød)	tmax
up to Ø63,0 mm / up to Ø2.480"	5,5 mm / 0.217"
up to Ø80,0 mm / up to Ø3.150"	5,0 mm / 0.197"
up to Ø100,0 mm / up to Ø3.937"	5,0 mm / 0.197"
up to Ø125,0 mm / up to Ø4.921"	4,5 mm / 0.177"
up to Ø160,0 mm / up to Ø6.299"	4,5 mm / 0.177"
up to Ø200,0 mm / up to Ø7.874"	4,0 mm / 0.158"

Soğutma nozulu/Coolant nozzle
TOC.A.5X13.PIN IC



Öncelikli kullanım alanı
Mainly designed for these surfaces
Uca bağlı olarak ekstra kullanım alanı
Also possible depending on insert type

κ	h mm	b mm	L1 mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	f mm	f1 mm	h1 js14 mm	h2 mm	L2 mm	Vida Screw	Vida anahtarı Screw driver	Connectcode www.simtek.com/ccode
▼ h = 12,0 mm													
0°	12,0	12,0	100,0	**TF3.01.1212.A.10.00 CG R/L**	R AZGB L AZGA	12,4	6,9	12,0	9,0	28,0	FM5x11,5T20R	T20R	R TF3.R.01.00 L TF3.L.01.00
▼ h = 16,0 mm													
0°	16,0	16,0	100,0	**TF3.01.1616.A.10.00 CG R/L**	R AZGD L AZGC	16,4	10,9	16,0	9,0	28,0	FM5x13T20R	T20R	R TF3.R.01.00 L TF3.L.01.00
▼ h = 19,05 mm													
0°	19,05	19,05	100,0	**TF3.01.075S.A.10.08 CG R**	A4YN	19,5	12,55	19,05	5,95	28,0	FM5x13T20R	T20R	TF3.R.01.08
▼ h = 20,0 mm													
0°	20,0	20,0	100,0	**TF3.01.2020.A.10.00 CG R/L**	R AZGF L AZGE	20,4	14,9	20,0	5,0	28,0	FM5x13T20R	T20R	R TF3.R.01.00 L TF3.L.01.00
0°	20,0	20,0	100,0	**TF3.01.2020.A.10.08 CG R/L**	R AZGH L AZGG	20,4	12,55	20,0	5,0	28,0	FM5x13T20R	T20R	R TF3.R.01.08 L TF3.L.01.08
0°	20,0	20,0	100,0	**TF3.01.2020.A.10.10 CG R/L**	R AZGK L AZGJ	20,4	9,6	20,0	5,0	28,0	FM5x13T20R	T20R	R TF3.R.01.10 L TF3.L.01.10
▼ h = 25,0 mm													
0°	25,0	25,0	100,0	**TF3.01.2525.A.10.00 CG R/L**	R AZGN L AZGM	25,4	19,9	25,0	-	-	FM5x13T20R	T20R	R TF3.R.01.00 L TF3.L.01.00
0°	25,0	25,0	100,0	**TF3.01.2525.A.10.08 CG R/L**	R A1QK L A1S9	25,4	17,55	25,0	-	-	FM5x13T20R	T20R	R TF3.R.01.08 L TF3.L.01.08
▼ h = 25,4 mm													
0°	25,4	25,4	100,0	**TF3.01.100S.A.10.08 CG R**	A4YK	25,8	18,0	25,4	-	-	FM5x13T20R	T20R	TF3.R.01.08
0°	25,4	25,4	100,0	**TF3.01.100S.A.10.10 CG R**	A42K	25,8	15,0	25,4	-	-	FM5x13T20R	T20R	TF3.R.01.10

Sipariş örneği // Order example: **TF3.01.2020.A.10.00 CG R** (R = Sağ model // Right hand version)

Dış çap uygulamalar için C tipi takım tutucu

Dış çap uygulamalarda, büyük çap iş parçalarında küçük kesme genişliği ve yüksek kesme derinliğine sahip takım tutucu.

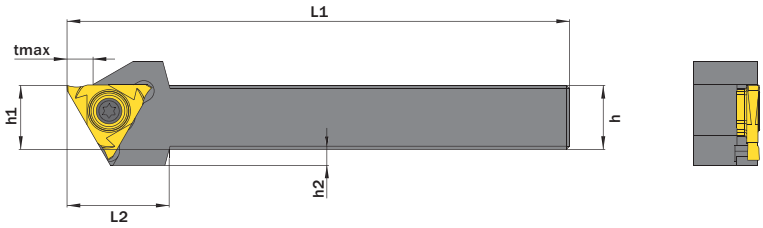
Toolholder, External Applications, Type C

Toolholder for external applications and small widths with high cutting depths on large work piece diameters.

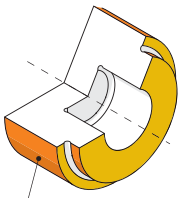
Sıkma torku (vida) // Tightening torque (Screw)
6,0 Nm

TW ST R Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/622** veya ziyaret edin // or visit



f ölçüsü, kullanılan kesici uca bağlıdır
Measure f depends on cutting insert



Öncelikli kullanım alanı
Mainly designed for these surfaces
Uca bağlı olarak ekstra kullanım alanı
Also possible depending on insert type

Görseldeki çizim/Drawing shows: TF3.00.1616.C.12.00 R

h mm	b mm	L1 mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	f1 mm	h1 js14 mm	h2 mm	L2 mm	tmax mm	Vida Screw	Vida anahtarı Screw driver	Connectcode www.simtek.com/ccode
▼ h = 16,0 mm												
16,0	16,0	125,0	**TF3.00.1616.C.12.00 R/L**	R ASZX L ADAJ	10,9	16,0	5,0	25,0	5,0	F M5x13 T20R	T20R	R TF3.R.00.00 L TF3.L.00.00
16,0	16,0	125,0	**TF3.50.1616.C.12.00 R/L**	R AG5J L ASZY	10,9	16,0	5,0	25,0	5,0	F M5x13 T20R	T20R	R TF3.R.50.00 L TF3.L.50.00
16,0	16,0	125,0	**TF3.51.1616.C.12.00 R/L**	R AZ35 L AZ36	10,9	16,0	5,0	25,0	5,0	F M5x13 T20R	T20R	R TF3.R.51.00 L TF3.L.51.00
▼ h = 19,05 mm												
19,05	19,05	125,0	**TF3.51.0.750.C.12.00 R**	A3SX	13,95	19,05	5,95	24,0	5,0	F M5x13 T20R	T20R	**TF3.R.51.00**
▼ h = 20,0 mm												
20,0	20,0	125,0	**TF3.00.2020.C.12.00 R/L**	R AJFQ L ASZZ	14,9	20,0	-	-	5,0	F M5x13 T20R	T20R	R TF3.R.00.00 L TF3.L.00.00
20,0	20,0	125,0	**TF3.50.2020.C.12.00 R/L**	R ABQ8 L ASZ0	14,9	20,0	-	-	5,0	F M5x13 T20R	T20R	R TF3.R.50.00 L TF3.L.50.00
20,0	20,0	125,0	**TF3.51.2020.C.12.00 R/L**	R AA69 L ASZ1	14,9	20,0	-	-	5,0	F M5x13 T20R	T20R	R TF3.R.51.00 L TF3.L.51.00
▼ h = 25,0 mm												
25,0	25,0	150,0	**TF3.00.2525.C.15.00 R/L**	R AHUW L ASZ2	19,9	25,0	-	-	5,0	F M5x13 T20R	T20R	R TF3.R.00.00 L TF3.L.00.00
25,0	25,0	150,0	**TF3.50.2525.C.15.00 R/L**	R AGWG L ASZ3	19,9	25,0	-	-	5,0	F M5x13 T20R	T20R	R TF3.R.50.00 L TF3.L.50.00
25,0	25,0	150,0	**TF3.51.2525.C.15.00 R/L**	R AMFF L ASZ4	19,9	25,0	-	-	5,0	F M5x13 T20R	T20R	R TF3.R.51.00 L TF3.L.51.00
▼ h = 25,4 mm												
25,4	25,4	150,0	**TF3.51.1.000.C.15.00 R**	A3B7	20,3	25,4	-	-	6,0	F M5x13 T20R	T20R	**TF3.R.51.00**
▼ h = 32,0 mm												
32,0	32,0	150,0	**TF3.50.3232.C.15.00 R/L**	R AS8K L AS8J	26,8	32,0	-	-	5,0	F M5x13 T20R	T20R	R TF3.R.50.00 L TF3.L.50.00

Sipariş örneği // Order example: **TF3.50.2525.C.15.00 R** (R = Sağ model // Right hand version)

Dış çap uygulamalar için kranklı takım tutucu

Dış çap uygulamalar için kranklı takım tutucu.

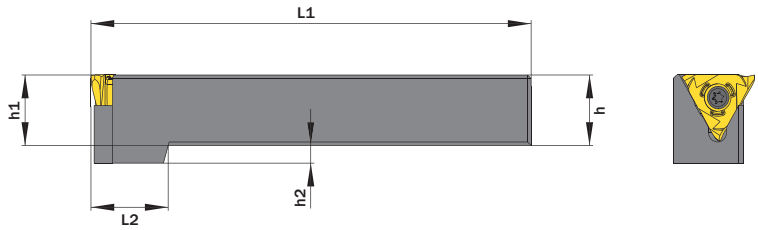
Toolholder, Cranked Style

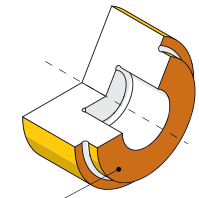
Toolholder for external applications.

Sıkma torku (vida) // Tightening torque (Screw)
6,0 Nm

TW ST R Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/623** veya ziyaret edin // or visit





Öncelikli kullanım alanı
Mainly designed for these surfaces
Uca bağlı olarak ekstra kullanım alanı
Also possible depending on insert type

Görseldeki çizim/Drawing shows: TF3.01.2020.D75.12.00 R

h	b	L1	Ürün kodu Part number	Webcode www.simtek.com/webcode	f	h1 js14	h2	L2	Vida Screw	Vida anahtarı Screw driver	Connectcode www.simtek.com/ccode
mm	mm	mm			mm	mm	mm	mm			
16,0	16,0	100,0	**TF3.01.1616.D75.10.00 R**	ATZC	18,5	16,0	4,0	21,0	F M5x13 T20R	T20R	**TF3.L.75.01.04**
20,0	20,0	125,0	**TF3.01.2020.D75.12.00 R**	AQF5	22,5	20,0	5,0	21,0	F M5x13 T20R	T20R	**TF3.L.75.01.04**
25,0	25,0	150,0	**TF3.01.2525.D75.15.00 R/L**	R AUF6 L AUF7	27,5	25,0	-	-	F M5x13 T20R	T20R	R TF3.L.75.01.04 L TF3.R.75.01.04

▌Sipariş örneği // Order example: **TF3.01.2525.D75.15.00 R** (R = Sağ model // Right hand version)

İç çap uygulamalar için A tipi takım tutucu

Küçük iç çap uygulamalarda, maksimum 2,0 mm genişlikle
ve 5,0 mm'ye kadar kesme derinliği olan takım tutucu.

