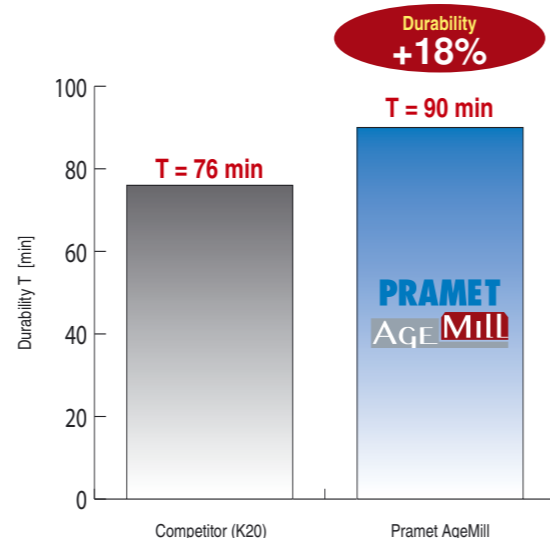


Practical example machining with new inserts SNMR

EXAMPLE 1

Machine: Starrag 1500
 Operation: face milling
 Tool: cutter diameter 125 mm
 Workpiece: ductile cast iron
 Inserts: SPEN 19, (grade K20) - Competitor
 SNMR 1706DZSR-R; 8230 - Pramet
 Cooling: without cooling

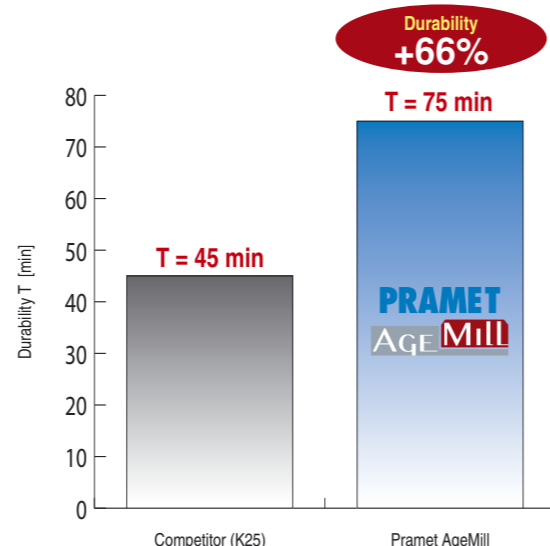
Cutting conditions		Competitors	Pramet	
Cutting speed	v_c	157	157	m.min ⁻¹
Feed per tooth	f	0,4	0,4	mm.tooth ⁻¹
Axial depth of cut	a_p	5,0	5,0	mm
Radial depth of cut	a_e	50	50	mm
Durability	T	76	90	min



EXMAPLE 2

Machine: HCV 200 (100 kW)
 Operation: face milling
 Tool: cutter diameter 250 mm
 Workpiece: GG25
 Inserts: tangential CNM 15, (group K25) - Competitor
 SNMR 1706DZSR-R; 8230 - Pramet
 Cooling: without cooling

Cutting conditions		Competitors	Pramet	
Cutting speed	v_c	160	160	m.min ⁻¹
Feed per tooth	f_z	0,6	0,6	mm.tooth ⁻¹
Axial depth of cut	a_p	7,0	7,0	mm
Radial depth of cut	a_e	220	220	mm
Durability	T	45	75	min



