

Changes in product line of cutting inserts

LFMX

1 At LFMX inserts were applied following changes of geometry of chipbreaker:

Former chipbreaker	⇒	New chipbreaker
none	⇒	F1
SF	⇒	F2
SM	⇒	M2

2 Chipbreaker **F1** used on inserts width 2.00, 2.20, 3.10 and 4.10:

- suitable for machining of low-carbon steels, cutting off of thin-walled work pieces, tubes and components with small diameter
- positive rake angle for lower and medium feeds ($f < 0.1 \text{ mm}\cdot\text{rev}^{-1}$)


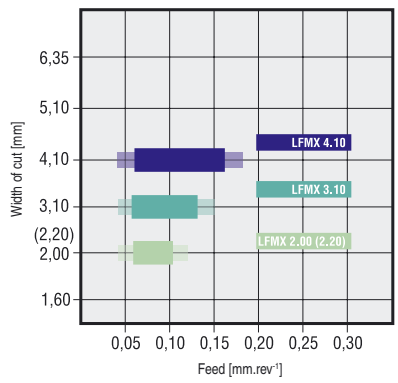

3 At present product line were chipbreakers **SF** and **SM** in grades 8030 and 6640 replaced by chipbreakers **F2** and **M2**.
- the constructional changes were made to improve clamping reliability of cutting insert in blade and increase its efficiency in recommended application areas


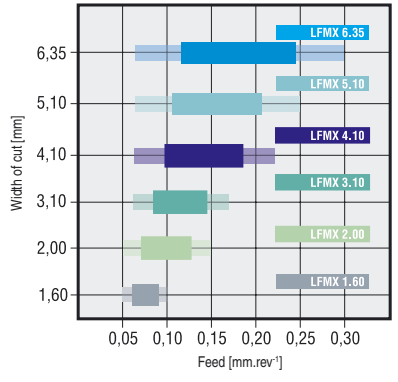
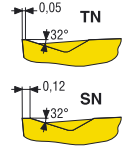
Specification - catalogue	2006	⇒	Specification - catalogue	2008	Assortment
LFMX 1.60-0.16SN-F2; 8030		⇒	LFMX 1.60-0.16SN-F2; 8030		●
NEW ITEM		⇒	LFMX 2.00-0.16EN-F1; 6640		●
NEW ITEM		⇒	LFMX 2.00-0.16EN-F1; 8030		●
LFMX 2.00-0.16SN-F2; 6640		⇒	LFMX 2.00-0.16SN-F2; 6640		●
LFMX 2.00-0.16SN-F2; 8030		⇒	LFMX 2.00-0.16SN-F2; 8030		●
LFMX 2.00-0.16SN-M2; 6640		⇒	LFMX 2.00-0.16SN-M2; 6640		●
LFMX 2.00-0.16SN-M2; 8030		⇒	LFMX 2.00-0.16SN-M2; 8030		●
LFMX 2.00-0.16SR12-M2; 6640		⇒	LFMX 2.00-0.16SR12-M2; 6640		●
LFMX 2.00-0.16SR12-M2; 8030		⇒	LFMX 2.00-0.16SR12-M2; 8030		●
LFMX 2.00-0.16SR6-M2; 6640		⇒	LFMX 2.00-0.16SR6-M2; 6640		●
LFMX 2.00-0.16SR6-M2; 8030		⇒	LFMX 2.00-0.16SR6-M2; 8030		●
LFMX 2.00-0.16SL12-M2; 6640		⇒	LFMX 2.00-0.16SL12-M2; 6640		●
LFMX 2.00-0.16SL12-M2; 8030		⇒	LFMX 2.00-0.16SL12-M2; 8030		●
LFMX 2.00-0.16SL6-M2; 6640		⇒	LFMX 2.00-0.16SL6-M2; 6640		●
LFMX 2.00-0.16SL6-M2; 8030		⇒	LFMX 2.00-0.16SL6-M2; 8030		●
NEW ITEM		⇒	LFMX 2.20-0.16EN-F1; 6640		●
NEW ITEM		⇒	LFMX 2.20-0.16EN-F1; 8030		●
LFMX 2.20-0.16SN-SF; 6640		⇒	not available		
LFMX 2.20-0.16SN-SF; 8030		⇒	not available		
LFMX 2.20-0.16SN-SM; 6640		⇒	LFMX 2.20-0.16SN-M2; 6640		●
LFMX 2.20-0.16SN-SM; 8030		⇒	LFMX 2.20-0.16SN-M2; 8030		●
NEW ITEM		⇒	LFMX 3.10-0.20EN-F1; 6640		●
NEW ITEM		⇒	LFMX 3.10-0.20EN-F1; 8030		●
LFMX 3.10-0.20SN-SF; 6640		⇒	LFMX 3.10-0.20SN-F2; 6640		●
LFMX 3.10-0.20SN-SF; 8030		⇒	LFMX 3.10-0.20SN-F2; 8030		●
LFMX 3.10-0.20SN-SM; 6640		⇒	LFMX 3.10-0.20SN-M2; 6640		●
LFMX 3.10-0.20SN-SM; 8030		⇒	LFMX 3.10-0.20SN-M2; 8030		●
LFMX 3.10-0.20TN-SF; 6640		⇒	LFMX 3.10-0.20TN-F2; 6640		●
LFMX 3.10-0.20TN-SF; 8030		⇒	LFMX 3.10-0.20TN-F2; 8030		●


