

Cutting Tools

Wendeschneidplatten und Werkzeuge

2007-2008

ZCC·CT



ZhuZhou Cemented Carbide Cutting Tools Co. Ltd
ZCC Group

DRILLING INSERTS

Schneidplatten zum Bohren

Drilling tools

Carbide grades for drilling
Sorten von Platten zum Bohren

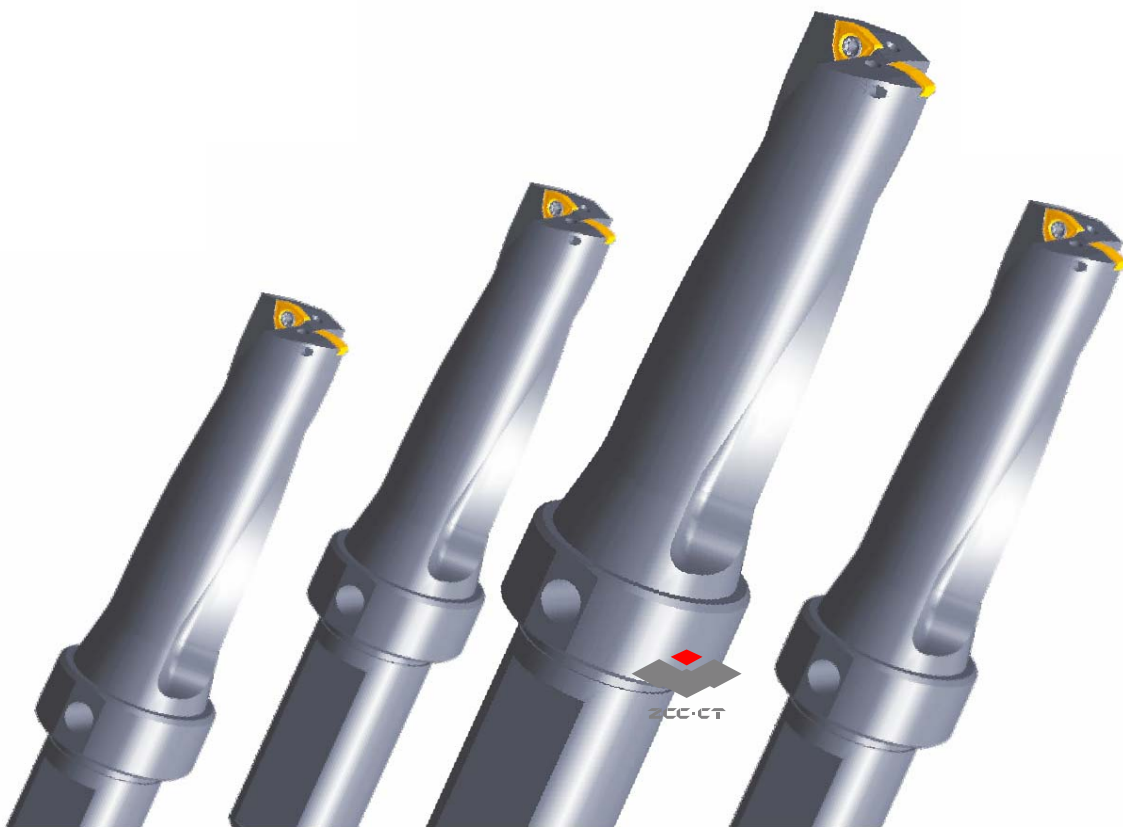
D2

ISO indexable insert code key
ISO Kennzeichnung von Schneidplatten zum Bohren

D3 - D4

Drilling inserts
Schneidplatten zum Bohren

D5



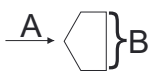
D1

DRILLING INSERTS

Schneidplatten zum Bohren

Grades for drilling
Sorten zum Bohren

ISO		Coated grades Beschichtete Sorten	Uncoated grades Unbeschichtete Sorten
P	01		
	10	YBC251, YBG40	
	20	YBG202	
	30		
	40	YBC351, YBG201, YB235	YC40
M	10	YBG40	YD201
	20	YBG201, YBG202, YB235	
	30		
	40		
K	01		
	10	YBC351, YBG201, YBG202, YBG40	YD201
	20		
	30		
N	01		
	10	YBG201, YBG202	YD201
	20		
	30		
S	10		YD201
	20	YBG201, YBG202	
	30		
	40		
H	01		
	10	YBG201, YBG202	
	20		
	30		



A Center of the field of application / *Hauptanwendungsbereich*
 B Recommended field of application / *Empfohlener Anwendungsbereich*