Toolholder, For Internal Applications, Type A

Toolholder for internal applications. For use in smaller bore diameters.
Depth of cut up to 5,0 mm with maximum width of 2,0 mm.

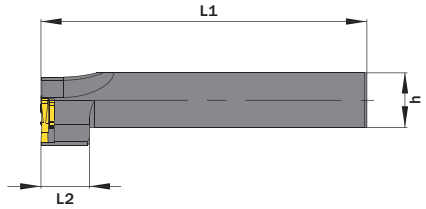
Sıkma torku (vida) // Tightening torque (Screw)

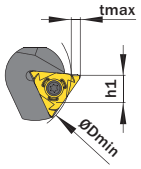
6,0 Nm

TW ST R

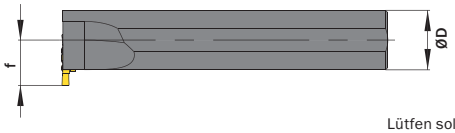
Referans Legend 27

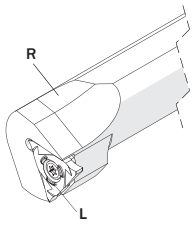
QR-Code Tara // Scan **www.simtek.info/cp/942** veya ziyaret edin // or visit



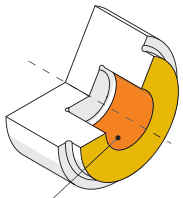


Bore diameter (ØDmin)	tmax
Ø46,0 mm / Ø1.811"	2,0 mm / 0.079"
Ø50,0 mm / Ø1.969"	3,0 mm / 0.118"
Ø60,0 mm / Ø2.362"	4,0 mm / 0.158"
Ø100,0 mm / Ø3.937"	5,0 mm / 0.197"





Lütfen sol kesici için sağ taraf takım tutucuyu kullanın ya da tam tersi
Please use right hand toolholder with left hand insert and vice versa.



Öncelikli kullanım alanı
Mainly designed for these surfaces
Uca bağlı olarak ekstra kullanım alanı
Also possible depending on insert type

Görseldeki çizim/Drawing shows: TF3.50.0025.A.17.00 R

ØD g6 mm	L1 mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	f mm	h mm	h1 js14 mm	L2 mm	Vida Screw	Vida anahtarı Screw driver	Connectcode www.simtek.com/ccode
▼ ØD = 25,0 mm										
25,0	170,0	**TF3.50.0025.A.17.05 R/L**	R AFQM L AT9H	19,0	23,0	23,0	20,0	FM5x13T20R	T20R	R TF3.L.50.00 L TF3.R.50.00
25,0	170,0	**TF3.51.0025.A.17.05 R/L**	R AF8J L AT9J	19,0	23,0	23,0	20,0	FM5x13T20R	T20R	R TF3.L.51.00 L TF3.R.51.00
▼ ØD = 32,0 mm										
32,0	200,0	**TF3.50.0032.A.20.05 R/L**	R AG1E L AT9K	20,0	30,0	30,0	10,0	FM5x13T20R	T20R	R TF3.L.50.00 L TF3.R.50.00
32,0	200,0	**TF3.51.0032.A.20.05 R/L**	R AEKY L AT9M	20,0	30,0	30,0	10,0	FM5x13T20R	T20R	R TF3.L.51.00 L TF3.R.51.00

Sipariş örneği // Order example: **TF3.51.0025.A.17.05 R** (R = Sağ model // Right hand version)

İç çap uygulamalar için C tipi takım tutucu

İç çap uygulamalar için takım tutucu.

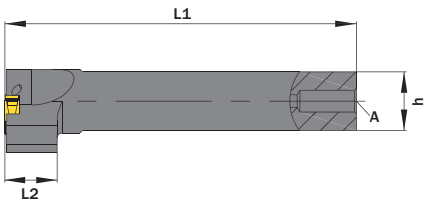
Toolholder, For Internal Applications, Type C

Toolholder for internal applications.

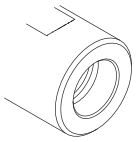
Sıkma torku (vida) // Tightening torque (Screw)
6,0 Nm

TW ST | R | Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/939** veya ziyaret edin // or visit

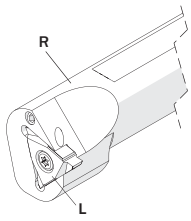


Detay/Detail A

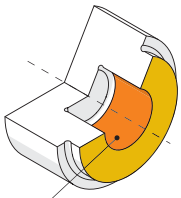


Bağlantı yuvası/Connection thread: G 1/8"

Bore diameter (ØDmin)	tmax
Ø50,0 mm / Ø1.969"	1,5 mm / 0.059"
Ø55,0 mm / Ø2.165"	1,8 mm / 0.071"
Ø60,0 mm / Ø2.362"	2,0 mm / 0.079"
Ø100,0 mm / Ø3.937"	2,5 mm / 0.098"
Ø150,0 mm / Ø5.906"	3,0 mm / 0.118"



Lütfen sol kesici için sağ taraf takım tutucuyu kullanın ya da tam tersi
Please use right hand toolholder with left hand insert and vice versa.



Öncelikli kullanım alanı
Mainly designed for these surfaces
Uca bağlı olarak ekstra kullanım alanı
Also possible depending on insert type

Görseldeki çizim/Drawing shows: TF3.14.0025.C.15.00 R

ØD g6 mm	L1 mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	f mm	h mm	h1 js14 mm	L2 mm	Vida Screw	Vida anahtarı Screw driver	Connectcode www.simtek.com/ccode
▼ h = 23,0 mm										
25,0	150,0	**TF3.14.0025.C.15.00 R/L**	R AT6W L AXZ0	16,5	23,0	20,0	20,0	FM5x13T20R	T20R	R TF3.L.14.00 L TF3.R.14.00
▼ h = 23,4										
23,4	152,4	**TF3.14.1.000.C.15.00 R/L**	R AT6V L AXZ3	16,9	23,4	20,0	20,0	FM5x13T20R	T20R	R TF3.L.14.00 L TF3.R.14.00
▼ h = 30,0 mm										
32,0	200,0	**TF3.14.0032.C.20.00 R/L**	R AT6X L AXZ1	19,5	30,0	20,0	20,0	FM5x13T20R	T20R	R TF3.L.14.00 L TF3.R.14.00
▼ h = 38,0 mm										
40,0	250,0	**TF3.14.0040.C.25.00 R/L**	R AT6Y L AXZ2	23,5	38,0	20,0	20,0	FM5x13T20R	T20R	R TF3.L.14.00 L TF3.R.14.00

▌Sipariş örneği // Order example: **TF3.14.0025.C.15.00 R** (R = Sağ model // Right hand version)

TOA Modüler takım sistemi için kaset

ISO 26623'e göre tasarlanmış TOA tabanlı ana takım tutucuda kullanım içindir.

Cassette for Modular Tool System TOA

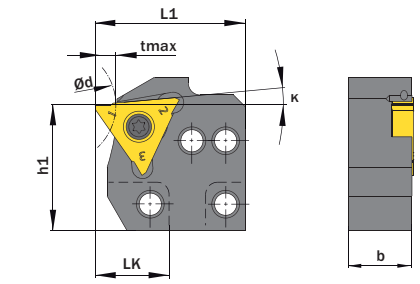
For use on SIMTEK base toolholder with polygon shank according to ISO 26623.

Sıkma torku (vida) // Tightening torque (Screw)
6,0 Nm

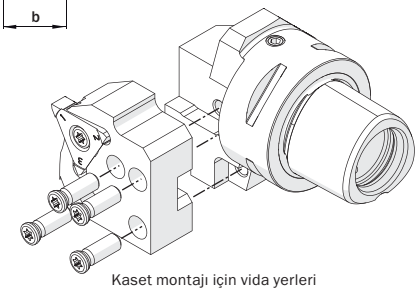
TW ST R

Referans Legend 27

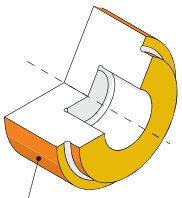
QR-Code Tara // Scan **www.simtek.info/cp/1190** veya ziyaret edin // or visit



Görseldeki çizim/Drawing shows: TOA.TF3.50.A.19.05 R



Kaset montajı için vida yerleri
Screw for cassette mounting
T M5x15 T20R



Öncelikli kullanım alanı
Mainly designed for these surfaces
Uca bağlı olarak ekstra kullanım alanı
Also possible depending on insert type

κ	LK mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	b mm	Ød mm	f mm	f1 mm	h1 mm	L1 mm	tmax mm	Vida Screw	Vida anahtarı Screw driver	Connectcode www.simtek.com/ccode	Adaptcode
0°	19,0	**TOA.TF3.00.A.19.05 R/L**	R AY97 L AZAS	16,0	100,0	16,4	10,9	31,6	37,9	5,0	F M5x13 T20R	T20R	R TF3.R.00.00 L TF3.L.00.00	TOA
0°	19,0	**TOA.TF3.01.A.19.05 R/L**	R AY55 L AZBQ	16,0	100,0	16,4	10,9	31,6	37,9	5,0	F M5x13 T20R	T20R	R TF3.R.01.00 L TF3.L.01.00	TOA
0°	29,0	**TOA.TF3.01.A.29.05 R/L**	R AZBT L AZBS	16,0	100,0	16,4	10,9	31,6	37,9	5,0	F M5x13 T20R	T20R	R TF3.R.01.00 L TF3.L.01.00	TOA
5°	19,0	**TOA.TF3.50.A.19.05 R/L**	R AZAU L AZAT	16,0	100,0	16,4	10,9	31,6	37,9	5,0	F M5x13 T20R	T20R	R TF3.R.50.00 L TF3.L.50.00	TOA

Sipariş örneği // Order example: **TOA.TF3.01.A.19.05 R** (R = Sağ model // Right hand version)

TOA Modüler takım sistemi için kaset

ISO 26623'e göre tasarlanmış TOA tabanlı ana takım tutucuda kullanım içindir.

