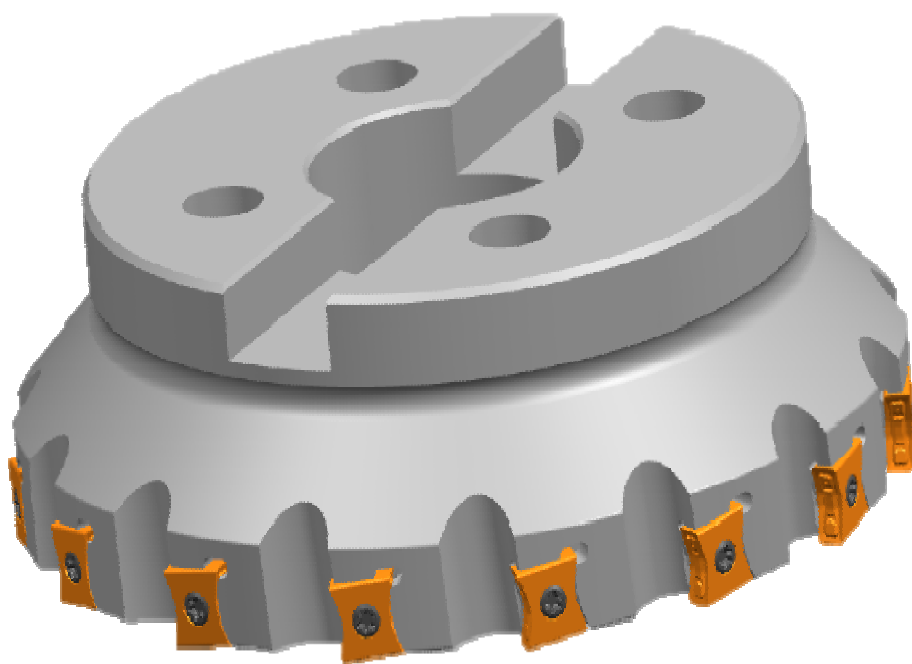




Tangential Double Side Heavy Face Milling





切削刀具新产品
CUTTING TOOLS

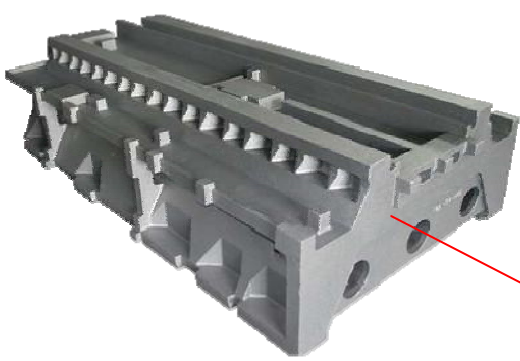
铣削刀片 • Milling Inserts

Tangential Double Side Heavy Face Milling

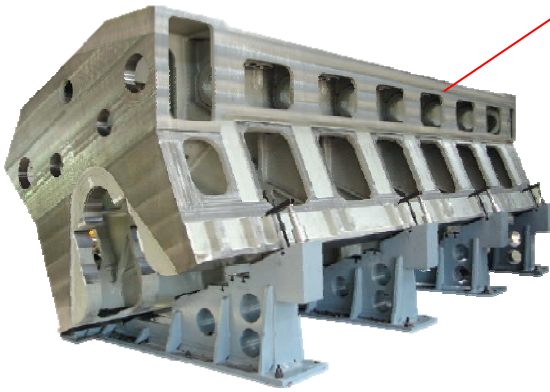
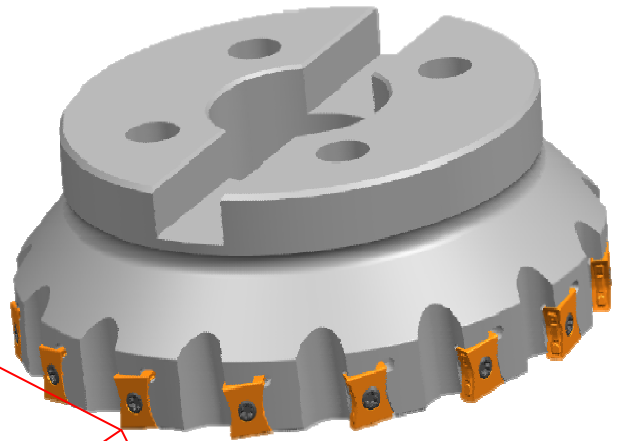
—— LN□T+MVA190