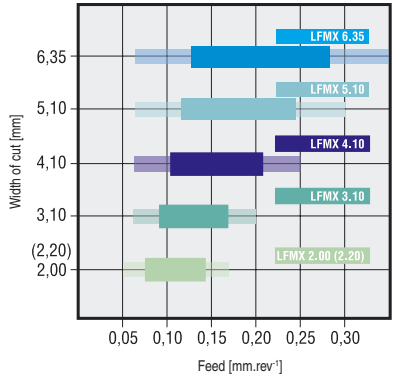
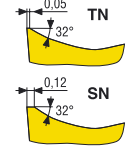
Specification - catalogue	2006	⇒	Specification - catalogue	2008	Assortment
LFMX 3.10-0.20TN-SM; 6640		⇒	LFMX 3.10-0.20TN-M2; 6640		●
LFMX 3.10-0.20TN-SM; 8030		⇒	LFMX 3.10-0.20TN-M2; 8030		●
LFMX 3.10-0.20SR-SM; 6640		⇒	LFMX 3.10-0.20SR8-M2; 6640		●
LFMX 3.10-0.20SR-SM; 8030		⇒	LFMX 3.10-0.20SR8-M2; 8030		●
LFMX 3.10-0.20SL-SM; 6640		⇒	LFMX 3.10-0.20SL8-M2; 6640		●
LFMX 3.10-0.20SL-SM; 8030		⇒	LFMX 3.10-0.20SL8-M2; 8030		●
NEW ITEM		⇒	LFMX 4.10-0.20EN-F1; 6640		●
NEW ITEM		⇒	LFMX 4.10-0.20EN-F1; 8030		●
LFMX 4.10-0.20SN-SF; 6640		⇒	LFMX 4.10-0.20SN-F2; 6640		○
LFMX 4.10-0.20SN-SF; 8030		⇒	LFMX 4.10-0.20SN-F2; 8030		●
LFMX 4.10-0.20SN-SM; 6640		⇒	LFMX 4.10-0.20SN-M2; 6640		●
LFMX 4.10-0.20SN-SM; 8030		⇒	LFMX 4.10-0.20SN-M2; 8030		●
LFMX 4.10-0.20TN-SF; 6640		⇒	LFMX 4.10-0.20TN-F2; 6640		○
LFMX 4.10-0.20TN-SF; 8030		⇒	LFMX 4.10-0.20TN-F2; 8030		●
LFMX 4.10-0.20TN-SM; 6640		⇒	LFMX 4.10-0.20TN-M2; 6640		○
LFMX 4.10-0.20TN-SM; 8030		⇒	LFMX 4.10-0.20TN-M2; 8030		●
LFMX 4.10-0.20SR-SM; 6640		⇒	LFMX 4.10-0.20SR8-M2; 6640		●
LFMX 4.10-0.20SR-SM; 8030		⇒	LFMX 4.10-0.20SR8-M2; 8030		●
LFMX 4.10-0.20SL-SM; 6640		⇒	LFMX 4.10-0.20SL8-M2; 6640		●
LFMX 4.10-0.20SL-SM; 8030		⇒	LFMX 4.10-0.20SL8-M2; 8030		●
LFMX 5.10-0.20SN-SF; 6640		⇒	LFMX 5.10-0.20SN-F2; 6640		●
LFMX 5.10-0.20SN-SF; 8030		⇒	LFMX 5.10-0.20SN-F2; 8030		●
LFMX 5.10-0.20SN-SM; 6640		⇒	LFMX 5.10-0.20SN-M2; 6640		●
LFMX 5.10-0.20SN-SM; 8030		⇒	LFMX 5.10-0.20SN-M2; 8030		●
LFMX 6.35-0.20SN-SF; 6640		⇒	LFMX 6.35-0.20SN-F2; 6640		○
LFMX 6.35-0.20SN-SF; 8030		⇒	LFMX 6.35-0.20SN-F2; 8030		○
LFMX 6.35-0.20SN-SM; 6640		⇒	LFMX 6.35-0.20SN-M2; 6640		●
LFMX 6.35-0.20SN-SM; 8030		⇒	LFMX 6.35-0.20SN-M2; 8030		●

Type of cutting inserts

LFMX

Geometry	Photo	Workpiece Material Group						Diagram of application	Description	Applied to inserts:	
		Turning operation	P	M	K	N	S			H	LFMX
LFMX F1		F	■	■	□	□	□		Applied to inserts: LFMX	- Universal cutting geometry characterized by low cutting resistance - parting and grooving - the main area of application – machined materials groups P and M - further area of application – machined materials group K - conditionally group S	
	Profile of cutting edge	M	■	■	□	□	□				
		R									
Range of cutting conditions:									f	See diagram	
									a _p	See diagram	

Geometry	Photo	Workpiece Material Group						Diagram of application	Description	Applied to inserts:	
		Turning operation	P	M	K	N	S			H	LFMX
LFMX F2		F	■	□	■	□	□		Applied to inserts: LFMX	- high universal cutting geometry characterized by very low cutting resistance - parting and grooving - the main area of application – machined materials groups P and K - further area of application – machined materials groups M - conditionally groups S and H - also for moderate interrupted cut	
	Profile of cutting edge	M	■	■	□	□	□				
		R									
Range of cutting conditions:									f	See diagram	
									a _p	See diagram	

Geometry	Photo	Workpiece Material Group						Diagram of application	Description	Applied to inserts:	
		Turning operation	P	M	K	N	S			H	LFMX
LFMX M2		F	■	■	□	□	□		Applied to inserts: LFMX	- high universal cutting geometry characterized by very low cutting resistance - parting and grooving - the main area of application – machined materials groups P and M - further area of application – machined materials groups K and S - conditionally groups N and H - also for moderate interrupted cut	
	Profile of cutting edge	M	■	■	□	□	□				
		R									
Range of cutting conditions:									f	See diagram	
									a _p	See diagram	



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