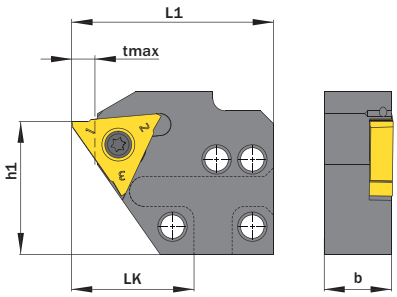
Cassette for Modular Tool System TOA

For use on SIMTEK base toolholder with polygon shank according to ISO 26623.

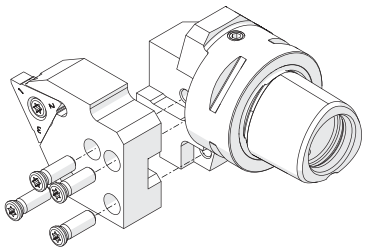
Sıkma torku (vida) // Tightening torque (Screw)
6,0 Nm

TW ST | R | Referans Legend 27

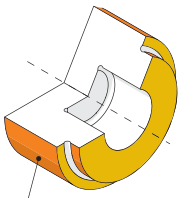
QR-Code Tara // Scan www.simtek.info/cp/1188 veya ziyaret edin // or visit



Görseldeki çizim/Drawing shows: TOA.TF3.51.C.29.05 R



Kaset montajı için vida yerleri
Screw for cassette mounting
T M5x15 T20R



Öncelikli kullanım alanı
Mainly designed for these surfaces
Uca bağlı olarak ekstra kullanım alanı
Also possible depending on insert type

Ürün kodu Part number	Webcode www.simtek.com/webcode	b mm	f mm	f1 mm	h1 mm	LK mm	L1 mm	tmax mm	Vida Screw	Vida anahtarı Screw driver	Connectcode www.simtek.com/ccode	Adaptcode
TOA.TF3.51.C.29.05 R/L	R AZAQ L AZAP	16,0	16,4	10,9	31,6	29,0	47,9	5,5	F M5x13 T20R	T20R	R TF3.R.51.00 L TF3.L.51.00	TOA

Sipariş örneği // Order example: **TOA.TF3.51.C.29.05 R** (R = Sağ model // Right hand version)

Connectcode „TF3.R.51.00" ve „TF3.L.51.00" içeren kasetler, özelleştirilmiş kesme takımları için sağlanır.
Cassette with Connectcode „TF3.R.51.00" und „TF3.L.51.00" are provided for customized cutting tools.

TOA Modüler takım sistemi için kaset

ISO 26623'e göre tasarlanmış TOA tabanlı ana takım tutucuda kullanım içindir.

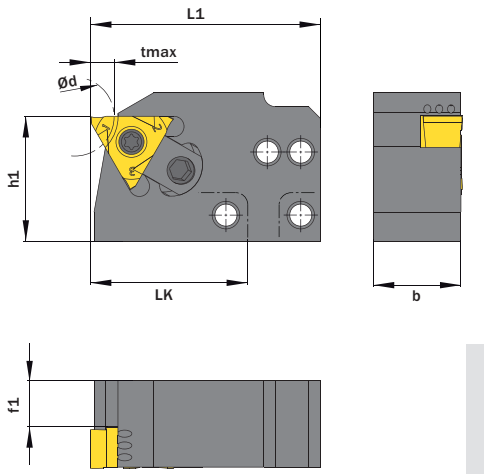
Cassette for Modular Tool System TOA

For use on SIMTEK base toolholder with polygon shank according to ISO 26623.

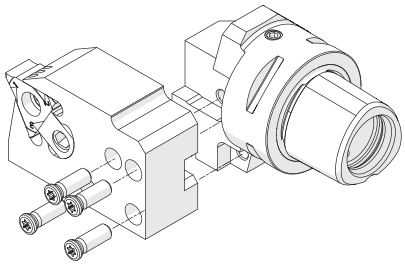
Sıkma torku (vida) // Tightening torque (Screw)
6,0 Nm

TW ST | R | Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/1185** veya ziyaret edin // or visit

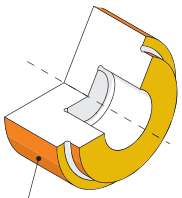


Görseldeki çizim/Drawing shows: TOA.TF3.00.B.39.10 R



Kaset montajı için vida yerleri
Screw for cassette mounting
T M5x15 T20R

tmax depends from Workpiece diameter (Ød)	tmax
up to Ø20,0 mm / up to Ø0.787"	6,0 mm / 0.236"
up to Ø30,0 mm / up to Ø1.181"	4,5 mm / 0.177"
up to Ø40,0 mm / up to Ø1.575"	4,0 mm / 0.158"
up to Ø50,0 mm / up to Ø1.969"	3,5 mm / 0.138"
up to Ø60,0 mm / up to Ø2.362"	3,5 mm / 0.138"
up to Ø100,0 mm / up to Ø3.937"	3,0 mm / 0.118"



Öncelikli kullanım alanı
Mainly designed for these surfaces
Uca bağlı olarak ekstra kullanım alanı
Also possible depending on insert type

Ürün kodu Part number	Webcode www.simtek.com/webcode	b mm	f1 mm	h1 mm	LK mm	L1 mm	Vida Screw	Vida anahtarı Screw driver	Bağlama Clamp	Connectcode www.simtek.com/ccode	Adaptcode
TOA.TF3.00.B.39.06 R/L	R AZAH L AZAG	22,0	15,7	31,6	39,5	58,4	F M5x13 T20R	T20R	F22.06.11	R TF3.L.00.06 L TF3.R.00.06	TOA
TOA.TF3.00.B.39.08 R/L	R AZAK L AZAJ	22,0	13,7	31,6	39,5	58,4	F M5x13 T20R	T20R	F22.08.11	R TF3.L.00.08 L TF3.R.00.08	TOA
TOA.TF3.00.B.39.10 R/L	R AZAN L AZAM	22,0	11,7	31,6	39,5	58,4	F M5x13 T20R	T20R	F22.10.11	R TF3.L.00.10 L TF3.R.00.10	TOA

Sipariş örneği // Order example: **TOA.TF3.00.B.39.10 R** (R = Sağ model // Right hand version)

Connectcode „TF3.R.51.00" y „TF3.L.51.00" içeren kasetler, özelleştirilmiş kesme takımları için sağlanır.
Cassette with Connectcode „TF3.R.51.00" and „TF3.L.51.00" are provided for customized cutting tools.

Yüksekliği ayarlanabilir kaset

Precium tarafından tasarlanmış, yüksekliği ayarlanabilen arka işlemler için TOG-System ile uyumlu kaset.

Height-Adjustable Cassette for Back Operations

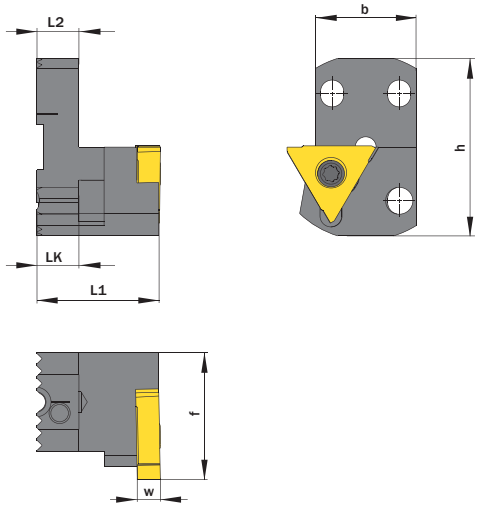
Cassette for height-adjustable back operations tools. Compatible to TOG-system by precium.

Sıkma torku (vida) // Tightening torque (Screw)

7,0 Nm

TW ST | R | Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/1222** veya ziyaret edin // or visit



Görseldeki çizim/Drawing shows: TOG.K.TF3.01.A1 R

İllüstrasyon çizim/Illustration only

Soğutma sıvısı besleme With through coolant supply	Ürün kodu Part number	Webcode www.simtek.com/webcode	b mm	h mm	f mm	L1 mm	L2 mm	LK mm	w mm	Vida Screw	Vida anahtarı Screw driver	Connectcode www.simtek.com/ccode
Hayır/No	**TOG.K.TF3.01.A1 R/L**	R AZHN L AZHM	24,0	43,0	30,75	29,0	10,0	10,0	5,5	TF3 M5x15 T20R	T20R	R TF3.R.01.00 L TF3.L.01.00
Evet/Yes	**TOG.K.TF3.01.B1 R/L**	R AZHS L AZHQ	24,0	43,0	30,75	46,0	27,0	10,0	5,5	TF3 M5x15 T20R	T20R	R TF3.R.01.00 L TF3.L.01.00

▌Sipariş örneği // Order example: **TOG.K.TF3.01.A1 R** (R = Sağ model // Right hand version)

„E“ tipi kesici tasarımı ile tornalama

Yüksek performans ve talaş kontrolü için „E“ tipi kesici tasarımlı takımlar.

Turning, Cutting Edge Design „E“

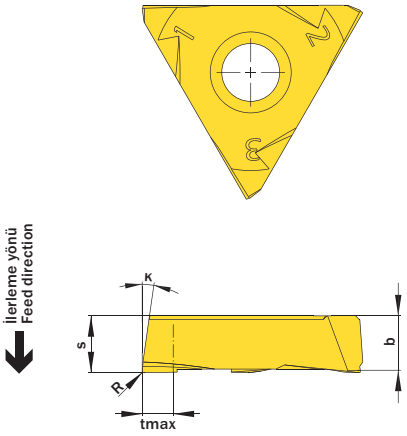
Cutting edge design „E“, for high performance and chip control.

