

# Tech-News

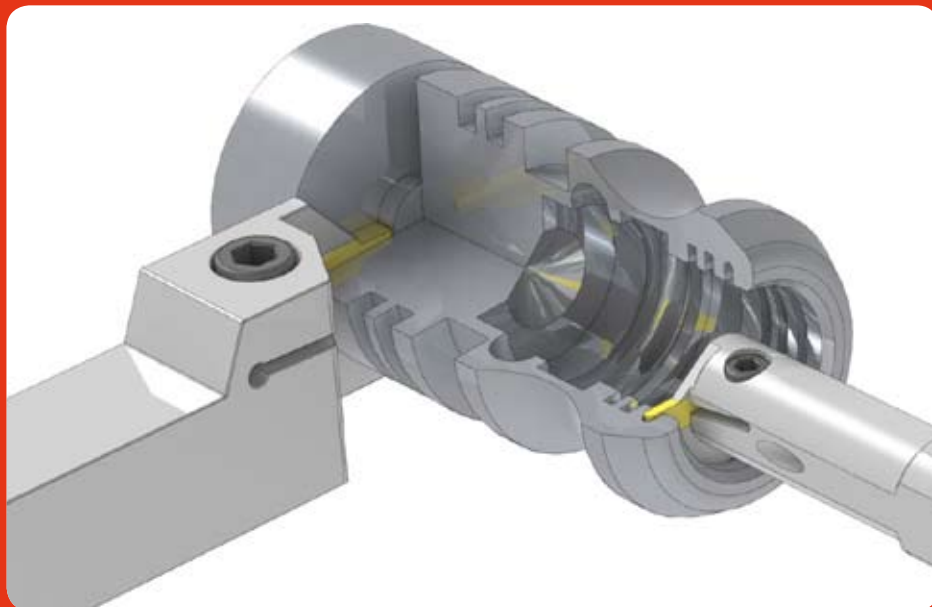
## G.T.S. - system do rowkowania

**3in1**

3 zastosowania jednej płytki

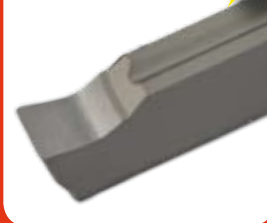
- Wewnętrzne rowkowanie promieniowe
- Zewnętrzne rowkowanie promieniowe
- Rowkowanie czołowe

**Wysokie bezpieczeństwo procesu przy rowkowaniu**



.10-D/ GK 1210

**New!**



.52-DM/ GM 5130

**New!**

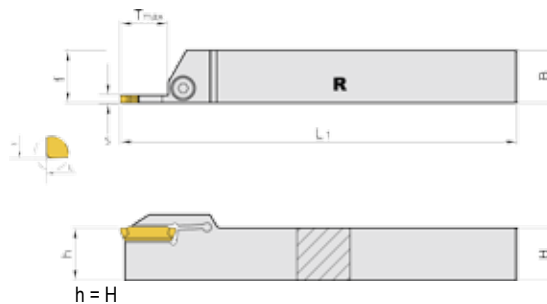
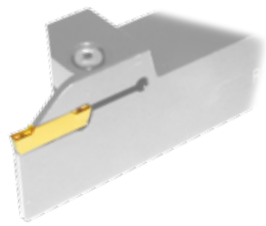


### Zalety systemu G.T.S.

- Unikatowy system zacisku „W” zapewnia wysoką stabilność podczas operacji toczenia rowków
- Płytki GTS jednakowe do obróbki zewnętrznej jak i wewnętrznej, również dla noży w wersji prawej i lewej (Oszczędność kosztów!), także do rowkowania czołowego
- Płytki z łamaczem „.30/.50” odkrywają nowe możliwości obróbki od zgrubnej po wykańczającą
- Płytki dostępne z magazynu; szlifowana wersja DG, jak również precyzyjnie spiekane w wersji DM
- Specjalny drobnoziarnisty gatunek węgla (GM5130) zapewnia najwyższą stabilność krawędzi

