





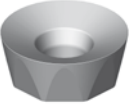
Jongen Werkzeugtechnik GmbH & Co. KG

Internal Product Information



Our standard inserts FP 808, 810 and 812 are now also available in the quality K15M.

Technical Data:

	FP 808 K15M 7,00 € / piece*	Measures: \varnothing 8 x 3,18, Insert seat: C6, Packing unit 20 pcs. Precision ground with high positive and polished chip-groove
	FP 810 K15M 7,30 € / piece*	Measures: \varnothing 10 x 3,97, Insert seat: C7, Packing unit 20 pcs. Precision ground with high positive and polished chip-groove
	FP 812 K15M 9,00 € / piece*	Measures: \varnothing 12 x 4,76, Insert seat: C8, Packing unit 20 pcs. Precision ground with high positive and polished chip-groove

* 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)