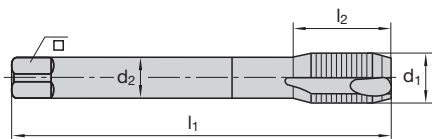




TiCN Plus



Katalog-Nr. Cat.-No.								6404C			6404	
P1	Stahl Steel < 500 N/mm²							■ v _c = 20–25 m/min	□ v _c = 10–15 m/min			
P2	Stahl Steel 500–1000 N/mm²							□ v _c = 10–15 m/min	□ v _c = 8–12 m/min			
P3	Stahl Steel > 1000 N/mm²											
M1	Rostfreie austenitische Stähle Stainless steel austenitic											
M2	Rostfreie martensitische Stähle Stainless steel martensitic											
K1	Grauguss Grey cast iron											
K2	Sphäroguss Nodular cast iron											
N1	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping < 5 % Si							□ v _c = 20–25 m/min	□ v _c = 10–15 m/min			
N2	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping 5–10 % Si							□ v _c = 20–25 m/min				
N3	Alu- & Cu-Legierungen kurzspanend Alu- & Copper alloys short chipping > 10 % Si											
N4	Graphit Graphite											
S1	Titanlegierungen mittelfest Titanium alloys medium strength < 900 N/mm²											
S2	Titanlegierungen hochfest Titanium alloys high strength < 1300 N/mm²											
H1	Hartguss und Harte Stähle Chilled steel and Hardened steel 45–55 HRC											
d ₁	P	I ₁	I ₂	d ₂	□ h12	z		Ident No.	LMT-Code	Ident No.	LMT-Code	
mit Überlaufschaft with standard straight shank												
MF 3	0,35	56	7	2,2	1,2	3	2,65	1391521	TC-BMF 03x0.35-6H-N0-1	1390794	TC-BMF 03x0.35-6H-N0-0	
MF 3,5	0,35	56	7	2,5	2,1	3	3,15	1391532	TC-BMF 3.5x0.35-6H-N0-1	1390801	TC-BMF 3.5x0.35-6H-N0-0	
MF 4	0,5	63	10	2,8	2,1	3	3,5	1391534	TC-BMF 04x0.50-6H-N0-1	1390810	TC-BMF 04x0.50-6H-N0-0	
MF 5	0,5	70	11	3,5	2,7	3	4,5	1391535	TC-BMF 05x0.50-6H-N0-1	1390829	TC-BMF 05x0.50-6H-N0-0	
MF 6	0,5	80	13	4,5	3,4	3	5,5	1391536	TC-BMF 06x0.50-6H-N0-1	1390838	TC-BMF 06x0.50-6H-N0-0	
MF 6	0,75	80	13	4,5	3,4	3	5,3	1391537	TC-BMF 06x0.75-6H-N0-1	1390847	TC-BMF 06x0.75-6H-N0-0	
MF 7	0,75	80	14	5,5	4,3	3	6,25	1391538	TC-BMF 07x0.75-6H-N0-1	1390856	TC-BMF 07x0.75-6H-N0-0	
MF 8	0,5	80	14	6	4,9	3	7,5	1391500	TC-BMF 08x0.50-6H-N0-1	1390860	TC-BMF 08x0.50-6H-N0-0	
MF 8	0,75	80	14	6	4,9	3	7,25	1391539	TC-BMF 08x0.75-6H-N0-1	1390865	TC-BMF 08x0.75-6H-N0-0	
MF 8	1	90	17	6	4,9	3	7	1391506	TC-BMF 08x1.00-6H-N0-1	1390874	TC-BMF 08x1.00-6H-N0-0	
MF 9	0,75	80	12	7	5,5	3	8,3	1391540	TC-BMF 09x0.75-6H-N0-1	1391509	TC-BMF 09x0.75-6H-N0-0	
MF 9	1	90	17	7	5,5	3	8	1391541	TC-BMF 09x1.00-6H-N0-1	1390883	TC-BMF 09x1.00-6H-N0-0	
MF 10	0,75	90	18	7	5,5	3	9,25	1391543	TC-BMF 10x0.75-6H-N0-1	1390892	TC-BMF 10x0.75-6H-N0-0	
MF 10	1	90	18	7	5,5	3	9	1391515	TC-BMF 10x1.00-6H-N0-1	1390909	TC-BMF 10x1.00-6H-N0-0	
MF 10	1,25	100	22	7	5,5	3	8,8	1391544	TC-BMF 10x1.25-6H-N0-1	1391511	TC-BMF 10x1.25-6H-N0-0	
MF 11	1	90	18	8	6,2	3	10	1391501	TC-BMF 11x1.00-6H-N0-1	1390918	TC-BMF 11x1.00-6H-N0-0	
MF 12	1	100	18	9	7	3	11	1390928	TC-BMF 12x1.00-6H-N0-1	1390927	TC-BMF 12x1.00-6H-N0-0	
MF 12	1,25	100	22	9	7	3	10,8	1391545	TC-BMF 12x1.25-6H-N0-1	1390936	TC-BMF 12x1.25-6H-N0-0	
MF 12	1,5	100	22	9	7	3	10,5	1391524	TC-BMF 12x1.50-6H-N0-1	1390945	TC-BMF 12x1.50-6H-N0-0	
MF 14	1	100	18	11	9	3	13	1390955	TC-BMF 14x1.00-6H-N0-1	1390954	TC-BMF 14x1.00-6H-N0-0	
MF 14	1,25	100	22	11	9	3	12,8	1391546	TC-BMF 14x1.25-6H-N0-1	1390963	TC-BMF 14x1.25-6H-N0-0	
MF 14	1,5	100	22	11	9	3	12,5	1390973	TC-BMF 14x1.50-6H-N0-1	1390972	TC-BMF 14x1.50-6H-N0-0	
MF 15	1	100	18	12	9	3	14	1391502	TC-BMF 15x1.00-6H-N0-1	1390981	TC-BMF 15x1.00-6H-N0-0	