## 260-D

## Rowkowanie, toczenie wzdłużne / Grooving, Groove Turning



| Oznaczenie<br>Part Number | Magazyn<br>Stock |   | Wymiary<br>Dimensions [mm] |                |      |                  | <br>Strona / Page: 7<br>s [mm] | Części zamienne Spare Parts                                                         |                                                                                     |
|---------------------------|------------------|---|----------------------------|----------------|------|------------------|-----------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
|                           | R                | L | H=B                        | L <sub>1</sub> | f    | T <sub>max</sub> |                                                                                                                 |  |  |
| R/L 260. 1212. 015        | ●                |   | 12                         | 80             | 12.3 | 12               | 216.0150.30<br>s=1,5 mm                                                                                         | 32.15.115                                                                           | 48.12.606                                                                           |
| R/L 260. 1616. 015        | ●                | ○ | 16                         | 100            | 16.3 | 14.5             |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 2020. 015        | ○                | ○ | 20                         | 125            | 20.3 | 14.5             |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 2525. 015        | ○                |   | 25                         | 150            | 25.4 | 14.5             |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 1212. 02         | ●                |   | 12                         | 100            | 12.3 | 12               | 30<br>216.0200.51<br>55<br>s=2,0 mm                                                                             |                                                                                     |                                                                                     |
| R/L 260. 1616. 02         | ●                | ● | 16                         | 100            | 16.3 | 14.5             |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 2020. 02         | ●                | ● | 20                         | 125            | 20.3 | 14.5             |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 2525. 02         | ●                | ○ | 25                         | 150            | 25.4 | 14.5             |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 1616. 025        | ●                | ● | 16                         | 100            | 16.3 | 14.5             | 50<br>218.0250.51<br>55<br>s=2,5 mm                                                                             |                                                                                     |                                                                                     |
| R/L 260. 2020. 025        | ●                | ● | 20                         | 125            | 20.3 | 14.5             |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 2525. 025        | ○                | ○ | 25                         | 150            | 25.4 | 14.5             |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 1212. 03         | ●                |   | 12                         | 100            | 12.3 | 12               | 50<br>222.0300.51<br>55<br>s=3,0 mm                                                                             | 32.15.114                                                                           | 48.11.602                                                                           |
| R/L 260. 1616. 03         | ●                | ● | 16                         | 100            | 16.3 | 18               |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 2020. 03         | ●                | ● | 20                         | 125            | 20.4 | 18               |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 2525. 03         | ●                | ● | 25                         | 150            | 25.4 | 18               |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 3232. 03         | ○                | ○ | 32                         | 170            | 32.4 | 18               |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 1616. 04         |                  |   | 16                         | 100            | 16.3 | 18               | 50<br>222.0400.51<br>55<br>s=4,0 mm                                                                             |                                                                                     |                                                                                     |
| R/L 260. 2020. 04         | ●                | ● | 20                         | 125            | 20.4 | 18               |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 2525. 04         | ●                | ● | 25                         | 150            | 25.4 | 18               |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 3232. 04         | ○                | ○ | 32                         | 170            | 32.4 | 18               |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 2020. 05         | ○                | ○ | 20                         | 125            | 20.5 | 23               | 50<br>226.0500.51<br>55<br>s=5,0 mm                                                                             |                                                                                     |                                                                                     |
| R/L 260. 2525. 05         | ●                | ○ | 25                         | 150            | 25.5 | 23               |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 3232. 05         | ○                | ○ | 32                         | 170            | 32.5 | 23               |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 2020. 06         | ○                |   | 20                         | 125            | 20.6 | 23               | 50<br>226.0600.51<br>55<br>s=6,0 mm                                                                             |                                                                                     |                                                                                     |
| R/L 260. 2525. 06         | ○                | ○ | 25                         | 150            | 25.6 | 23               |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 260. 3232. 06         | ○                | ○ | 32                         | 170            | 32.6 | 23               |                                                                                                                 |                                                                                     |                                                                                     |

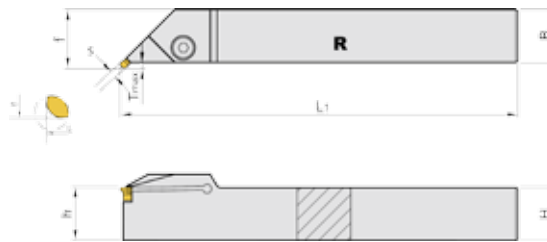
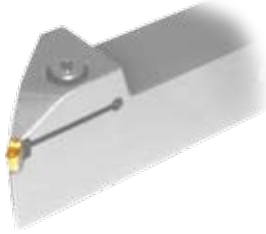
Dostępne w wersji prawej lub lewej / state R or L version