Application

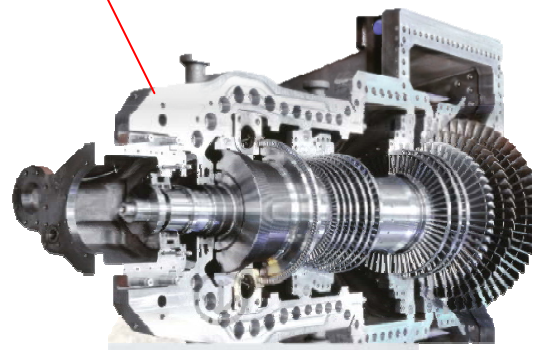
MVA190+LN□T series tools have wide range of application, having tangential structure, can be available for continue milling for large workpiece.



Lathe Bed



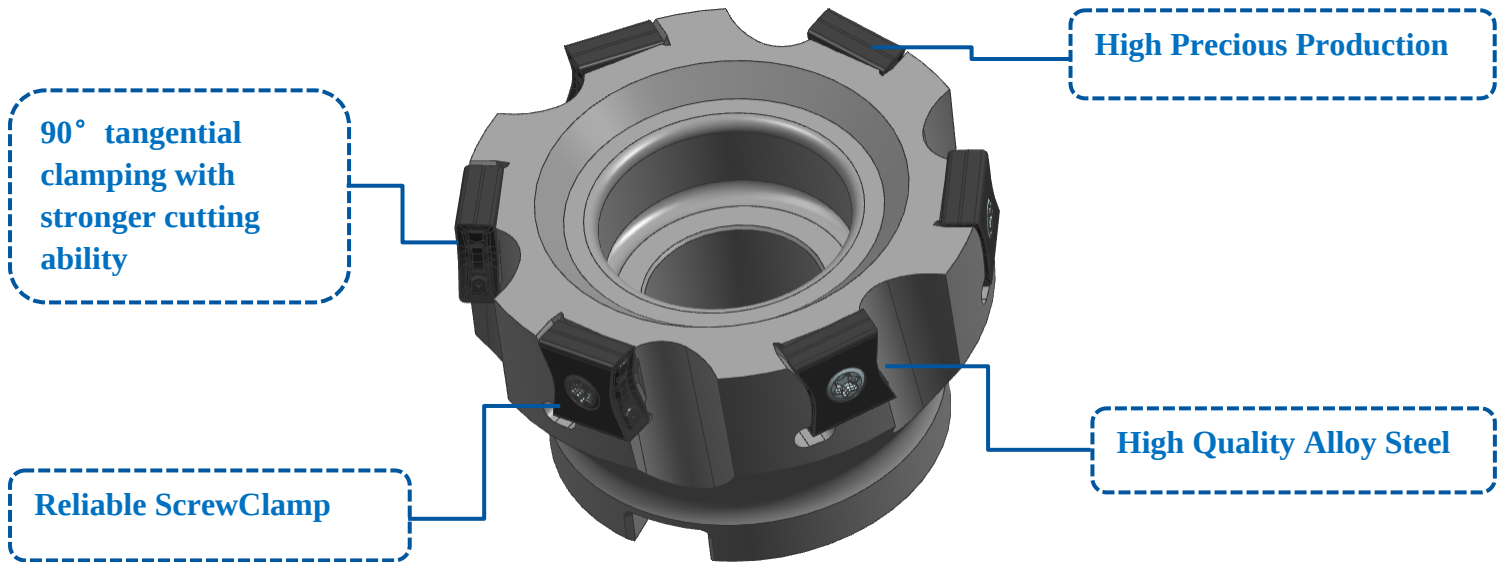
Ship Engine Cylinder



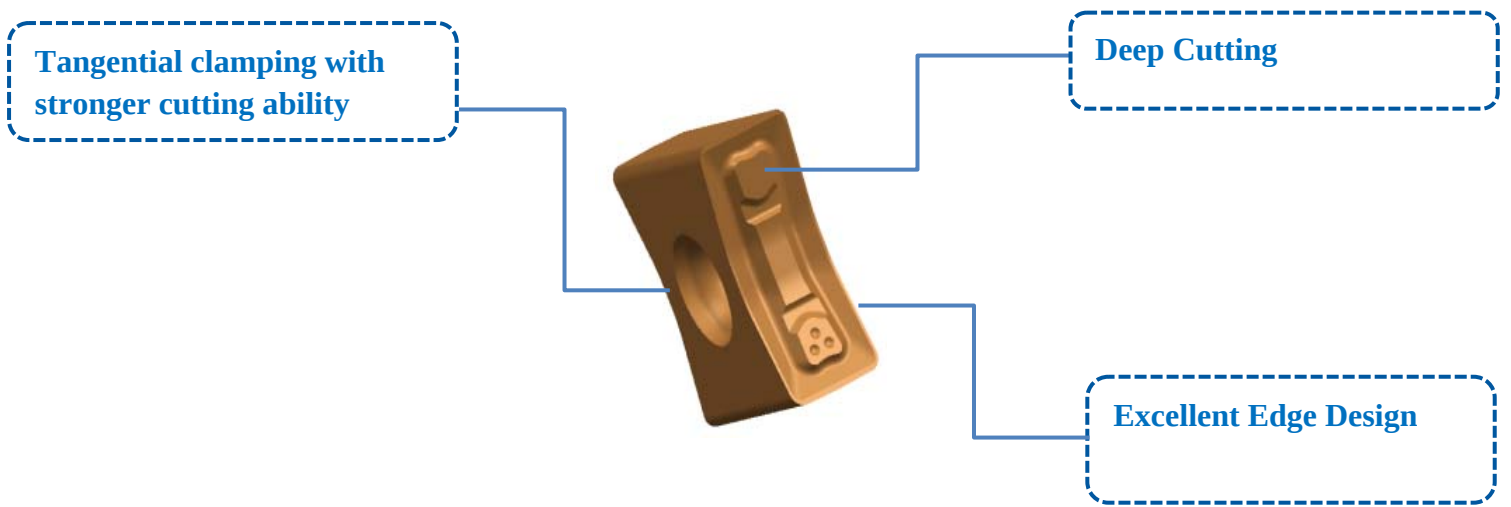
**Turbine
Monoblock**



Cutter



Insert





Geometry

Geometry	PIC.	Application
GL		Light Cutting Big rake angle with small edge land
GM		Medium Cutting Medium edge land
GH		Heavy Cutting Big room for heavy cutting

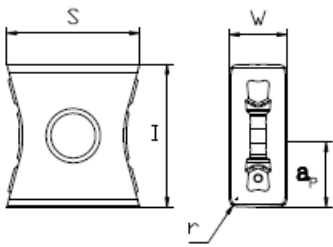
Grades

ISO	Steel P					Stainless Steel M					Cast Iron K					Nonferrous Material N				HRSA S				