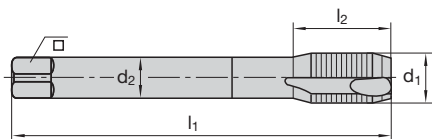
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■ = Hauptanwendung First choice
□ = Nebenanwendung Second choice





TiCN Plus



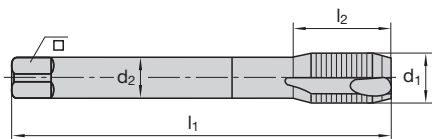
Katalog-Nr. Cat.-No.								6404C			6404	
P1	Stahl Steel < 500 N/mm ²							■ v _c = 20–25 m/min	□ v _c = 10–15 m/min			
P2	Stahl Steel 500–1000 N/mm ²							□ v _c = 10–15 m/min	□ v _c = 8–12 m/min			
P3	Stahl Steel > 1000 N/mm ²											
M1	Rostfreie austenitische Stähle Stainless steel austenitic											
M2	Rostfreie martensitische Stähle Stainless steel martensitic											
K1	Grauguss Grey cast iron											
K2	Sphäroguss Nodular cast iron											
N1	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping < 5 % Si							□ v _c = 20–25 m/min	□ v _c = 10–15 m/min			
N2	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping 5–10 % Si							□ v _c = 20–25 m/min				
N3	Alu- & Cu-Legierungen kurzspanend Alu- & Copper alloys short chipping > 10 % Si											
N4	Graphit Graphite											
S1	Titanlegierungen mittelfest Titanium alloys medium strength < 900 N/mm ²											
S2	Titanlegierungen hochfest Titanium alloys high strength < 1300 N/mm ²											
H1	Hartguss und Harte Stähle Chilled steel and Hardened steel 45–55 HRC											
d ₁	P	I ₁	I ₂	d ₂	□ h12	z		Ident No.	LMT-Code	Ident No.	LMT-Code	
mit Überlaufschaft with standard straight shank												
MF 15	1,5	100	22	12	9	3	13,5	1391503	TC-BMF 15x1.50-6H-N0-1	1390984	TC-BMF 15x1.50-6H-N0-0	
MF 16	1	100	18	12	9	4	15	1390991	TC-BMF 16x1.00-6H-N0-1	1390990	TC-BMF 16x1.00-6H-N0-0	
MF 16	1,5	100	22	12	9	4	14,5	1391533	TC-BMF 16x1.50-6H-N0-1	1391007	TC-BMF 16x1.50-6H-N0-0	
MF 18	1	110	20	14	11	4	17	1391563	TC-BMF 18x1.00-6H-N0-1	1391016	TC-BMF 18x1.00-6H-N0-0	