PRAMET
AGE MILL

NEW PRODUCTIVE TOOLS
 WITH INSERTS SNMR 17



STABILITY IN CUT
 LOW CUTTING RESISTANCE
 HIGH QUALITY OF MACHINED SURFACE

SNMR 17

$\kappa_r = 60^\circ$



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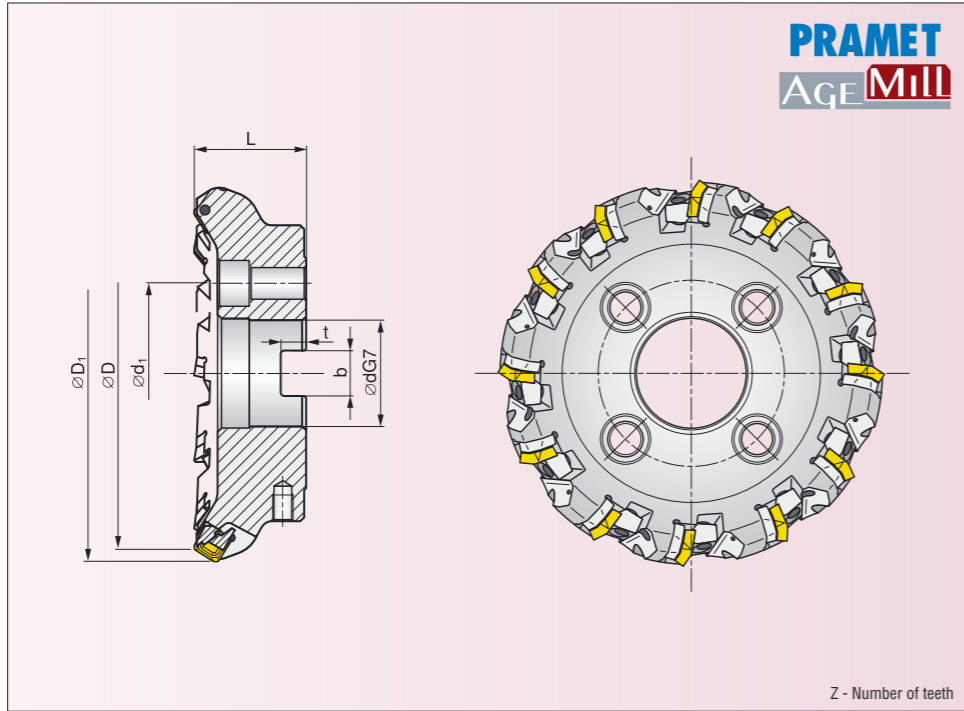
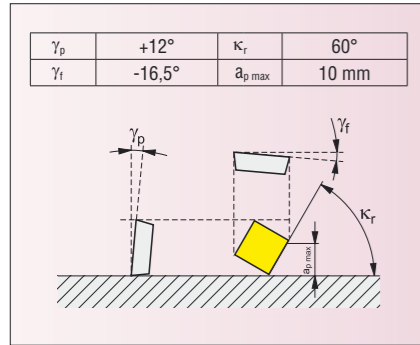


880515



F60SN17X

Face milling cutters - for semi-roughing



ISO	Assortment	Dimensions									kg	Indexable Cutting Inserts
		D	D ₁	dG7	d ₁	d ₂	L	t	b	Z		
125B08R-F60SN17X	●	125	137,5	40	-	-	63	9	16,4	8	3,2	SNMR 1706DZSR-R
160C10R-F60SN17X	●	160	172,5	40	66,7	-	63	9	16,4	10	5,7	
200C12R-F60SN17X	●	200	212,5	60	101,6	-	63	14	25,7	12	9,0	
250C14R-F60SN17X	●	250	262,5	60	101,6	-	63	14	25,7	14	15,4	
315C16R-F60SN17X	●	315	327,5	60	101,6	177,8	63	14	25,7	16	32,4	