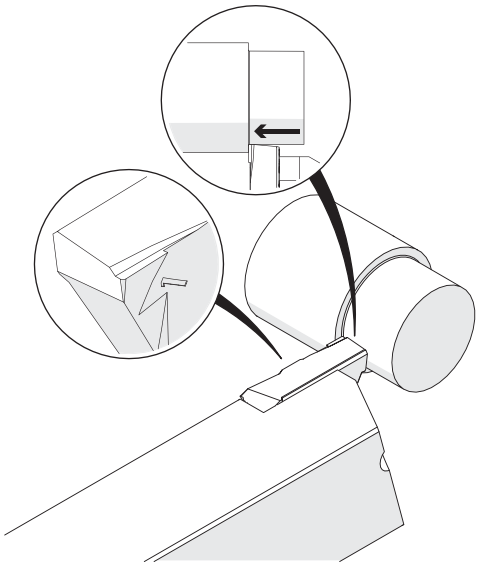
Kesme parametreleri // Cutting parameters (start)	
f **0,08 mm/U**	Vc **Sayfa/Page 29**

Uyumlu takım tutucu sayfaları // Suitable toolholders on page
5, 7, 12, 15

SP HM R Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/1018** veya ziyaret edin // or visit





Görseldeki çizim/Drawing shows: TF3.01.008.10.020 YER

K	R	Ürün kodu Part number	Webcode www.simtek.com/webcode		Bizim tavsiyemiz Our first choice		b	S	tmax	Connectcode www.simtek.com/ccode	
					P K M N S						
	mm						mm	mm	mm		
8°	0,2	**TF3.01.008.10.020 YER/L**	R AWZD	L AWZC	X802	X602	5,2	5,5	3,0	R TF3.R.01.00	L TF3.L.01.00
8°	0,4	**TF3.01.008.10.040 YER/L**	R AWZF	L AWZE	X800	X602	5,2	5,5	3,0	R TF3.R.01.00	L TF3.L.01.00

Sipariş örneği // Order example: **TF3.01.008.10.040 YER X802** (R = Sağ model // Right hand version, X802 = Kesici kalitesi // Grade)

WIPER-Geometrili „E“ tipi kesici tasarımı ile tornalama

WIPER-Geometri eşit ilerleme hızlarında mükemmel yüzey kalitesi ve iki kat ilerleme hızı sunar.

Turning, Cutting Edge Design Type „E“ with WIPER-Geometry

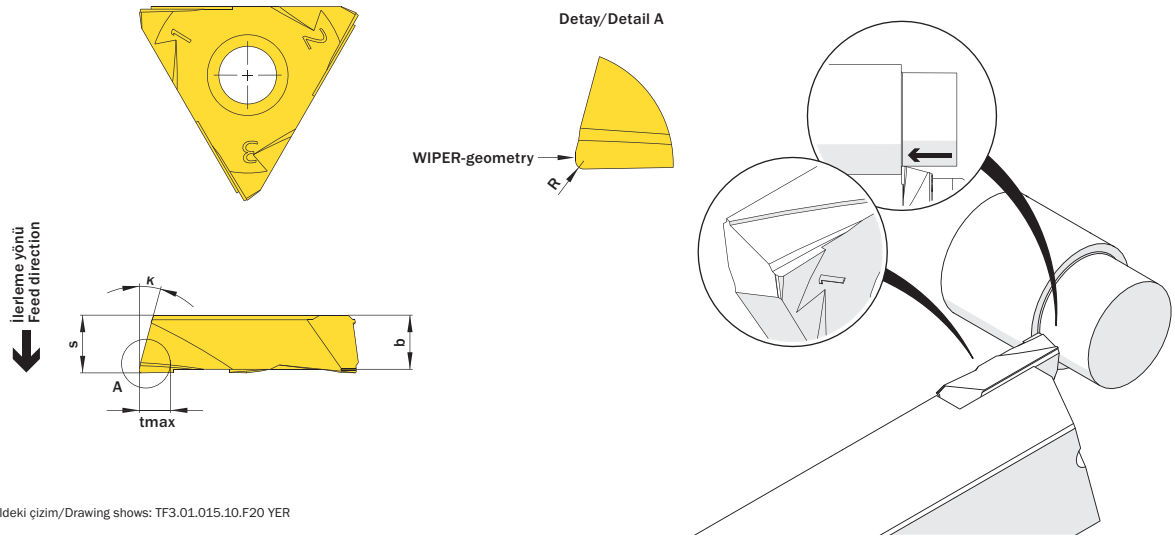
WIPER-geometry offers better surface quality at equal feed rates or doubled feed rates at equal surface quality.

Kesme parametreleri // Cutting parameters (start)	
f **0,08 mm/U**	Vc **Sayfa/Page 29**

Uyumlu takım tutucu sayfaları // Suitable toolholders on page
5, 7, 12, 15

SP HM R Referans Legend **27**

QR-Code Tara // Scan **www.simtek.info/cp/1027** veya ziyaret edin // or visit



Görseldeki çizim/Drawing shows: TF3.01.015.10.F20 YER

K	R mm	Ürün kodu Part number	Webcode www.simtek.com/webcode				Bizim tavsiyemiz Our first choice P K M N S	b mm	S mm	tmax mm	Connectcode www.simtek.com/ccode	
15°	0,2	**TF3.01.015.10.F20 YER/L**	R	AWZH	L	AWZG	X802 X402	5,2	5,5	3,0	R TF3.R.01.00	L TF3.L.01.00
15°	0,4	**TF3.01.015.10.F40 YER/L**	R	AWZK	L	AWZJ	X802 X402	5,2	5,5	3,0	R TF3.R.01.00	L TF3.L.01.00

Sipariş örneği // Order example: **TF3.01.015.10.F40 YER FT40** (R = Sağ model // Right hand version, FT40 = Kesici kalitesi // Grade)

„E“ tipi kesici tasarımı ile tornalama ve profil tornalama

Yüksek performans ve talaş kontrolü için „E“ tipi kesici tasarımlı takımlar.

Turning and Profiling,Cutting Edge Design „E“

Cutting edge design „E“, for high performance and chip control.

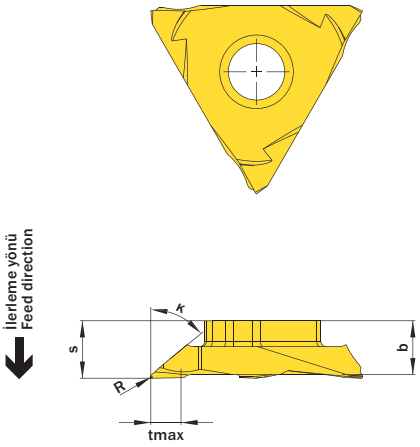
Kesme parametreleri // Cutting parameters (start)

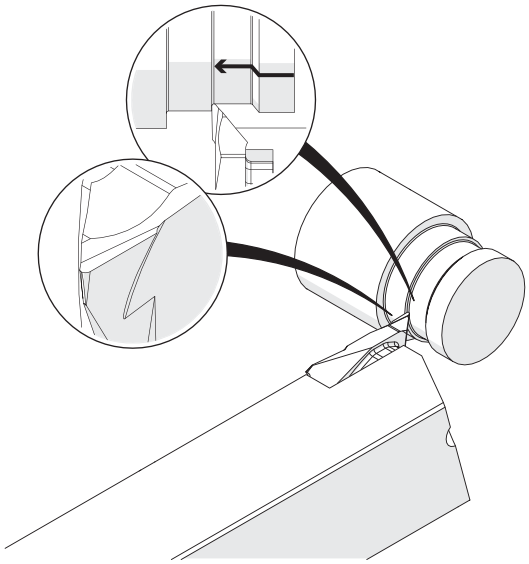
f	Vc
0,08 mm/U	Sayfa/Page 29

Uyumlu takım tutucu sayfaları // Suitable toolholders on page
5, 7, 12, 15

SP HM R Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/1028** veya ziyaret edin // or visit





Görseldeki çizim/Drawing shows: TF3.01.050.10.020 YER

κ	R	Ürün kodu Part number	Webcode www.simtek.com/webcode	Bizim tavsiyemiz Our first choice P K M N S	b	S	tmax	Connectcode www.simtek.com/ccode
	mm				mm	mm	mm	
▼ κ = 30°								
30°	0,2	**TF3.01.030.10.020 YER/L**	R AWZV L AWZU	X802 X602	5,2	5,5	3,0	R TF3.R.01.00 L TF3.L.01.00
30°	0,4	**TF3.01.030.10.040 YER/L**	R AWZX L AWZW	X802 X602	5,2	5,5	3,0	R TF3.R.01.00 L TF3.L.01.00
▼ κ = 50°								
50°	0,2	**TF3.01.050.10.020 YER/L**	R AWZ3 L AWZ2	X802 X602	5,3	5,6	3,0	R TF3.R.01.00 L TF3.L.01.00
50°	0,4	**TF3.01.050.10.040 YER/L**	R AWZ5 L AWZ4	X802 X602	5,3	5,6	3,0	R TF3.R.01.00 L TF3.L.01.00

Sipariş örneği // Order example: **TF3.01.050.10.020 YER X802** (R = Sağ model // Right hand version, X802 = Kesici kalitesi // Grade)

Ters tornalama

Ters tornalama ve „gövde arkasını“da tornalama için ayarlanabilen kesici takımlar.

Back Turning

Indexable insert for back turning as well as for turning „behind shoulder“.

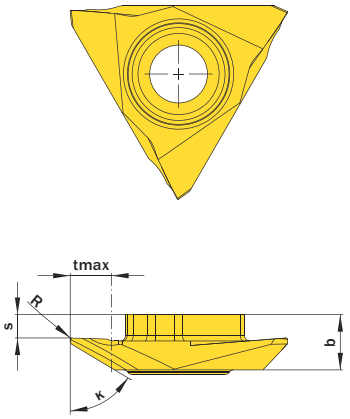
Kesme parametreleri // Cutting parameters (start)

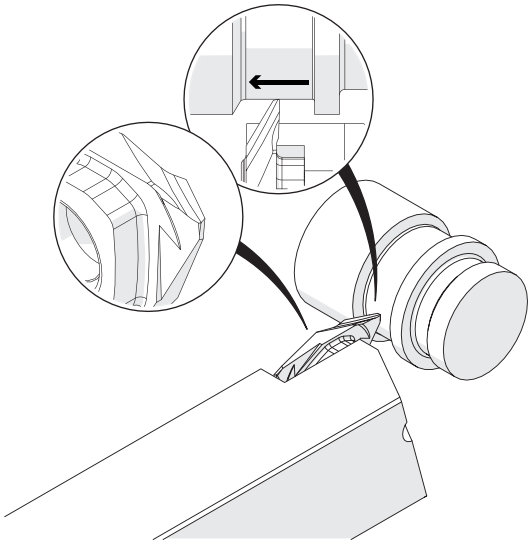
f	Vc
0,08 mm/U	Sayfa/Page 29

Uyumlu takım tutucu sayfaları // Suitable toolholders on page
5, 7, 12, 15

SP HM R Referans Legend 27

QR-Code Tara // Scan www.simtek.info/cp/1075 veya ziyaret edin // or visit





Görseldeki çizim/Drawing shows: TF3.059.02.06.020 YY R

K	R mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	Bizim tavsiyemiz Our first choice P K M N S	b mm	S mm	tmax mm	Connectcode www.simtek.com/ccode
59°	0,2	**TF3.01.059.26.020 YYR/L**	R AXTH L AXTJ	X800 X600	5,35	2,26	4,0	R TF3.R.01.00 L TF3.L.01.00
59°	0,4	**TF3.01.059.26.040 YYR/L**	R AXTK L AXTM	X800 X600	5,35	2,26	4,0	R TF3.R.01.00 L TF3.L.01.00

▌Sipariş örneği // Order example: **TF3.01.059.26.020 YYR X800** (R = Sağ model // Right hand version, X800 = Kesici kalitesi // Grade)

„E“ tipi kesici tasarımı ile kanal açma

Yüksek performans ve talaş kontrolü için „E“ tipi kesici tasarımlı takımlar.