	P01	P10	P20	P30	P40	M01	M10	M20	M30	M40	K01	K10	K20	K30	K40	N01	N10	N20	N30	S01	S10	S20	S30	S40
Grade																								

Inserts

LNQT15

●: Stable
 ●: Normal
 ⊕: Unstable

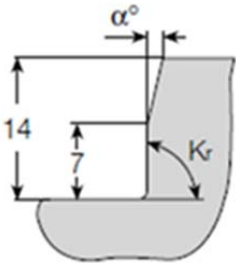
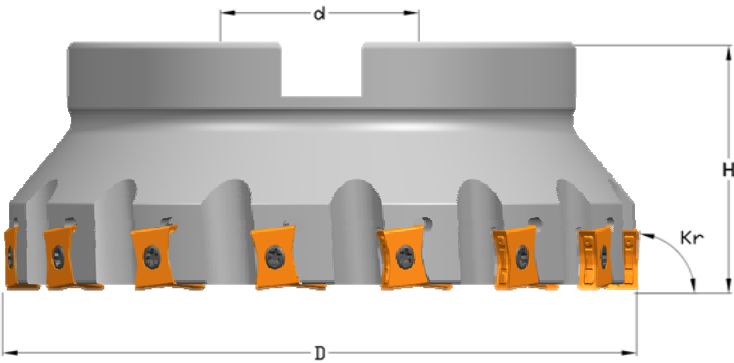
			Workpiece Material		P	Steel						
					M	Stainless Steel						
					K	Cast Iron						
					N	Non-ferrous Metal						
					S	Heat-resistant Alloy, Ti Alloy						
					H	High Hardness Material						
Application	Appearance	Insert Type	Dimension					Grade				
			S	W	a _p	I	r	GP4225	GA4230	GS4130	GK2115	GK4125
Light Cutting		LNQT150608-GL	13.9	6	7	15	0.8					
Medium Cutting		LNMT150608-MM	13.9	6	7	15	0.8					
Heavy Cutting		LNMT150608-GH	13.9	6	7	15	0.8					