● Magazyn JD / JD-Stock

○ ograniczony zapas / limited stock

**262-D**

# Podcinanie zewnętrzne / Corner releasing, external


 $h = H$ 

Narzędzia  
do toczenia  
Turning Tools

Narzędzia  
do frezowania  
Milling Tools

Frezy monolityczne  
Solid Carbide  
Endmills

Narzędzia  
do rowkowania  
Grooving Tools

Mini Narzędzia  
tokarskie  
Mini Tools

Micro Narzędzia  
tokarskie  
Micro Tools

Narzędzia  
do gwintów  
Threading Tools

Wiertła składane  
Indexable Drills

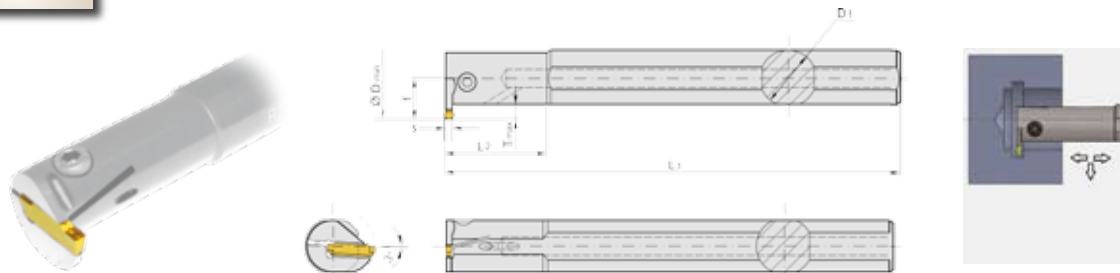
Wiertła  
pełnowęglikowe  
Solid Carbide Drills

| Oznaczenie<br>Part Number | Magazyn<br>Stock |   | Wymiary<br>Dimensions [mm] |                |    |                  | Strona / Page: 7<br>s [mm] | Części zamienne Spare Parts |           |
|---------------------------|------------------|---|----------------------------|----------------|----|------------------|----------------------------|-----------------------------|-----------|
|                           | R                | L | H=B                        | L <sub>1</sub> | f  | T <sub>max</sub> |                            |                             |           |
| R/L 262. 2020. 03         | ○                |   | 20                         | 125            | 23 | 3                | 50                         | 32.15.114                   | 48.11.602 |
| R/L 262. 2525. 03         |                  |   | 25                         | 150            | 28 | 3                | 222.0300.51<br>55          |                             |           |
| R/L 262. 3232. 03         |                  |   | 32                         | 170            | 35 | 3                | s=3,0 mm                   |                             |           |
| R/L 262. 2020. 04         |                  |   | 20                         | 125            | 23 | 3                | 50                         |                             |           |
| R/L 262. 2525. 04         | ○                |   | 25                         | 125            | 28 | 3                | 222.0400.51<br>55          |                             |           |
| R/L 262. 3232. 04         |                  |   | 32                         | 170            | 35 | 3                | s=4,0 mm                   |                             |           |
| R/L 262. 2020. 05         |                  |   | 20                         | 125            | 24 | 4                | 50                         |                             |           |
| R/L 262. 2525. 05         |                  |   | 25                         | 150            | 29 | 4                | 226.0500.51<br>55          |                             |           |
| R/L 262. 3232. 05         |                  |   | 32                         | 170            | 36 | 4                | s=5,0 mm                   |                             |           |
| R/L 262. 2020. 06         |                  |   | 20                         | 125            | 24 | 4                | 50                         |                             |           |
| R/L 262. 2525. 06         |                  |   | 25                         | 150            | 29 | 4                | 226.0600.51<br>55          |                             |           |
| R/L 262. 3232. 06         |                  |   | 32                         | 170            | 36 | 4                | s=6,0 mm                   |                             |           |