Grooving, Cutting Edge Design Type „E“

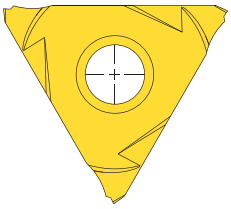
Cutting edge design type „E“,for high performance and chip control.

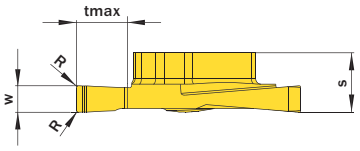
Kesme parametreleri // Cutting parameters (start)	
f **0,08 mm/U**	**Vc** **Sayfa/Page 29**

Uyumlu takım tutucu sayfaları // Suitable toolholders on page
5, 7, 12, 15

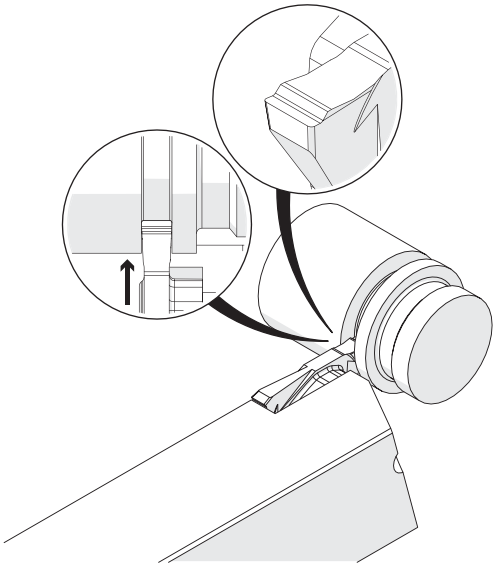
SP HM R Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/1029** veya ziyaret edin // or visit





Görseldeki çizim/Drawing shows: TF3.01.0250.020 NER



w ±0,02 mm	R mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	Bizim tavsiyemiz Our first choice P K M N S	S mm	tmax mm	Connectcode www.simtek.com/ccode
1,5	0,2	**TF3.01.0150.020 NER/L**	R AWZN L AWZM	X802 X602	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
1,8	0,2	**TF3.01.0180.020 NER/L**	R AX72 L AYV4	X802 X602	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
2,0	0,2	**TF3.01.0200.020 NER/L**	R AWZQ L AWZP	X802 X602	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
2,5	0,2	**TF3.01.0250.020 NER/L**	R AWZT L AWZS	X802 X602	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
3,0	0,2	**TF3.01.0300.020 NER/L**	R AWZZ L AWZY	X802 X602	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
4,0	0,2	**TF3.01.0400.020 NER/L**	R AWZ1 L AWZ0	X802 X602	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
5,0	0,2	**TF3.01.0500.020 NER/L**	R AWZ7 L AWZ6	X802 X602	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00

Sipariş örneği // Order example: **TF3.01.0400.020 NER X802** (R = Sağ model // Right hand version, X802 = Kesici kalitesi // Grade)

Kanal açma ve profil tornalama

CNC profil tornalama ve kanal açma uygulamaları için kesici takımlar.

Grooving and Profiling

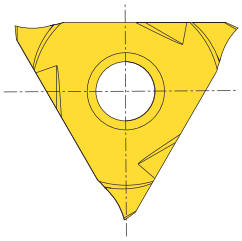
CNC Profiling.

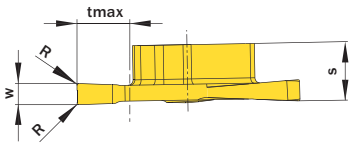
Kesme parametreleri // Cutting parameters (start)	
f **0,08 mm/U**	Vc **Sayfa/Page 29**

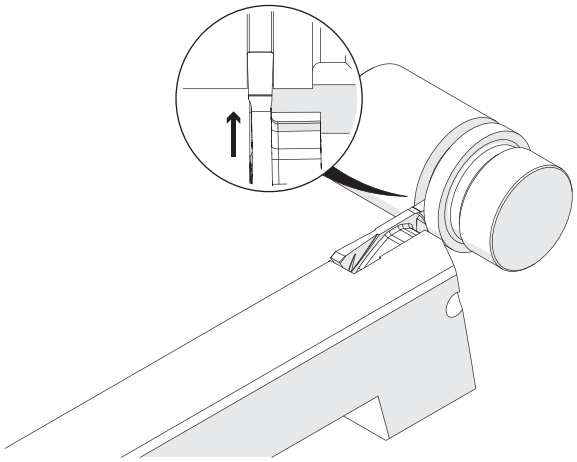
Uyumlu takım tutucu sayfaları // Suitable toolholders on page
5, 7, 12, 15

SP HM R Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/1262** veya ziyaret edin // or visit







Görseldeki çizim/Drawing shows: TF3.01.0200.020 NS R

w ±0,02 mm	R mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	Bizim tavsiyemiz Our first choice P K M N S	S mm	tmax mm	Connectcode www.simtek.com/ccode
1,0	0,2	**TF3.01.0100.020 NSR/L**	R A10V L A197	X808 X608	5,35	5,0	R TF3.R.01.00 L TF3.L.01.00
1,5	0,2	**TF3.01.0150.020 NSR/L**	R A06Q L A06S	X800 X600	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
2,0	0,2	**TF3.01.0200.020 NSR/L**	R A06N L A06P	X800 X600	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
2,5	0,2	**TF3.01.0250.020 NSR/L**	R A06K L A06M	X800 X600	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00

Sipariş örneği // Order example: **TF3.01.0100.020 NSR X808** (R = Sağ model // Right hand version, X808 = Kesici kalitesi // Grade)

Hafif alaşımlarda kanal açma ve profil tornalama

Hafif alaşımlardaki uygulamalar için özel geometrili CNC profil tornalama ve kanal açma kesici takımları.

Grooving and Profiling In Light Alloys

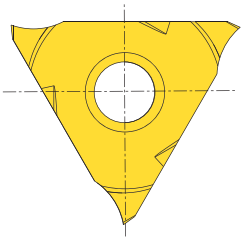
CNC profiling with special geometry for applications in light alloys.

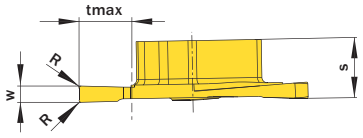
Kesme parametreleri // Cutting parameters (start)	
f **0,08 mm/U**	Vc **Sayfa/Page 29**

Uyumlu takım tutucu sayfaları // Suitable toolholders on page
5, 7, 12, 15

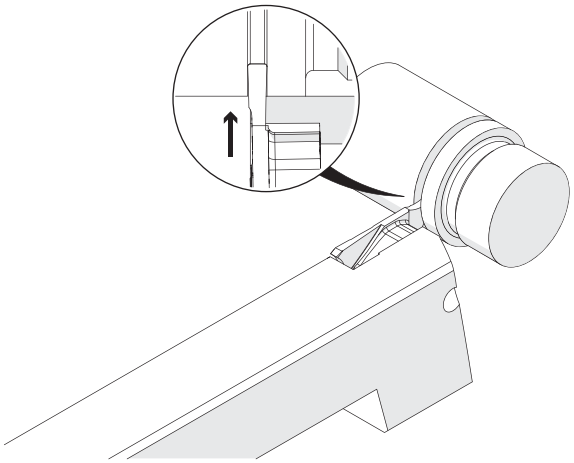
SP HM R Referans Legend **27**

QR-Code Tara // Scan **www.simtek.info/cp/1263** veya ziyaret edin // or visit





Görseldeki çizim/Drawing shows: TF3.01.0150.020 NC R



w ±0,02 mm	R mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	Bizim tavsiyemiz Our first choice P K M N S	S mm	tmax mm	Connectcode www.simtek.com/ccode
1,5	0,2	**TF3.01.0150.020 NCR**	A101	X808 X408	5,5	5,0	TF3.R.01.00
2,0	0,2	**TF3.01.0200.020 NCR**	A102	X808 X408	5,5	5,0	TF3.R.01.00

Sipariş örneği // Order example: **TF3.01.0200.020 NCR X800** (R = Sağ model // Right hand version, X800 = Kesici kalitesi // Grade)

„D“ tipi kesici tasarımı ile kanal açma ve profil tornalama

Gelişmiş talaş kontrolü ve yüksek performans için „D“ tipi kesici tasarımı ile; kanal açma ve profil tornalama uygulamaları için kesici takımlar.

Grooving, Cutting Edge Design Type „D“

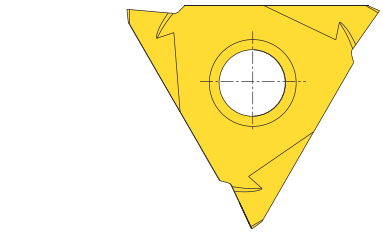
Grooving with ground geometry type „D“ for improved chip control.