DRILLING INSERTS

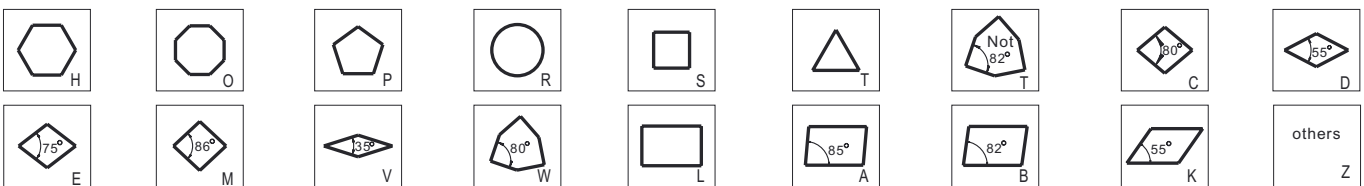
Schneidplatten zum Bohren

ISO indexable insert code key
ISO Kennzeichnung

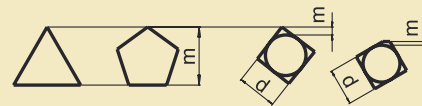
Example / Beispiele



Insert shape / Plattenform



D. Theoretical diameter of inscribed circle
s. Insert thickness
m. See Fig.



Clearance angle of major cutting edge / Freiwinkel von Hauptschneide



Tolerances, mm inch / Toleranz

letter Symbol	Tolerances in mm			Tolerances in inches		
	m	s	d	m	s	d
A	± 0.005	± 0.025	± 0.025	± 0.0002	± 0.001	± 0.0010
F	± 0.005	± 0.025	± 0.013	± 0.0002	± 0.001	± 0.0005
C	± 0.013	± 0.025	± 0.025	± 0.0005	± 0.001	± 0.0010
H	± 0.013	± 0.025	± 0.013	± 0.0005	± 0.001	± 0.0005
E	± 0.025	± 0.025	± 0.025	± 0.0010	± 0.001	± 0.0010
G	± 0.025	± 0.130	± 0.025	± 0.0010	± 0.005	± 0.0010
J	± 0.005	± 0.025	± 0.05 ± 0.13	± 0.0002	± 0.001	± 0.002 ± 0.005
K	± 0.013	± 0.025	± 0.05 ± 0.13	± 0.0005	± 0.001	± 0.002 ± 0.005
L	± 0.025	± 0.025	± 0.05 ± 0.13	± 0.0010	± 0.001	± 0.002 ± 0.005
M	± 0.08 ± 0.18	± 0.13	± 0.05 ± 0.13	± 0.003 ± 0.007	± 0.005	± 0.002 ± 0.005
N	± 0.08 ± 0.18	± 0.025	± 0.05 ± 0.13	± 0.003 ± 0.007	± 0.001	± 0.002 ± 0.005
U	± 0.13 ± 0.38	± 0.13	± 0.08 ± 0.25	± 0.005 ± 0.015	± 0.005	± 0.003 ± 0.010

Varies depending on the insert size for insert shapes H . O . P . S . T . C . E . M . W . R . V and D See table below
Insert shape H . O . P . S . T . C . E . M . W . R

inscribed circle diameter		Tolerances for M				Tolerances for d			
		Class M		Class U		Class M.J.K.L		Class U	
(mm)	in	(mm)	in	(mm)	in	(mm)	in	(mm)	in
6.35	0.250	0.08	0.003	± 0.13	± 0.005	± 0.05	± 0.002	± 0.08	± 0.003
9.525(10)	0.375	0.08	0.003	± 0.13	± 0.005	± 0.05	± 0.002	± 0.08	± 0.003
12.7(12)	0.500	0.13	0.005	± 0.20	± 0.008	± 0.08	± 0.003	± 0.13	± 0.005
15.875(16)	0.625	0.15	0.006	± 0.27	± 0.011	± 0.10	± 0.004	± 0.18	± 0.007
19.05(20)	0.750	0.15	0.006	± 0.27	± 0.011	± 0.10	± 0.004	± 0.18	± 0.007
25.4	1.000	0.18	0.007	± 0.38	± 0.015	± 0.13	± 0.005	± 0.25	± 0.010

DRILLING INSERTS

Schneidplatten zum Bohren

ISO indexable insert code key
ISO Kennzeichnung

Insert shape D

inscribed circle diameter		Tolerances for m		Tolerances for d	
(mm)	in	(mm)	in	(mm)	in
6.35	0.250	±0.11	±0.004	±0.05	±0.002
9.525	0.375	±0.11	±0.004	±0.05	±0.002
12.70	0.500	±0.15	±0.006	±0.08	±0.003
15.875	0.625	±0.18	±0.007	±0.10	±0.004
19.05	0.750	±0.18	±0.007	±0.10	±0.004

Insert shape V

inscribed circle diameter		Tolerances for m		Tolerances for d	
(mm)	in	(mm)	in	(mm)	in
6.35	0.250	±0.15	±0.006	±0.05	±0.002
9.525	0.375	±0.15	±0.006	±0.05	±0.002
12.70	0.500	±0.20	±0.008	±0.08	±0.003
15.875	0.625	±0.27	±0.011	±0.10	±0.004
19.05	0.750	±0.27	±0.011	±0.10	±0.004

Chipbreaker and fixing type / Spanformstufen und Klemmung

N	R	F	A	M	G	W	T
						Special design	

Cutting edge condition / Schneidelänge

mm	Integers to be preceded by 0, eg. 9.52mm indicated with 09.												