Dostępne w wersji prawej lub lewej / state R or L version

● Magazyn JD / JD-Stock

○ ograniczony zapas / limited stock

**270-D**
**Rowkowanie wewnętrzne / Grooving, internal**


| Oznaczenie<br>Part Number | Magazyn<br>Stock |   | Wymiary<br>Dimensions [mm] |                |                |                |                  |      |                                                                                     | <br>Strona / Page: 7<br>s [mm] | Części zamienne<br>Spare Parts                                                      |  |
|---------------------------|------------------|---|----------------------------|----------------|----------------|----------------|------------------|------|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|--|
|                           | R                | L | D <sub>min</sub>           | D <sub>1</sub> | L <sub>1</sub> | L <sub>2</sub> | T <sub>max</sub> | f    |  |                                                                                                                  |  |  |
| R/L 270. 0016. 015        |                  |   | 20                         | 16             | 125            | 35             | 4                | 11.3 | 216.0150. <sup>30</sup> <sub>51</sub><br>s=1,5 mm                                   | 32.45.124                                                                                                        | 48.12.604                                                                           |  |
| R/L 270. 0020. 015        |                  |   | 25                         | 20             | 150            | 45             | 4                | 13.1 |                                                                                     | 32.15.115                                                                                                        | 48.12.606                                                                           |  |
| R/L 270. 0025. 015        |                  |   | 29                         | 25             | 200            | 45             | 4                | 16.2 |                                                                                     |                                                                                                                  |                                                                                     |  |
| R/L 270. 0016. 02         | ●                | ● | 20                         | 16             | 135            | 35             | 5                | 12.4 | 216.0200. <sup>30</sup> <sub>51</sub><br>55<br>s=2,0 mm                             | 32.45.124                                                                                                        | 48.12.604                                                                           |  |
| R/L 270. 0020. 02         | ●                | ● | 25                         | 20             | 150            | 45             | 5                | 14.0 |                                                                                     | 32.15.115                                                                                                        | 48.12.606                                                                           |  |
| R/L 270. 0025. 02         | ○                | ○ | 29                         | 25             | 200            | 45             | 5                | 17.2 |                                                                                     |                                                                                                                  |                                                                                     |  |
| R/L 270. 0016. 025        | ●                | ● | 21                         | 16             | 125            | 35             | 6                | 13.3 | 218.0250. <sup>50</sup> <sub>51</sub><br>s=2,5 mm                                   | 32.45.124                                                                                                        | 48.12.604                                                                           |  |
| R/L 270. 0020. 025        |                  |   | 25                         | 20             | 150            | 45             | 6                | 15.1 |                                                                                     | 32.15.115                                                                                                        | 48.12.606                                                                           |  |
| R/L 270. 0025. 025        |                  |   | 29                         | 25             | 200            | 45             | 6                | 18.2 |                                                                                     |                                                                                                                  |                                                                                     |  |
| R/L 270. 0020. 03         | ●                | ● | 25                         | 20             | 150            | 45             | 6                | 15.6 | 222.0300. <sup>50</sup> <sub>51</sub><br>55<br>s=3,0 mm                             | 32.15.115                                                                                                        | 48.12.606                                                                           |  |
| R/L 270. 0025. 03         | ●                | ● | 31                         | 25             | 200            | 45             | 6                | 18.9 |                                                                                     |                                                                                                                  |                                                                                     |  |
| R/L 270. 0032. 03         | ●                | ● | 37                         | 32             | 250            | 65             | 6                | 21.5 |                                                                                     |                                                                                                                  |                                                                                     |  |
| R/L 270. 0020. 04         | ●                | ● | 25                         | 20             | 150            | 45             | 6                | 15.6 | 222.0400. <sup>50</sup> <sub>51</sub><br>55<br>s=4,0 mm                             |                                                                                                                  |                                                                                     |  |
| R/L 270. 0025. 04         | ●                | ○ | 31                         | 25             | 200            | 45             | 6                | 18.9 |                                                                                     |                                                                                                                  |                                                                                     |  |
| R/L 270. 0032. 04         | ●                |   | 37                         | 32             | 250            | 65             | 6                | 21.5 |                                                                                     |                                                                                                                  |                                                                                     |  |
| R/L 270. 0025. 05         | ○                |   | 31                         | 25             | 200            | 45             | 8                | 19.4 | 226.0500. <sup>50</sup> <sub>55</sub><br>s=5,0 mm                                   |                                                                                                                  |                                                                                     |  |
| R/L 270. 0032. 05         | ○                |   | 37                         | 32             | 250            | 65             | 8                | 21.5 |                                                                                     |                                                                                                                  |                                                                                     |  |
| R/L 270. 0025. 06         | ○                | ○ | 31                         | 25             | 200            | 45             | 8                | 19.4 | 226.0600. <sup>50</sup> <sub>55</sub><br>s=6,0 mm                                   |                                                                                                                  |                                                                                     |  |
| R/L 270. 0032. 06         | ○                | ○ | 37                         | 32             | 250            | 65             | 8                | 21.5 |                                                                                     |                                                                                                                  |                                                                                     |  |

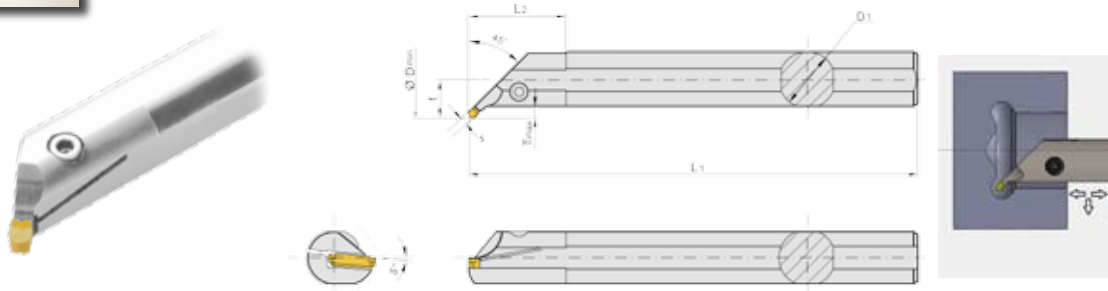
Dostępne w wersji prawej lub lewej / state R or L version