Kesme parametreleri // Cutting parameters (start)	
f **0,08 mm/U**	Vc **Sayfa/Page 29**

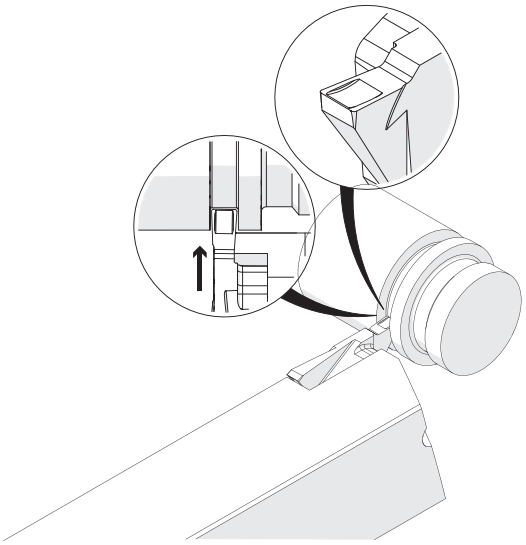
Uyumlu takım tutucu sayfaları // Suitable toolholders on page
5, 7, 12, 15

SP HM R Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/1226** veya ziyaret edin // or visit



Görseldeki çizim/Drawing shows: TF3.01.0250.020 ND R



w ±0,02 mm	R mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	Bizim tavsiyemiz Our first choice P K M N S	S mm	tmax mm	Connectcode www.simtek.com/ccode
1,5	0,2	**TF3.01.0150.020 NDR/L**	R AZXD L AZXC	X800 X600	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
1,8	0,2	**TF3.01.0180.020 NDR/L**	R AZXE L AZXF	X800 X600	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
2,0	0,2	**TF3.01.0200.020 NDR/L**	R AZXH L AZXG	X800 X600	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
2,5	0,2	**TF3.01.0250.020 NDR/L**	R AZXJ L AZXK	X800 X600	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
3,0	0,2	**TF3.01.0300.020 NDR/L**	R AZXN L AZXM	X800 X600	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
4,0	0,2	**TF3.01.0400.020 NDR/L**	R AZXP L AZXQ	X800 X600	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
5,0	0,2	**TF3.01.0500.020 NDR/L**	R AZXT L AZXS	X800 X600	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00

Sipariş örneği // Order example: **TF3.01.0150.020 NDR X800** (R = Sağ model // Right hand version, X800 = Kesici kalitesi // Grade)

„A“ tipi kesici tasarımı ile kanal açma ve profil tornalama

„A“ tipi kesici tasarımı ile, gelişmiş talaş kontrolü ve kontrollü talaş kırıcı formlu kesici takımlar.

Grooving and Profiling, Cutting Edge Design Type „A“

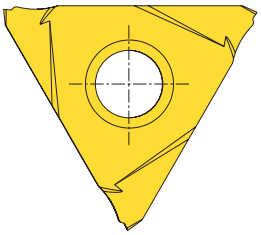
Cutting edge design „A“,for ideal chip control and controlled chip breaking.

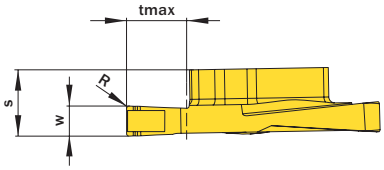
Kesme parametreleri // Cutting parameters (start)	
f **0,08 mm/U**	**Vc** **Sayfa/Page 29**

Uyumlu takım tutucu sayfaları // Suitable toolholders on page
5, 7, 12, 15

SP HM R Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/1240** veya ziyaret edin // or visit





Görseldeki çizim/Drawing shows: TF3.01.0250.020 NA R

w ±0,02 mm	R mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	Bizim tavsiyemiz Our first choice P K M N S	S mm	tmax mm	Connectcode www.simtek.com/ccode
2,0	0,2	**TF3.01.0200.020 NAR/L**	R AZKA L AZJ9	X802 X402	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
2,5	0,2	**TF3.01.0250.020 NAR/L**	R AZKC L AZKB	X802 X402	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
3,0	0,2	**TF3.01.0300.020 NAR/L**	R AZKE L AZKD	X802 X402	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
4,0	0,2	**TF3.01.0400.020 NAR/L**	R AZKG L AZKF	X802 X402	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00
5,0	0,2	**TF3.01.0500.020 NAR/L**	R AZKJ L AZKH	X802 X402	5,5	5,0	R TF3.R.01.00 L TF3.L.01.00

Sipariş örneği // Order example: **TF3.01.0500.020 NAR X802** (R = Sağ model // Right hand version, X802 = Kesici kalitesi // Grade)

Diş sonu boşaltma

Diş sonu boşaltma uygulamaları için tasarlanmış 45 ° takım tutucuya monte edilmiş kesici takımlar.

Face Thread Reliefs

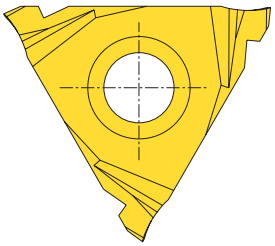
Suitable for thread Reliefs. Mounted in a 45° Toolholder.

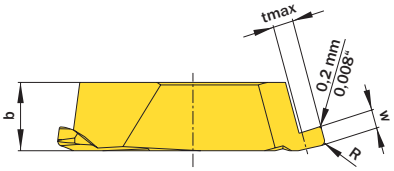
Kesme parametreleri // Cutting parameters (start)	
f **0,08 mm/U**	Vc **Sayfa/Page 29**

Uyumlu takım tutucu sayfaları // Suitable toolholders on page
9

SP HM R Referans Legend 27

QR-Code Tara // Scan **www.simtek.info/cp/1086** veya ziyaret edin // or visit





Görseldeki çizim/Drawing shows: TF3.01.L0815.75.04 FR

ØDmin (min. delik) ØDmin (min. bore)	w	R	Ürün kodu Part number	Webcode www.simtek.com/webcode	Bizim tavsiyemiz Our first choice	b	tmax	Connectcode www.simtek.com/ccode
mm	mm	mm			P K M N S	mm	mm	
8,0	1,5	0,4	**TF3.01.L0815.75.04 FR**	AXUN	X800 X400	5,45	1,6	TF3.R.75.01.04
12,0	2,0	0,5	**TF3.01.L1220.75.05 FR**	AXUP	X800 X400	5,45	1,8	TF3.R.75.01.04
20,0	2,4	0,6	**TF3.01.L2024.75.06 FR**	AXUQ	X800 X400	5,45	2,0	TF3.R.75.01.04

▌Sipariş örneği // Order example: **TF3.01.L2024.75.06 FR X800** (R = Sağ model // Right hand version, X800 = Kesici kalitesi // Grade)

Diş sonu boşaltma

Diş sonu boşaltma uygulamaları için tasarlanmış 45 ° takım tutucuya monte edilmiş kesici takımlar.

Face Thread Reliefs

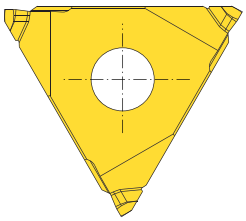
Suitable for thread Reliefs. Mounted in a 45° Toolholder.

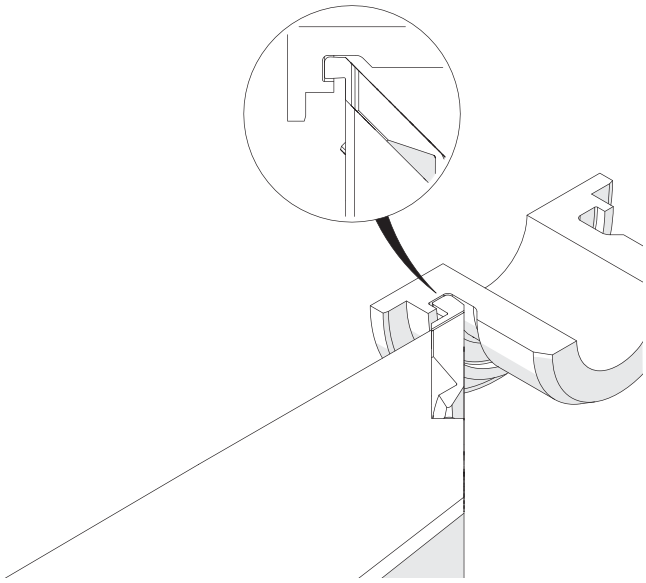
Kesme parametreleri // Cutting parameters (start)	
f **0,08 mm/U**	Vc **Sayfa/Page 29**

Uyumlu takım tutucu sayfaları // Suitable toolholders on page
6

SP HM L Referans Legend **27**

QR-Code Tara // Scan **www.simtek.info/cp/1127** veya ziyaret edin // or visit





Görseldeki çizim/Drawing shows: TF3.00.0815.45.04 E L

ØDmin (min. delik) ØDmin (min. bore) mm	w mm	R1 mm	Ürün kodu Part number	Webcode www.simtek.com/webcode	Bizim tavsiyemiz Our first choice P K M N S	R2 mm	b mm	tmax mm	Connectcode www.simtek.com/ccode
8,0	1,5	0,2	**TF3.00.0815.45.02 E R/L**	R A4TF L A1GA	X800 X600	0,2	3,3	1,6	R TF3.L.45.00.03 L TF3.R.45.00.03
8,0	1,5	0,4	**TF3.00.0815.45.04 E R/L**	R A4TH L AYJV	X800 X600	0,2	3,3	1,6	R TF3.L.45.00.03 L TF3.R.45.00.03
12,0	2,0	0,2	**TF3.00.1220.45.02 E R/L**	R A4TK L A1EJ	X800 X600	0,2	3,3	2,0	R TF3.L.45.00.03 L TF3.R.45.00.03
12,0	2,0	0,5	**TF3.00.1220.45.05 E R/L**	R A4TN L AYJW	X800 X600	0,2	3,3	2,0	R TF3.L.45.00.03 L TF3.R.45.00.03
20,0	2,4	0,6	**TF3.00.2024.45.06 E R/L**	R A4TQ L AYJX	X800 X600	0,2	3,3	2,0	R TF3.L.45.00.03 L TF3.R.45.00.03

▌Sipariş örneği // Order example: **TF3.00.2024.45.06 E R X800** (R = Sağ model // Right hand version, X800 = Kesici kalitesi // Grade)

Referans
Legend

SP / HM **Karbür uç // Carbide insert**

TW / ST **Çelik takım tutucu // Steel toolholder**

L **Sol yön versiyonu gösterilmiştir // Left hand version shown**

R **Sağ yön versiyonu gösterilmiştir, sol yön versiyonu ters // Right hand version shown, left hand version inversely**