● Stock ○ Order

Cutter

MVA190

◆ Arbor



$Kr=90^\circ$
 $D \leq 80\text{mm}, \alpha = 6^\circ$
 $D \geq 100\text{mm}, \alpha = 4.5^\circ$
 $D=50\text{mm}, \alpha = 8^\circ \quad Kr=91^\circ$

Fig1

Type	stock	Z	ap (mm)	Dimension			Parts		Inserts	Shape
				ΦD	H	Φd	Screw	Wrench		
MVA190-050R04A22-LN15	●	4	7	50	40	22	SI60M4*11	TT15P	LN□T15	Fig1
MVA190-050L04A22-LN15	○	4		50	40	22				
MVA190-063R05A22-LN15	●	5		63	40	22				
MVA190-063L05A22-LN15	○	5		63	40	22				
MVA190-080R06B27-LN15	●	6		80	50	27				
MVA190-080L06B27-LN15	○	6		80	50	27				
MVA190-100R08B32-LN15	●	8		100	50	32				
MVA190-100L08B32-LN15	○	8		100	50	32				
MVA190-125R10B40- LN15	●	10		125	63	40				
MVA190-125L10B40- LN15	○	10		125	63	40				
MVA190-160R12C40- LN15	●	12		160	63	40				



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MVA190-160L12C40- LN15	○	12		160	63	40			
MVA190-200R15C60- LN15	●	15		200	63	60			
MVA190-200L15C60- LN15	○	15		200	63	60			
MVA190-250R20C60- LN15	●	20		250	63	60			
MVA190-250L20C60- LN15	○	20		250	63	60			
MVA190-050R05A22-LN15	●	5		50	40	22			
MVA190-050L05A22-LN15	○	5		50	40	22			
MVA190-063R06A22-LN15	●	6		63	40	22			
MVA190-063L06A22-LN15	○	6		63	40	22			
MVA190-080R08B27-LN15	●	8		80	50	27			
MVA190-080L08B27-LN15	○	8		80	50	27			
MVA190-100R12B32-LN15	●	12		100	50	32			
MVA190-100L12B32-LN15	○	12		100	50	32			
MVA190-125R12B40- LN15	○	12		125	63	40			
MVA190-125L12B40- LN15	○	12		125	63	40			
MVA190-160R15C40- LN15	○	15		160	63	40			
MVA190-160L15C40- LN15	○	15		160	63	40			
MVA190-200R20C60- LN15	○	20		200	63	60			
MVA190-200L20C60- LN15	○	20		200	63	60			
MVA190-250R25C60- LN15	○	25		250	63	60			
MVA190-250L25C60- LN15	○	25		250	63	60			

●Stock○Order

Recommended Cutting Data

Workpiece Materials		Material Hardness	Grade	Cutting Speed	Light Cutting (L)		Medium Cutting (M)		Heavy Cutting (H)	
				Vc (m/min)	Feed (mm/tooth)	Geometry	Feed (mm/tooth)	槽型	Feed (mm/tooth)	Geometry
P	Low Carbon Steel	≤HB180	GA4225 GA4230	220 (180-300)	0.2 (0.1-0.3)	GL	0.25 (0.1-0.4)	MM	0.3 (0.2-0.5)	GH
	Carbon Steel, Alloy Steel	HB180-280	GA4225 GA4230	200 (150-280)	0.2 (0.1-0.3)	GL	0.25 (0.1-0.4)	MM	0.3 (0.2-0.5)	GH
		HB280-350	GA4225 GA4230	150 (120-250)	0.2 (0.1-0.3)	GL	0.25 (0.1-0.4)	MM	0.3 (0.2-0.5)	GH
M	Stainless Steel	≤HB275	GA4225 GA4230	160 (100-250)	0.15 (0.1-0.3)	GL	0.2 (0.1-0.3)	MM	0.25 (0.2-0.4)	GH
K	Gray Cast Iron Nodular Cast Iron	≤HB350	GA4230 GK4125	180 (120-250)	0.2 (0.1-0.3)	GL	0.25 (0.1-0.4)	MM	0.3 (0.2-0.5)	GH
N	Nonferrous Metal	HB60-210	-	-	-	-	-	-	-	-
S	Heat-resistant Alloy and Titanium Alloy	HRC25-35	GA4230	40 (30-60)	0.15 (0.1-0.2)	GL	0.2 (0.1-0.3)	MM	0.25 (0.1-0.4)	GH

Tool Rotate Speed (min⁻¹) = (1000xCutting Speed) ÷ (3.14x Diameter Of Cutting edge)

Workbench Feed (mm/min) =Feed each Pith x tooth Num. x Tool Rotate Speed