



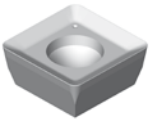
# Jongen Werkzeugtechnik GmbH & Co. KG

## Internal Product Information

# FP 332 HT50

Our standard insert FP 332 is now also available with the coating type HT50.

### Technical Data:

	<b>FP 332 HT50</b> 7,50 € / piece*	Measures: 9,0 x 9,0 x 3,97, r=0,8, Insert seat: B12 Precision ground with high positive chip-groove and rounded cutting edge. Packing units: 20 pcs.
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\* price plus V.A.T.

### The quality HT50:

Code 22, ISO-Classification P30-P35

Very tough carbide type with a new developed TIALN-coating for middle up to high cutting speeds for high tooth feed rates. This quality is especially suitable for dry milling. Application areas are roughing and finishing almost all materials such as, structural steel, tool steel, tempered steel, unalloyed, low alloyed and high grade steel, as well as grey cast iron, grey cast iron with globular graphite etc.

### Cutting Data Recommendations:

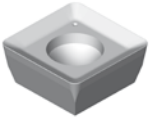
Material	Cutting speed $V_c$ in m/min	Feed rate per tooth $F_z$ in mm
Unalloyed steel, structural steel	300 (180-350)	0,2 (0,1-0,4)
Low alloy steel	250 (150-300)	0,2 (0,1-0,4)
High alloyed steel	250 (150-300)	0,2 (0,1-0,4)
Stainless steel, high grade steel	240 (150-320)	0,2 (0,1-0,3)
Cast Iron with globular graphite	200 (180-250)	0,2 (0,1-0,4)



# FP 332 K15M

Our standard insert FP 332 is now also available in the quality K15M.

## Technical Data:

	<b>FP 332 K15M</b> 6,70 € / piece*	Measures: 9,0 x 9,0 x 3,97, r=0,6, Insert seat: B12 Precision ground with high positive and polished chip-groove Packing units: 20 pcs.
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\* price plus V.A.T.

## The quality K15M:

Code 8, Iso- Classification K10

Very wear-resistant type for processing of nonferrous metals, as aluminium up to ca. 8% Si, copper, etc. as well as for processing of synthetic materials.

## Cutting Data Recommendations:

Material	Cutting speed $V_c$ in m/min	Feed rate per tooth $F_z$ in mm
Aluminium up to ca.8 % Si	1.500 (500-2.500)	0,2 (0,1-0,4)
Copper and copper alloys	350 (250-500)	0,2 (0,1-0,4)
Synthetic materials	500 (150-1.000)	0,2 (0,1-0,4)