Soğutma sıvısı // Through coolant

Tools for highest expectations
En Yüksek Talepler için Makine Takımları
SİMTEK

Gösterge (indeks) // Index

simturn FX ürün listesi
simturn FX Product list

Ürün kodu/Part Nr.	S/P
TF3.00.062S.D.45.10.00 R	6
TF3.00.075S.D.45.12.00 R	6
TF3.00.0815.45.02 E L	26
TF3.00.0815.45.02 E R	26
TF3.00.0815.45.04 E L	26
TF3.00.0815.45.04 E R	26
TF3.00.100S.D.45.15.00 R	6
TF3.00.1220.45.02 E L	26
TF3.00.1220.45.02 E R	26
TF3.00.1220.45.05 E L	26
TF3.00.1220.45.05 E R	26
TF3.00.1616.C.12.00 L	8
TF3.00.1616.C.12.00 R	8
TF3.00.1616.D.45.10.00 L	6
TF3.00.1616.D.45.10.00 R	6
TF3.00.2020.C.12.00 L	8
TF3.00.2020.C.12.00 R	8
TF3.00.2020.D.45.12.00 L	6
TF3.00.2020.D.45.12.00 R	6
TF3.00.2024.45.06 E L	26
TF3.00.2024.45.06 E R	26
TF3.00.2525.C.15.00 L	8
TF3.00.2525.C.15.00 R	8
TF3.00.2525.D.45.15.00 L	6
TF3.00.2525.D.45.15.00 R	6
TF3.01.0.625.A.12.00 R	5
TF3.01.008.10.020 YEL	16
TF3.01.008.10.020 YER	16
TF3.01.008.10.040 YEL	16
TF3.01.008.10.040 YER	16
TF3.01.0100.020 NSL	21
TF3.01.0100.020 NSR	21
TF3.01.015.10.F20 YEL	17
TF3.01.015.10.F20 YER	17
TF3.01.015.10.F40 YEL	17
TF3.01.015.10.F40 YER	17
TF3.01.0150.020 NCR	22
TF3.01.0150.020 NDL	23
TF3.01.0150.020 NDR	23
TF3.01.0150.020 NEL	20
TF3.01.0150.020 NER	20
TF3.01.0150.020 NSL	21
TF3.01.0150.020 NSR	21
TF3.01.0180.020 NDL	23
TF3.01.0180.020 NDR	23
TF3.01.0180.020 NEL	20
TF3.01.0180.020 NER	20
TF3.01.0200.020 NAL	24
TF3.01.0200.020 NAR	24
TF3.01.0200.020 NCR	22
TF3.01.0200.020 NDL	23
TF3.01.0200.020 NDR	23
TF3.01.0200.020 NEL	20
TF3.01.0200.020 NER	20
TF3.01.0200.020 NSL	21
TF3.01.0200.020 NSR	21
TF3.01.0250.020 NAL	24
TF3.01.0250.020 NAR	24
TF3.01.0250.020 NDL	23
TF3.01.0250.020 NDR	23
TF3.01.0250.020 NEL	20
TF3.01.0250.020 NER	20
TF3.01.0250.020 NSL	21
TF3.01.0250.020 NSR	21
TF3.01.030.10.020 YEL	18
TF3.01.030.10.020 YER	18

Ürün kodu/Part Nr.	S/P
TF3.01.030.10.040 YEL	18
TF3.01.030.10.040 YER	18
TF3.01.0300.020 NAL	24
TF3.01.0300.020 NAR	24
TF3.01.0300.020 NDL	23
TF3.01.0300.020 NDR	23
TF3.01.0300.020 NEL	20
TF3.01.0300.020 NER	20
TF3.01.0400.020 NAL	24
TF3.01.0400.020 NAR	24
TF3.01.0400.020 NDL	23
TF3.01.0400.020 NDR	23
TF3.01.0400.020 NEL	20
TF3.01.0400.020 NER	20
TF3.01.050.10.020 YEL	18
TF3.01.050.10.020 YER	18
TF3.01.050.10.040 YEL	18
TF3.01.050.10.040 YER	18
TF3.01.0500.020 NAL	24
TF3.01.0500.020 NAR	24
TF3.01.0500.020 NDL	23
TF3.01.0500.020 NDR	23
TF3.01.0500.020 NEL	20
TF3.01.0500.020 NER	20
TF3.01.059.26.020 YYL	19
TF3.01.059.26.020 YYR	19
TF3.01.059.26.040 YYL	19
TF3.01.059.26.040 YYR	19
TF3.01.075S.A.10.08 CG R	7
TF3.01.1.000.A.15.00 R	5
TF3.01.100S.A.10.08 CG R	7
TF3.01.100S.A.10.10 CG R	7
TF3.01.1212.A.10.00 CG L	7
TF3.01.1212.A.10.00 CG R	7
TF3.01.1212.A.10.00 L	5
TF3.01.1212.A.10.00 R	5
TF3.01.1616.A.10.00 CG L	7
TF3.01.1616.A.10.00 CG R	7
TF3.01.1616.A.12.00 L	5
TF3.01.1616.A.12.00 R	5
TF3.01.1616.A.12.08 L	5
TF3.01.1616.A.12.08 R	5
TF3.01.1616.D75.10.00 R	9
TF3.01.2020.A.10.00 CG L	7
TF3.01.2020.A.10.00 CG R	7
TF3.01.2020.A.10.08 CG L	7
TF3.01.2020.A.10.08 CG R	7
TF3.01.2020.A.10.10 CG L	7
TF3.01.2020.A.10.10 CG R	7
TF3.01.2020.A.12.00 L	5
TF3.01.2020.A.12.00 R	5
TF3.01.2020.A.12.08 L	5
TF3.01.2020.A.12.08 R	5
TF3.01.2020.A.12.10 L	5
TF3.01.2020.A.12.10 R	5
TF3.01.2020.D75.12.00 R	9
TF3.01.2525.A.10.00 CG L	7
TF3.01.2525.A.10.00 CG R	7
TF3.01.2525.A.10.08 CG L	7
TF3.01.2525.A.10.08 CG R	7
TF3.01.2525.A.15.00 L	5
TF3.01.2525.A.15.00 R	5
TF3.01.2525.A.15.08 L	5
TF3.01.2525.A.15.08 R	5
TF3.01.2525.D75.15.00 L	9
TF3.01.2525.D75.15.00 R	9

Ürün kodu/Part Nr.	S/P
TF3.01.L0815.75.04 FR	25
TF3.01.L1220.75.05 FR	25
TF3.01.L2024.75.06 FR	25
TF3.14.0025.C.15.00 L	11
TF3.14.0025.C.15.00 R	11
TF3.14.0032.C.20.00 L	11
TF3.14.0032.C.20.00 R	11
TF3.14.0040.C.25.00 L	11
TF3.14.0040.C.25.00 R	11
TF3.14.1.000.C.15.00 L	11
TF3.14.1.000.C.15.00 R	11
TF3.50.0025.A.17.05 L	10
TF3.50.0025.A.17.05 R	10
TF3.50.0032.A.20.05 L	10
TF3.50.0032.A.20.05 R	10
TF3.50.1616.C.12.00 L	8
TF3.50.1616.C.12.00 R	8
TF3.50.2020.A.12.00 L	5
TF3.50.2020.A.12.00 R	5
TF3.50.2020.C.12.00 L	8
TF3.50.2020.C.12.00 R	8
TF3.50.2525.A.15.00 L	5
TF3.50.2525.A.15.00 R	5
TF3.50.2525.C.15.00 L	8
TF3.50.2525.C.15.00 R	8
TF3.50.3225.A.15.00 L	5
TF3.50.3225.A.15.00 R	5
TF3.50.3232.C.15.00 L	8
TF3.50.3232.C.15.00 R	8
TF3.51.0.750.C.12.00 R	8
TF3.51.0025.A.17.05 L	10
TF3.51.0025.A.17.05 R	10
TF3.51.0032.A.20.05 L	10
TF3.51.0032.A.20.05 R	10
TF3.51.1.000.C.15.00 R	8
TF3.51.100S.D.90.15.00 L	6
TF3.51.100S.D.90.15.00 R	6
TF3.51.1616.A.12.00 L	5
TF3.51.1616.A.12.00 R	5
TF3.51.1616.C.12.00 L	8
TF3.51.1616.C.12.00 R	8
TF3.51.2020.A.12.00 L	5
TF3.51.2020.A.12.00 R	5
TF3.51.2020.C.12.00 L	8
TF3.51.2020.C.12.00 R	8
TF3.51.2020.D.90.12.00 L	6
TF3.51.2020.D.90.12.00 R	6
TF3.51.2525.A.15.00 L	5
TF3.51.2525.A.15.00 R	5
TF3.51.2525.C.15.00 L	8
TF3.51.2525.C.15.00 R	8
TF3.51.2525.D.90.15.00 L	6
TF3.51.2525.D.90.15.00 R	6
T0A.F22.V1.06 L	10
T0A.F22.V1.06 R	10
T0A.F22.V1.08 L	10
T0A.F22.V1.08 R	10
T0A.F22.V1.10 L	10
T0A.F22.V1.10 R	10
T0A.F56.V1.51 L	9
T0A.F56.V1.51 R	9
T0A.F56.V3.50 L	8
T0A.F56.V3.50 R	8
T0A.TF3.00.A.19.05 L	12
T0A.TF3.00.A.19.05 R	12
T0A.TF3.00.B.39.06 L	14

Ürün kodu/Part Nr.	S/P
T0A.TF3.00.B.39.06 R	14
T0A.TF3.00.B.39.08 L	14
T0A.TF3.00.B.39.08 R	14
T0A.TF3.00.B.39.10 L	14
T0A.TF3.00.B.39.10 R	14
T0A.TF3.01.A.19.05 L	12
T0A.TF3.01.A.19.05 R	12
T0A.TF3.01.A.29.05 L	12
T0A.TF3.01.A.29.05 R	12
T0A.TF3.50.A.19.05 L	12
T0A.TF3.50.A.19.05 R	12
T0A.TF3.51.C.29.05 L	13
T0A.TF3.51.C.29.05 R	13
T0G.K.TF3.01.A1 L	15
T0G.K.TF3.01.A1 R	15
T0G.K.TF3.01.B1 L	15
T0G.K.TF3.01.B1 R	15

SİMTEK
En Yüksek Talepler için Makine Takımları
Tools for highest expectations

Kesme hızı parametreleri hakkında genel bilgi
Information About The Cutting Parameters

Kesme hızı önerisi sayfası
Cutting speed recommendation as of page **30**

Kesme hızı parametreleri ve önerileri hakkında genel bilgi
General information about the cutting parameters recommendations

Kesme hızı ve ilerleme hızları için verilen kesme parametreleri başlangıç değerleri içindir ve standart uygulama koşulları için tavsiye edilir.
En iyi kesme hızı parametreleri, çok çeşitli işleme,iş parçası takım ve genel makina durumuna bağlı olup, verilen başlangıç değerlerinin altında ve üstünde olabilir.

The given cutting parameters for speed and feed rates are meant as initial start values and are estimated for standard application conditions.
The best parameters depend on a wide variety of machine, workpiece and tool related conditions, for example the general machine condition, and can be above or below the given start values.