● Magazyn JD / JD-Stock

○ ograniczony zapas / limited stock

**272-D**

## Podcinanie wewnętrzne / Corner releasing, internal



Narzędzia  
do toczenia  
Turning Tools

Narzędzia  
do frezowania  
Milling Tools

Frezy monolityczne  
Solid Carbide  
Endmills

Narzędzia  
do rowkowania  
Grooving Tools

Mini Narzędzia  
tokarskie  
Mini Tools

Micro Narzędzia  
tokarskie  
Micro Tools

Narzędzia  
do gwintów  
Threading Tools

Wiertła składane  
Indexable Drills

Wiertła  
pełnowęglikowe  
Solid Carbide Drills

| Oznaczenie<br>Part Number | Magazyn<br>Stock |   | Wymiary<br>Dimensions [mm] |                |                |                |                  |      | <br>Strona / Page: 7<br>s [mm] | Części zamienne <i>Spare Parts</i>                                                  |                                                                                     |
|---------------------------|------------------|---|----------------------------|----------------|----------------|----------------|------------------|------|-----------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
|                           | R                | L | D <sub>min</sub>           | D <sub>1</sub> | L <sub>1</sub> | L <sub>2</sub> | T <sub>max</sub> | f    |                                                                                                                 |  |  |
| R/L 272. 0020. 03         | ○                |   | 35                         | 20             | 150            | 45             | 3.5              | 13   | 50<br>222.0300.51<br>55<br>s=3,0 mm                                                                             | 32.15.115                                                                           | 48.12.606                                                                           |
| R/L 272. 0025. 03         | ○                |   | 40                         | 25             | 200            | 45             | 3.5              | 15.5 |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 272. 0032. 03         |                  |   | 50                         | 32             | 250            | 65             | 3.5              | 19   |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 272. 0020. 04         | ○                |   | 35                         | 20             | 150            | 45             | 3.5              | 13   | 50<br>222.0400.51<br>55<br>s=4,0 mm                                                                             |                                                                                     |                                                                                     |
| R/L 272. 0025. 04         | ○                |   | 40                         | 25             | 200            | 45             | 3.5              | 15.5 |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 272. 0032. 04         | ○                |   | 50                         | 32             | 250            | 65             | 3.5              | 19   |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 272. 0025. 05         |                  |   | 40                         | 25             | 200            | 45             | 3.5              | 15.5 | 226.0500.50<br>55<br>s=5,0 mm                                                                                   |                                                                                     |                                                                                     |
| R/L 272. 0032. 05         | ○                |   | 50                         | 32             | 250            | 65             | 3.5              | 19   |                                                                                                                 |                                                                                     |                                                                                     |
| R/L 272. 0025. 06         |                  |   | 40                         | 25             | 200            | 45             | 3.5              | 15.5 | 226.0600.50<br>55<br>s=6,0 mm                                                                                   |                                                                                     |                                                                                     |
| R/L 272. 0032. 06         |                  |   | 50                         | 32             | 250            | 65             | 3.5              | 19   |                                                                                                                 |                                                                                     |                                                                                     |

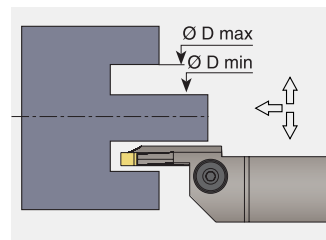
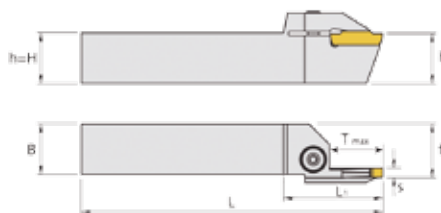
Dostępne w wersji prawej lub lewej / state R or L version