Comparison of cutting edge length (mm) with the standard I.C(inch)

I.C=d	3.97	4.76	5.56	6.35	7.94	9.52	11.1	12.7	14.29	15.88	17.46	19.05	22.22	25.4	31.75
	03	04	05	06	07	09	11	12	14	15	17	19	22	25	31

Insert thickness / Dicke

	00s=0.79	02s=2.38	04s=4.76	06s=6.35	T9s=9.72
	T0s=0.99	T2s=2.58	T4s=4.96	T6s=6.75	11s=11.11
	01s=1.59	03s=3.18	05s=5.56	07s=7.94	12s=12.70
	T1s=1.98	T3s=3.97	T5s=5.95	09s=9.52	

Nose radius / Verrundungsradius

Radius
02-0.2
04-0.4
08-0.8
12-1.2
16-1.6
20-2.0
24-2.4
32-3.2
x-other
MO

Cutting edge condition / Schneideform

F		Sharp cutting edge
E		ER treated cutting edge
T		Negative land
S		Negative land and ER treated cutting edge

Feeding direction / Vorschubrichtung

R	
L	
N	


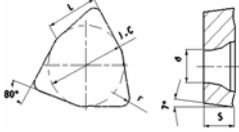
Chipbreakers code / Spanformstufe


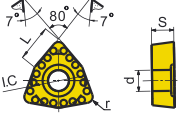
Position 10 indicates the cutting properties and chipbreakers of inserts


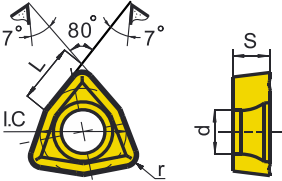
DRILLING INSERTS

Schneidplatten zum Bohren

Drilling inserts
Schneidplatten zum Bohren

 	Type / Typ	Dimension(mm) Abmessungen					Grades Sorte							
		L	I.C	s	d	r	YBC251	YBC351	YBG201	YBG40	YB235	YC40	YD101	YD201
WCMX030208-PG		3.8	5.56	2.38	2.8	0.8			●					
WCMX040208R-PG		4.3	6.35	2.38	3.1	0.8			●					
WCMX050308R-PG		5.4	7.94	3.18	3.2	0.8			●					
WCMX06T308R-PG		6.5	9.525	3.97	3.7	0.8			●					
WCMX080412R-PG		8.7	12.7	4.76	4.3	1.2			●					

 	Type / Typ	Dimension(mm) Abmessungen					Grades Sorte							
		L	I.C	s	d	r	YBC251	YBC351	YBG201	YBG40	YC40	YB235	YD101	YD201
WCMX030208-D		3.8	5.56	2.38	2.8	0.8				●	○			
WCMX040208-D		4.3	6.35	2.38	3.1	0.8				●	○			
WCMX050308-D		5.4	7.94	3.18	3.2	0.8				●	○			
WCMX06T308-D		6.5	9.525	3.97	3.7	0.8				●	○			
WCMX080412-D		8.7	12.70	4.76	4.3	1.2				●	○			

 	Type / Typ	Dimension(mm) Abmessungen					Grades Sorte							
		L	I.C	s	d	r	YBC251	YBC351	YBG201	YBG40	YB235	YC40	YD101	YD201
WCMX030208-53		3.8	5.56	2.38	2.8	0.8			●	●				
WCMX040202		4.3	6.35	2.38	2.8	0.2								
WCMX040208R-53		4.3	6.35	2.38	3.1	0.8			●	●				○
WCMX050308R-53		5.4	7.94	3.18	3.2	0.8			●	●				○
WCMX06T308R-53		6.5	9.525	3.97	3.7	0.8			●	●				○
WCMX080412R-53		8.7	12.7	4.76	4.3	1.2			●	●				○
WCMX080412T		8.7	12.7	4.76	4.3	1.2								○
WCMX06T308T		6.5	9.525	3.97	3.7	0.8								○

● ex stock / ab Lager / pris en magasin

○ short-term delivery / kurzfristige Lieferung / délai de livraison au plus court

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