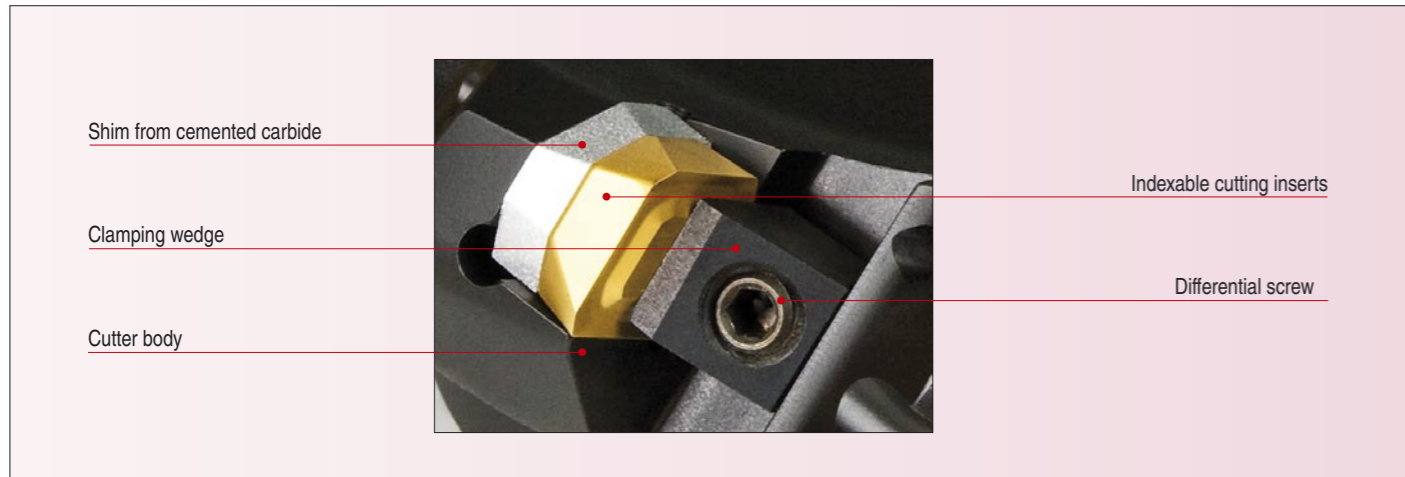
● Stock assortment ○ Non-stock assortment

All dimensions in [mm]

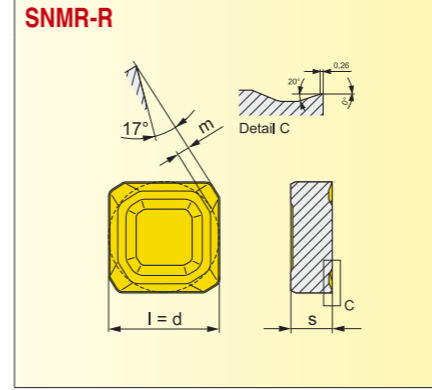
SPARE PARTS:

ISO	Spare parts					
	Shim	Screw	Key	Clamping wedge	Differential screw	Key
125B08R-F60SN17X	SSN 170512	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04
160C10R-F60SN17X						
200C12R-F60SN17X						
250C14R-F60SN17X						
315C16R-F60SN17X						

DESIGN OF INDEXABLE INSERT CLAMPING:



Indexable cutting inserts SNMR 17



● Stock assortment ○ Non-stock assortment

ISO	ANSI	Grade		Dimensions			
		8230	8240	l	d	s	m
SNMR 1706DZSR-R	SNMR -4DZSR-R	●	●	17,000	17,000	6,55	1,97

All dimensions in [mm]

Assortment of inserts SNMR 17

Basic shape of insert	Cutting conditions	Initial cutting conditions			
		P	M	K	S
SNMR 1706DZSR-R; 8230	cutting speed [m.rev ⁻¹]	205 ÷ 315	120 ÷ 185	190 ÷ 295	40 ÷ 90
	feed [mm.tooth ⁻¹]	0,30 ÷ 0,55	0,30 ÷ 0,41	0,30 ÷ 0,55	0,30 ÷ 0,33
	depth of cut [mm]	0,5 ÷ 10,0	0,5 ÷ 7,5	0,5 ÷ 10,0	0,5 ÷ 6,0
SNMR 1706DZSR-R; 8240	cutting speed [m.rev ⁻¹]	205 ÷ 300	120 ÷ 180	190 ÷ 285	40 ÷ 90
	feed [mm.tooth ⁻¹]	0,30 ÷ 0,55	0,30 ÷ 0,41	0,30 ÷ 0,55	0,30 ÷ 0,33
	depth of cut [mm]	0,5 ÷ 10,0	0,5 ÷ 7,5	0,5 ÷ 10,0	0,5 ÷ 6,0

Technical information