● Magazyn JD / JD-Stock

○ ograniczony zapas / limited stock

## 290-D

## Rowkowanie czołowe / Face



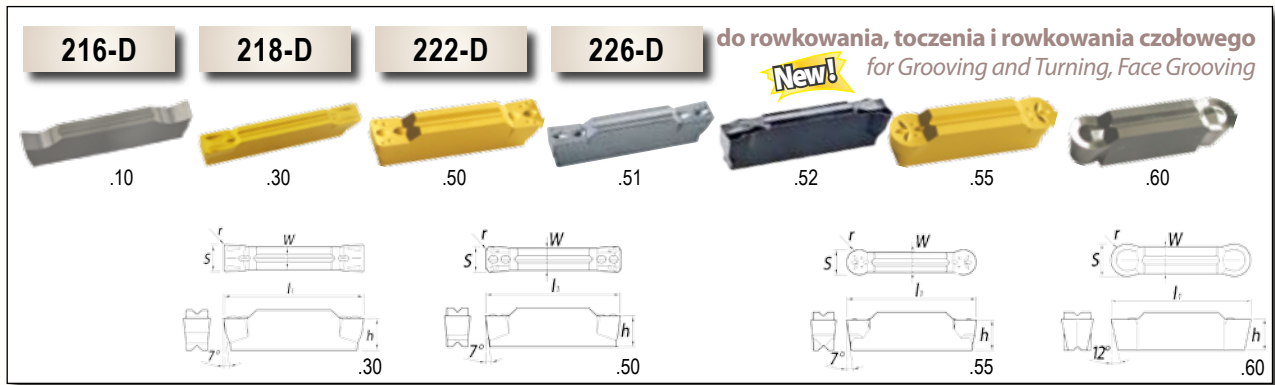
Przedstawione wykonanie prawe

| Oznaczenie<br>Part Number | Magazyn<br>Stock |   | Wymiary [mm]<br>Dimensions |     |                |    |                  |            |                      | <br>Strona / Page: 7 | Części zamienne<br>Spare Parts                                                      |                      |                   |  |  |
|---------------------------|------------------|---|----------------------------|-----|----------------|----|------------------|------------|----------------------|--------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|----------------------|-------------------|--|--|
|                           | R                | L | H=B                        | L   | L <sub>1</sub> | f  | T <sub>max</sub> | Średnica Ø | s [mm]               |                     |  |                      |                   |  |  |
| R/L290. 2525. 03-34/45    | ●                | ○ | 25                         | 150 | 40             | 25 | 17               | 34-45      | 222.0300.50<br>s=3mm |                     |  |                      |                   |  |  |
| R/L290. 2525. 03-39/55    | ●                | ○ | 25                         | 150 | 40             | 25 | 17               | 39-55      |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 03-49/80    | ○                | ○ | 25                         | 150 | 40             | 25 | 17               | 49-80      |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 03-50/60    | ●                | ○ | 25                         | 150 | 40             | 25 | 17               | 50-60      |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 03-60/80    | ●                | ○ | 25                         | 150 | 40             | 25 | 17               | 60-80      |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 03-70/110   | ○                | ○ | 25                         | 150 | 40             | 25 | 17               | 70-110     |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 03-80/110   | ●                | ○ | 25                         | 150 | 40             | 25 | 17               | 80-110     |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 03-100/150  | ○                | ○ | 25                         | 150 | 40             | 25 | 17               | 100-150    |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 03-110/150  | ●                | ○ | 25                         | 150 | 40             | 25 | 17               | 110-150    |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 04-50/60    | ○                | ○ | 25                         | 150 | 45             | 25 | 20               | 50-60      | 222.0400.50<br>s=4mm |                                                                                                        |                                                                                     | 32.30.116<br>(M6x20) | 48.11.602<br>(S5) |  |  |
| R/L290. 2525. 04-60/80    | ○                | ○ | 25                         | 150 | 46             | 25 | 20               | 60-80      |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 04-80/110   | ○                | ○ | 25                         | 150 | 46             | 25 | 20               | 80-110     |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 04-110/150  | ○                | ○ | 25                         | 150 | 46             | 25 | 20               | 110-150    |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 04-140/600  | ○                | ○ | 25                         | 150 | 49             | 25 | 25               | 140-600    |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 05-50/80    | ○                | ○ | 25                         | 150 | 45             | 25 | 20               | 50-80      | 222.0500.50<br>s=5mm |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 05-80/110   | ○                | ○ | 25                         | 150 | 45             | 25 | 20               | 80-110     |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 05-110/150  | ○                | ○ | 25                         | 150 | 45             | 25 | 20               | 110-150    |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 05-140/350  | ○                | ○ | 25                         | 150 | 45             | 25 | 20               | 140-350    |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 05-350/500  | ○                | ○ | 25                         | 150 | 45             | 25 | 20               | 350-500    |                      |                                                                                                        |                                                                                     |                      |                   |  |  |
| R/L290. 2525. 05-140/600  | ○                | ○ | 25                         | 150 | 49             | 25 | 25               | 140-600    |                      |                                                                                                        |                                                                                     |                      |                   |  |  |