MF 18	1,5	110	25	14	11	4	16,5	1391026	TC-BMF 18x1.50-6H-N0-1	1391025	TC-BMF 18x1.50-6H-N0-0	
MF 18	2	125	26	14	11	4	16	1391547	TC-BMF 18x2.00-6H-N0-1	1391512	TC-BMF 18x2.00-6H-N0-0	
MF 20	1	125	20	16	12	4	19	1391548	TC-BMF 20x1.00-6H-N0-1	1391043	TC-BMF 20x1.00-6H-N0-0	
MF 20	1,5	125	25	16	12	4	18,5	1391542	TC-BMF 20x1.50-6H-N0-1	1391052	TC-BMF 20x1.50-6H-N0-0	
MF 20	2	140	27	16	12	4	18	1391549	TC-BMF 20x2.00-6H-N0-1	1391061	TC-BMF 20x2.00-6H-N0-0	
MF 22	1	125	20	18	14,5	4	21	1391550	TC-BMF 22x1.00-6H-N0-1	1391070	TC-BMF 22x1.00-6H-N0-0	
MF 22	1,5	125	25	18	14,5	4	20,5	1391551	TC-BMF 22x1.50-6H-N0-1	1391089	TC-BMF 22x1.50-6H-N0-0	
MF 22	2	140	27	18	14,5	4	20	1391552	TC-BMF 22x2.00-6H-N0-1	1391098	TC-BMF 22x2.00-6H-N0-0	
MF 24	1	140	20	18	14,5	4	23	1391553	TC-BMF 24x1.00-6H-N0-1	1391514	TC-BMF 24x1.00-6H-N0-0	
MF 24	1,5	140	27	18	14,5	4	22,5	1391106	TC-BMF 24x1.50-6H-N0-1	1391105	TC-BMF 24x1.50-6H-N0-0	
MF 24	2	140	27	18	14,5	4	22	1391554	TC-BMF 24x2.00-6H-N0-1	1391114	TC-BMF 24x2.00-6H-N0-0	
MF 26	1,5	140	28	18	14,5	4	24,5	1391555	TC-BMF 26x1.50-6H-N0-1	1391132	TC-BMF 26x1.50-6H-N0-0	
MF 27	1	140	28	20	16	4	26	1391556	TC-BMF 27x1.00-6H-N0-1	1391516	TC-BMF 27x1.00-6H-N0-0	
MF 27	1,5	140	28	20	16	4	25,5	1391557	TC-BMF 27x1.50-6H-N0-1	1391141	TC-BMF 27x1.50-6H-N0-0	
MF 27	2	140	28	20	16	4	25	1391558	TC-BMF 27x2.00-6H-N0-1	1391150	TC-BMF 27x2.00-6H-N0-0	
MF 28	1	140	28	20	16	4	27	1391559	TC-BMF 28x1.00-6H-N0-1	1391517	TC-BMF 28x1.00-6H-N0-0	
MF 28	1,5	140	28	20	16	4	26,5	1391170	TC-BMF 28x1.50-6H-N0-1	1391169	TC-BMF 28x1.50-6H-N0-0	
MF 28	2	140	28	20	16	4	26	1391560	TC-BMF 28x2.00-6H-N0-1	1391518	TC-BMF 28x2.00-6H-N0-0	
MF 30	1	150	30	22	18	4	29	1391561	TC-BMF 30x1.00-6H-N0-1	1391519	TC-BMF 30x1.00-6H-N0-0	

