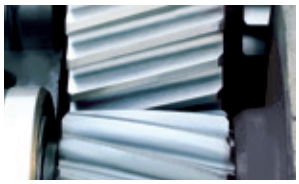




VEHICLES | AEROSPACE | GEARS + BEARINGS | ENGINEERING | WIND ENERGY

LKT 550

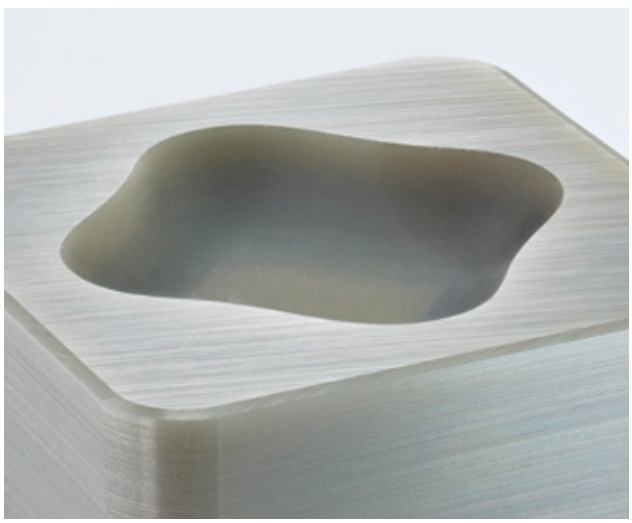
For rough turning and rough-finishing of cast iron parts

CeramTec
THE CERAMIC EXPERTS

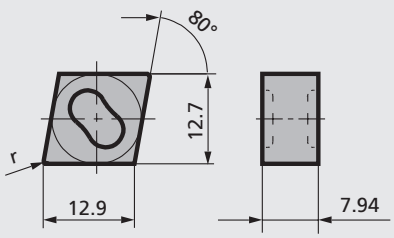
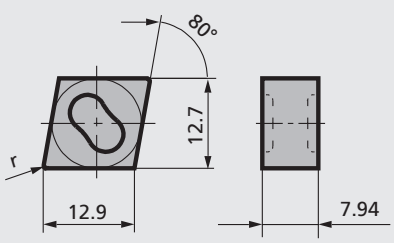
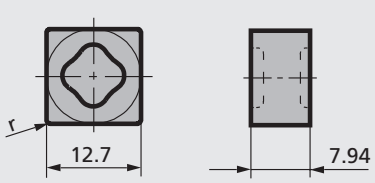
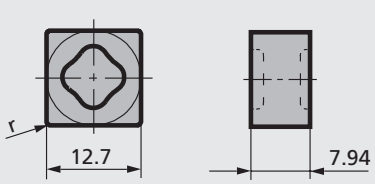
LKT 550 - α/β-SiAlON for turning of cast iron

The new LKT 550 is an α/β-SiAlON. LKT 550 is perfectly suitable for rough turning and rough-finishing of GJL (GG) materials.

LKT 550 cutting inserts stand out with high wear resistance and fracture toughness. In use, high feed rates and cutting speeds are possible due to the great process reliability and process safety. Therefore, high machining speed is achievable as well. As a result, production costs per part decrease considerably due to higher productivity. The saving potential is also enhanced because of the convincing price-performance of the cutting insert. The LKT 550 cutting insert is available in C- and S-geometries and with the approved IX-notch.



Hardness (HB)	Cutting speed v_c (m/min)		Cutting depth a_p (mm)	Feed rate f (mm)		Grade
	Recommended value	Total range		Recommended value	Total range	
25 ▽ Roughing (GJL)						
140 - 210	800	300 - 1000	1,0 - 4,0	0,40	0,20 - 0,60	LKT550
220 - 240	800	300 - 1000	1,0 - 4,0	0,40	0,20 - 0,60	LKT550
250 - 280	800	300 - 1000	1,0 - 4,0	0,40	0,20 - 0,60	LKT550
6.3 ▽ Rough-Finishing (GJL)						
140 - 210	900	400 - 1200	0,3 - 1,0	0,25	0,20 - 0,50	LKT 550
220 - 240	900	400 - 1200	0,3 - 1,0	0,25	0,20 - 0,50	LKT 550
250 - 280	900	400 - 1200	0,3 - 1,0	0,25	0,20 - 0,50	LKT 550

Cutting insert	ISO	Grade	SPK-ORDER NR.
CNMX 12 07 .. T 02020 	CNMX 12 07 12 T 02020	LKT 550	23.54.031.04.0
CNMX 12 07 .. T 02020 	CNMX 12 07 16 T 02020	LKT 550	23.54.032.04.0
SNMX 12 07 .. T 02020 	SNMX 12 07 12 T 02020	LKT 550	23.14.162.04.0
SNMX 12 07 .. T 02020 	SNMX 12 07 16 T 02020	LKT 550	23.14.163.04.0

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