Örnek etki faktörleri ve bunların kesme hızı parametreleri üzerindeki etkisi
Example factors of influence and their effect on the cutting parameters

Değerleri azaltın // Reduce values	Değerleri arttırın // Increase values
Zor işleme ve sıkma koşulları Difficult machine and clamping conditions	Katı işleme ve sıkma koşulları Solid machine and clamping conditions
İşlenmesi zor malzemeler Difficult to machine materials	İşlenmesi kolay malzemeler Easy to machine materials
Uzun takım erişimi(L2) Long tool reach (L2)	Kısa takım erişimi(L2) Small tool reach (L2)
Talaş formu geometrisi yok No chip form geometry	Talaş formu geometrili With chip form geometry

Kesici kalitesinin malzeme sertliğine göre uygunluğu
Suitability of cutting grades in relation to work piece hardness

Kesici kalitesi // Grade	Yaklaşık olarak önerilen // Recommended up to approx.
X8*	HRC52
*T90 / *T91	HRC62
CBN	HRC65 (Uygulamaya bağlı // Depending on application)

Tools for highest expectations
En Yüksek Talepler için Makine Takımları
SİMTEK

Kesme hızı önerisi
Cutting Speed Recommendation

ISO-Grup *ISO-Group*	Önerilen kesici kalitesi (2) *Recommended Cutting Grade*	Malzeme bilgisi *Work piece material*	Alt grup *Sub-group*	Alternatif kesici kalitesi *Alternative cutting grade*	Vc m/min (Start)
P	X800 X802 X804 X808	Çelik, alaşımsız *Steel, unalloyed*	≤ 0,15 % C	X400 / X600	210
			0,15 - 0,4 % C	X400 / X600	190
			≥ 0,4 % C	X400 / X600	180
		Çelik, düşük alaşımlı (alaşım elementleri ≤% 5) *Steel, low alloyed (alloying elements ≤ 5%)*	Sertleştirilmemiş *Non-hardened*	X400 / X600	170
			Sertleştirilmiş *Hardened*	X400 / X600	100
		Çelik, yüksek alaşımlı (alaşım elementleri > % 5) *Steel, high alloyed (Alloying elements > 5%)*	Tavlanmış *Annealed*	X400 / X600	110
			Sertleştirilmiş *Hardened*	X400 / X600	90
		Döküm *Castings*	Alaşımsız *Unalloyed*	X400 / X600	150
			Düşük alaşımlı (alaşım elementleri ≤% 5) *Low alloyed (Alloying elements ≤ 5%)*	X400 / X600	120
			Yüksek alaşımlı (alaşım elementleri > % 5) *High alloyed (Alloying elements > 5%)*	X400 / X600	90
M	X400 / X600 X402 / X602 X404 / X604 X408 / X608	Paslanmaz çelik Ferritik / Martensitik *Stainless Steel Ferritic/Martensitic*	Sertleştirilmemiş *Non-hardened*	*T41	150
			PH sertleştirilmiş *PH-hardened*	*T41	110
			Sertleştirilmiş *Hardened*	*T41	110
		Paslanmaz çelik Östenitik *Stainless Steel Austenitic*	Östenitik *Austenitic*	*T41	140
			PH sertleştirilmiş *PH-hardened*	*T41	100
			Süper östenitik *Super Austenitic*	*T41	110
		Paslanmaz çelik Östenitik-Ferritik (iki katlı) *Stainless Steel Austenitic-ferritic (Duplex)*	Kaynaklanamaz ≥% 0,05 C *Non-weldable ≥ 0,05 % C*	*T41	120
			Kaynaklanabilir <% 0,05 C *Weldable < 0,05 % C*	*T41	100
		Paslanmaz Çelik (Döküm) Ferritik / Martensitik *Stainless Steel (Cast) Ferritic/martensitic*	Sertleştirilmemiş *Non-hardened*	*T41	130
			PH sertleştirilmiş *PH-hardened*	*T41	90
			Sertleştirilmiş *Hardened*	*T41	100
		Paslanmaz Çelik (Döküm) Östentitik *Stainless Steel (Cast) Austenitic*	Östenitik *Austenitic*	*T41	130
			PH sertleştirilmiş *PH-hardened*	*T41	90
		Paslanmaz Çelik (Döküm) Östenitik-Ferritik(iki katlı) *Stainless Steel (Cast) Austenitic-ferritic (Duplex)*	Kaynaklanamaz ≥% 0,05 C *Non-weldable ≥ 0,05 % C*	*T41	110
			Kaynaklanabilir <% 0,05 C *Weldable < 0,05 % C*	*T41	90

SİMTEK | En Yüksek Talepler için Makine Takımları | Tools for highest expectations

Kesme hızı önerisi
Cutting Speed Recommendation

ISO-Grup *ISO-Group*	Önerilen kesici kalitesi (2) *Recommended Cutting Grade*	Malzeme bilgisi *Work piece material*	Alt grup *Sub-group*	Alternatif kesici kalitesi *Alternative cutting grade*	Vc m/min (Start)
K	X800 X802 X804 X808	Dövülebilir *Malleable*	Ferritik (kısa talaşlı) *Ferritic (short chipping)*	*T57	180
			Perlitli (uzun talaşlı) *Pearlitic (long chipping)*	*T57	150
		Gri dökme demir *Grey Cast Iron*	Düşük gerilme mukavemeti *Low tensile strength*	*T57	200
			Yüksek gerilme mukavemeti *High tensile strength*	*T57	150
		Küresel grafitli dökme demir *Spheroidal Graphite cast iron*	Ferritik *Ferritic*	*T57	120
			Perlitli *Pearlitic*	*T57	110
			Martensitik *Martensitic*	*T57	110
N	X400 / X600 X402 / X602 X404 / X604 X408 / X608	Alüminyum alaşımları, Dövme *Aluminium alloys, Whrought*	Sertleştirilemez *Can not be hardened*	*F25	590
			Sertleştirilebilir, sertleştirilmiş *Can be hardened, hardened*	*F25	530
		Alüminyum alaşımları, Döküm *Aluminium alloys, Cast*	Sertleştirilemez *Can not be hardened*	*F25	590
			Sertleştirilebilir, sertleştirilmiş *Can be hardened, hardened*	*F25	530
		Alüminyum alaşımları, Döküm *Aluminium alloys, Cast*	< 5 % Si	*F25	240
			5 - 12 % Si	*X17	240
			> 12 % Si	PKD[1]	180
		Bakır ve Bakır alaşımları *Copper and Copper Alloys*	Serbest Kesme Alaşımları, ≥1% Pb *Free Cutting Alloys, ≥1 % Pb*	*F25	290
			Pirinç, kurşunlu bronzlar, ≤% 1 Pb *Brass, leaded bronzes, ≤ 1 % Pb*	*F25	290
			Bronz, elektrolitik bakır dahil kurşunsuz bakır *Bronze, lead-free copper incl. electrolytic copper*	*F25	210

Kesme hızı önerisi
Cutting Speed Recommendation

ISO-Grup *ISO-Group*	Önerilen kesici kalitesi (2) *Recommended Cutting Grade*	Malzeme bilgisi *Work piece material*	Alt grup *Sub-group*	Alternatif kesici kalitesi *Alternative cutting grade*	Vc m/min (Start)
S	X400 / X600 X402 / X602 X404 / X604 X408 / X608	Isıya dayanıklı süper alaşımlar, Fe-bazlı *Heat-resistant super alloys, Fe-based*	Tavlı veya çözelti işlemine tabi tutulmuş *Annealed or solution treated*	*X79	40
			Eskitilmiş veya çözelti işlemine tabi tutularak eskitilmiş *Aged or solution treated and aged*	*X79	30
		Isıya dayanıklı süper alaşımlar Ni-bazlı *Heat-resistant super alloys Ni-based*	Tavlı veya çözelti işlemine tabi tutulmuş *Annealed or solution treated*	*X79	40
			Eskitilmiş veya çözelti işlemine tabi tutularak eskitilmiş *Aged or solution treated and aged*	*X79	20
			Döküm veya döküm ve eskitilmiş *Cast or Cast and aged*	*X79	30
		Isıya dayanıklı süper alaşımlar Co-bazlı *Heat-resistant super alloys Co-based*	Tavlı veya çözelti işlemine tabi tutulmuş *Annealed or solution treated*	*X79	10
			Çözelti işlemine tabi tutulmuş ve eskitilmiş *Solution treated and aged*	*X79	10
			Döküm veya döküm ve eskitilmiş *Cast or Cast and aged*	*X79	10
		Titanyum alaşımları *Titanium Alloys*	Ticari saflıkta(99,5 % Ti) *Commercial pure (99,5 % Ti)*	*X79	80
			α, yakın α ve α + β alaşımlar, tavlanmış *α, near α and α + β alloys, annealed*	*X79	40
			α+β eskitilmiş koşullarda alaşımlar ve β alaşımları. Tavlanmış veya eskitilmiş *α+β Alloys in aged conditions as well as β alloys. Annealed or aged*	*X79	40
H	CBN[1]	Sertleştirilmiş çelik *Hardened steel*		*T91	50
		Soğutulmuş dökme demir, döküm veya döküm ve eskitilmiş *Chilled cast iron, cast or cast and aged*		*T91	90

1) En iyi sonuçlar için, burada özel bir kesme kenarı geometrisi önerilir.
Lütfen teknik desteğimizle iletişime geçin: +90 266 376 11 61 veya sales.tr@simtek.com

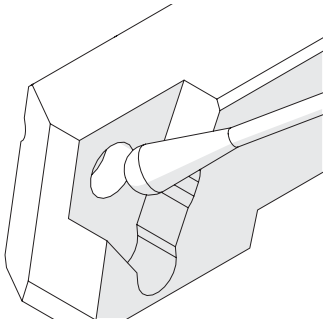
For best results, a special cutting edge geometry is recommended here.
Please contact our tecnical support +90 266 376 11 61 or sales.tr@simtek.com

(2) Öneri, seçilen kesici uçlara bağlıdır. Lütfen kesici ucun katalog sayfasındaki bizim tavsiyemiz alanına bakın.

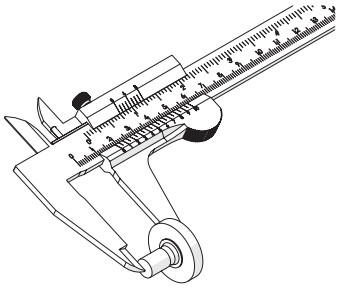
Recommendation depends on the chosen cutting inserts. Please look at the cutting grade recommendations on the catalog page of the cutting insert.

SIMTEK En Yüksek Talepler için Makine Takımları | Tools for highest expectations

Genel kullanım talimatları
General Instructions For Use



Lütfen takmadan ve kullanmadan önce uç yuvasını iyice temizleyin
Please clean insert seat well before mounting and use



Lütfen iş parçalarınızı sık sık kontrol edin
Please control your work pieces frequently

Takım ön ayar ve ölçüm cihazlarının kullanılmasını öneririz
We recommend the use of tool presetting and measuring devices

Tools for highest expectations
En Yüksek Talepler için Makine Takımları
SİMTEK