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 Pre-drills starting page 367

 ■ = Hauptanwendung First choice
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TiCN Plus



Katalog-Nr. Cat.-No.								6404C		6404	
P1	Stahl Steel < 500 N/mm ²							■ v _c = 20–25 m/min	□ v _c = 10–15 m/min		
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P3	Stahl Steel > 1000 N/mm ²										
M1	Rostfreie austenitische Stähle Stainless steel austenitic										
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K1	Grauguss Grey cast iron										
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N1	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping < 5 % Si							□ v _c = 20–25 m/min	□ v _c = 10–15 m/min		
N2	Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping 5–10 % Si							□ v _c = 20–25 m/min			
N3	Alu- & Cu-Legierungen kurzspanend Alu- & Copper alloys short chipping > 10 % Si										
N4	Graphit Graphite										
S1	Titanlegierungen mittelfest Titanium alloys medium strength < 900 N/mm ²										
S2	Titanlegierungen hochfest Titanium alloys high strength < 1300 N/mm ²										
H1	Hartguss und Harte Stähle Chilled steel and Hardened steel 45–55 HRC										
d ₁	P	l ₁	l ₂	d ₂	□ h12	z		Ident No.	LMT-Code	Ident No.	LMT-Code
mit Überlaufschaft with standard straight shank											
MF 30	1,5	150	30	22	18	4	28,5	1391179	TC-BMF 30x1.50-6H-N0-1	1391178	TC-BMF 30x1.50-6H-N0-0
MF 30	2	150	30	22	18	4	28	1391562	TC-BMF 30x2.00-6H-N0-1	1391187	TC-BMF 30x2.00-6H-N0-0
MF 32	1,5	150	30	22	18	4	30,5	–	–	1391196	TC-BMF 32x1.50-6H-N0-0
MF 32	2	150	30	22	18	4	30	–	–	1391520	TC-BMF 32x2.00-6H-N0-0
MF 33	1,5	160	30	25	20	4	31,5	–	–	1391203	TC-BMF 33x1.50-6H-N0-0
MF 33	2	160	30	25	20	4	31	–	–	1391212	TC-BMF 33x2.00-6H-N0-0
MF 34	1,5	170	30	28	22	6	32,5	–	–	1391522	TC-BMF 34x1.50-6H-N0-0
MF 35	1,5	170	30	28	22	6	33,5	–	–	1391523	TC-BMF 35x1.50-6H-N0-0
MF 36	1,5	170	30	28	22	6	34,5	–	–	1391230	TC-BMF 36x1.50-6H-N0-0
MF 36	2	170	30	28	22	6	34	–	–	1391249	TC-BMF 36x2.00-6H-N0-0
MF 36	3	170	42	28	22	6	33	–	–	1391258	TC-BMF 36x3.00-6H-N0-0
MF 38	1,5	170	30	28	22	6	36,5	–	–	1391267	TC-BMF 38x1.50-6H-N0-0
MF 39	1,5	170	30	32	24	6	37,5	–	–	1391525	TC-BMF 39x1.50-6H-N0-0
MF 39	2	170	30	32	24	6	37	–	–	1391526	TC-BMF 39x2.00-6H-N0-0
MF 40	1,5	170	30	32	24	6	38,5	–	–	1391276	TC-BMF 40x1.50-6H-N0-0
MF 40	2	170	30	32	24	6	38	–	–	1391527	TC-BMF 40x2.00-6H-N0-0
MF 40	3	170	30	32	24	6	37	–	–	1391528	TC-BMF 40x3.00-6H-N0-0
MF 42	1,5	170	30	32	24	6	40,5	–	–	1391285	TC-BMF 42x1.50-6H-N0-0
MF 42	2	170	30	32	24	6	40	–	–	1391294	TC-BMF 42x2.00-6H-N0-0
MF 42	3	170	42	32	24	6	39	–	–	1391529	TC-BMF 42x3.00-6H-N0-0

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■ = Hauptanwendung First choice
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