Dostępne w wersji prawej lub lewej / state R or L version

● Magazyn JD / JD-Stock

○ ograniczony zapas / limited stock



Narzędzia  
do toczenia  
Turning Tools

Narzędzia  
do frezowania  
Milling Tools

Frezy monolityczne  
Solid Carbide  
Endmills

Narzędzia  
do rowkowania  
Grooving Tools

Mini Narzędzia  
tokarskie  
Mini Tools

Micro Narzędzia  
tokarskie  
Micro Tools

Narzędzia  
do gwintów  
Threading Tools

Wiertła składane  
Indexable Drills

Wiertła  
pełnowęglikowe  
Solid Carbide Drills

| Oznaczenie<br>Part Number                                                                                                                                                                                              | Magazyn<br>Stock |                                      |         |                                           | s<br><br>mm | r<br><br>mm            | l <sub>1</sub><br><br>mm | w<br><br>mm             | h<br><br>mm | Typ noża<br>Toolholder Type |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------|--------------------------------------|---------|-------------------------------------------|-------------|------------------------|--------------------------|-------------------------|-------------|-----------------------------|
|                                                                                                                                                                                                                        | GK 1110          | GK 1210                              | GP 2120 | GM 5130                                   |             |                        |                          |                         |             |                             |
| 216. 0150. 10 - D<br>216. 0150. 30 - DM<br>216. 0150. 30 - DP                                                                                                                                                          |                  | ○<br><br>●                           |         | ○                                         | 1.5         | 0.15                   | 16                       | 1.2                     | 3.5         | .015                        |
| 216. 0200. 10 - D<br>216. 0200. 30 - DG<br>216. 0200. 30 - DM<br>216. 0200. 30 - DP<br>216. 0200. 51 - DG<br>216. 0200. 55 - DG<br>216. 0200. 55 - DM<br>216. 0200. 55 - DP                                            |                  | ●<br><br><br>○<br><br><br>●          |         | ○<br>●<br>●<br>○<br>●<br>●<br>●           | 2.0         | 0.2<br><br><br><br>1.0 | 16                       | 1.6                     | 3.5         | .02                         |
| 218. 0250. 10 - D<br>218. 0250. 50 - DG<br>218. 0250. 50 - DM<br>218. 0250. 50 - DP                                                                                                                                    |                  | ○<br><br><br>○                       |         | ○<br>●<br>○                               | 2.5         | 0.2                    | 18.5                     | 2.0                     | 3.8         | .025                        |
| 222. 0300. 10 - D<br>222. 0300. 50 - 1<br>222. 0300. 50 - DG<br>222. 0300. 50 - DM<br>222. 0300. 50 - DP<br>222. 0300. 51 - DG<br>222. 0300. 52 - DM<br>222. 0300. 55 - DG<br>222. 0300. 55 - DM<br>222. 0300. 55 - DP |                  | ●<br><br><br><br>○<br>●<br><br><br>● |         | ○<br>○<br>●<br>●<br>○<br>○<br>●<br>●<br>● | 3.0         | 0.4<br><br><br><br>1.5 | 21                       | 2.35<br><br><br><br>4.8 | 4.8         | .03                         |
| 222. 0400. 10 - D<br>222. 0400. 50 - DG<br>222. 0400. 50 - DM<br>222. 0400. 50 - DP<br>222. 0400. 51 - DG<br>222. 0400. 55 - DG<br>222. 0400. 55 - DM<br>222. 0400. 55 - DP                                            |                  | ●<br><br><br><br>○<br><br><br>●      |         | ○<br>●<br>●<br>○<br>●<br>○<br>●<br>●      | 4.0         | 0.4<br><br><br>2.0     | 3.3                      | 3.3                     | 4.8         | .04                         |
| 226. 0500. 10 - D<br>226. 0500. 50 - DG<br>226. 0500. 50 - DM<br>226. 0500. 50 - DP<br>226. 0500. 55 - DM<br>226. 0500. 55 - DP<br>226. 0500. 60 - D                                                                   |                  | ○<br><br><br><br><br>●               |         | ○<br>●<br>●<br>○<br>○<br>●                | 5.0         | 0.8<br><br>2.5         | 26                       | 4.1                     | 5.8         | .05                         |
| 226. 0600. 10 - D<br>226. 0600. 50 - DM<br>226. 0600. 50 - DP<br>226. 0600. 55 - DM<br>226. 0600. 55 - DP<br>226. 0600. 60 - D                                                                                         |                  | ○<br><br><br><br>○                   |         | ○<br>○<br>○                               | 6.0         | 0.8<br><br>2.5         | 26                       | 5.0                     | 5.8         | .06                         |
| 232. 0800. 10 - D<br>232. 0800. 50 - DP<br>232. 0800. 51 - D<br>232. 0800. 60 - D                                                                                                                                      |                  | ○<br><br>○                           |         |                                           | 8.0         | 0.8<br><br>4.0         | 31                       | 6.0                     | 6.5         | .08                         |

Płytki przeznaczone są do noży prawych i lewych, również wewnętrznych.  
Inserts can be used in RH and LH toolholders as well as in boring bars.

● Magazyn JD / JD-Stock

○ ograniczony zapas / limited stock

**Zalecane parametry skrawania dla rowkowania i przecinania**  
**Cutting Data Recommendations for Grooving / Parting - off**

| Obrabiany materiał<br>Material |                                                                                | Stop<br>Alloy                                        | Prędkości skrawania $v_c$ [m/min]<br>Cutting Speeds $v_c$ [m/min] |           |           |           |
|--------------------------------|--------------------------------------------------------------------------------|------------------------------------------------------|-------------------------------------------------------------------|-----------|-----------|-----------|
|                                |                                                                                |                                                      | GK 1110                                                           | GK 1210   | GP 2120   | GM 5130   |
| <b>A</b><br><b>(P)</b>         | Stal niestopowa<br>Mild steel                                                  | odprężony termicznie /<br>annealed $\leq 0,15\% C$   | -                                                                 | -         | 120 - 200 | 100 - 180 |
|                                |                                                                                | odprężony termicznie /<br>annealed $0,15\%-0,45\% C$ | -                                                                 | -         | 100 - 200 | 100 - 180 |
|                                |                                                                                | obrabiany cieplnie / heat<br>treated $\geq 0,45\% C$ | -                                                                 | -         | 90 - 180  | 80 - 160  |
|                                | Stal stopowa<br>Alloyed steel                                                  | nisko- / low                                         | -                                                                 | -         | 100 - 200 | 100 - 200 |
|                                |                                                                                | średnio- / medium                                    | -                                                                 | -         | 90 - 160  | 80 - 150  |
|                                |                                                                                | wysoko- / high                                       | -                                                                 | -         | 70 - 100  | 70 - 100  |
| <b>R</b><br><b>(M)</b>         | Stal nierdzewna<br>Stainless steel                                             | austenityczna                                        | -                                                                 | -         | 50 - 160  | 30 - 150  |
|                                |                                                                                | martensitisch                                        | -                                                                 | -         | 50 - 200  | 30 - 180  |
| <b>F</b><br><b>(K)</b>         | Żeliwo szare<br>Grey cast iron                                                 |                                                      | 60 - 100                                                          | 60 - 90   | -         | -         |
| <b>N</b>                       | Aluminium                                                                      | nietwardzalne<br>not hardenable                      | 800 - 1000                                                        | 700 - 850 | -         | -         |
|                                |                                                                                | utwardzalne<br>hardenable                            | 250 - 450                                                         | 250 - 400 | -         | -         |
|                                |                                                                                | > 12% Si                                             | 200 - 300                                                         | 200 - 250 | -         | -         |
|                                | Brąz, mosiądz, mosiądz<br>czerwony<br>Bronze, brass, red brass                 |                                                      | 90 - 200                                                          | 90 - 180  | -         | -         |
| <b>S</b>                       | Stopy żaroodporne,<br>Dodatk stopowy- Ni<br>Heat resistant alloys, Ni-<br>base |                                                      | -                                                                 | 20 - 60   | -         | 25 - 60   |
| <b>H</b>                       | Stal hartowana<br>Hardened steel                                               |                                                      | 10 - 20                                                           | -         | -         | -         |

| Typ płytki<br>Type of Insert | Posuwy (zależnie od szerokości płytki) [mm/U]<br>Feeds (acc. to Width of Groove) [mm/rev] |
|------------------------------|-------------------------------------------------------------------------------------------|
| 216 / 218 / 222 / 226 / 232  | 0.06 - 0.24                                                                               |

Podane parametry prędkości skrawania i posuwów przy zastosowaniu emulsji jako chłodziwa.  
 Recommendations for cutting speed and feed when using coolants.

 Nie ponosimy odpowiedzialności za błędy w druku. Zdjęcia/rysunki poglądowe.  
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