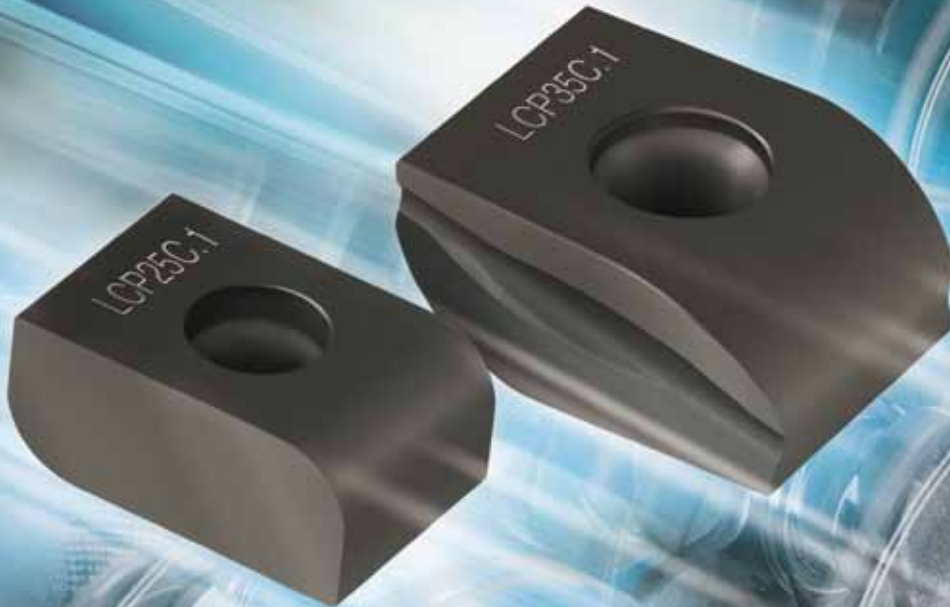


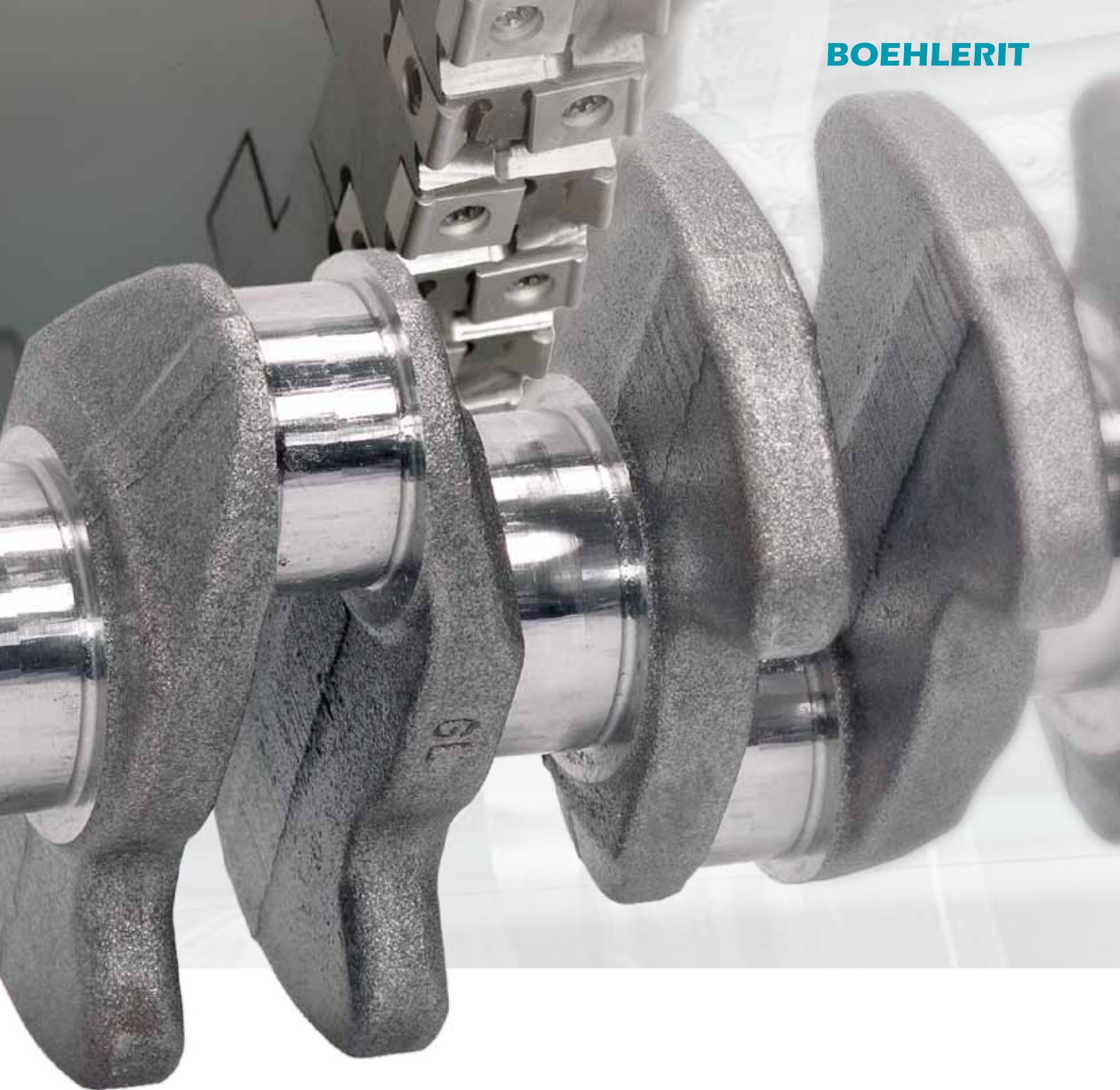
BOEHLERIT

Hard, universal and tough
more tool life for crankshaft machining



in alliance with





Special grades for crankshaft machining

Boehlerit, the alliance partner of the LMT Group and leading tool system supplier for crankshaft milling of large-dimension and passenger car crankshafts, has launched new cutting grades on the market that are tailored to the demands of crankshaft milling. To reduce thermal cracking, a unique, new, nano-structured layer has been applied to three new carbide substrates with special alloy elements.

The combination of new carbide substrates with reduced tendency towards thermal cracking and the extremely heat-resistant layer increase the tool life on dry machining of steel materials by 40 – 200 %. The cost-intensive set-up times time can be considerably reduced in crankshaft machining.

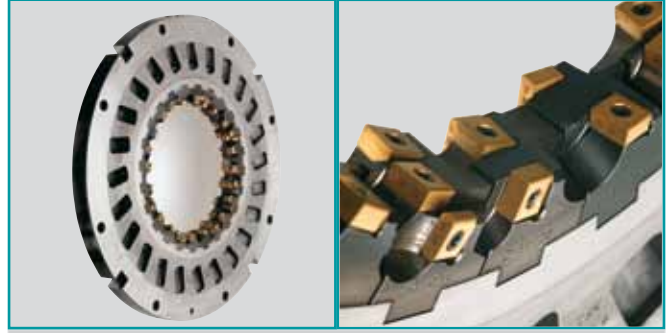
The specially developed grades for crankshaft machining are available in the tough LCP35C.1, the universal LCP30C.1 and the wear-resistant LCP25C.1.



External milling cutter

For large volume production of small (passenger car) to medium-sized crankshafts
- with or without grooves

- shortest cycle times
- high cutting speed



Internal milling cutter

For the machining of medium-sized crankshafts (trucks) to ship engines made from drop-forged or hammer-forged blanks

- stable cutting conditions
- highest metal removal rate

Grade overview

Grade	ISO	Range of application	Group of materials						Application					
			P	M	K	N	S	H	T	M	D	S	G	P
LCP25C.1	HC-P25		■							●				
LCP30C.1	HC-P30		■							●				
LCP35C.1	HC-P35		■							●				
LC609T	HC-K10				■					●				
LC619T	HC-K20				■					●				
Application peak			■ Main application □ Further applications						Standard grade					
Full range to ISO 513														

- LCP25C.1 (HC-P25)
PVD coated carbide grade for milling easily machinable steel, or for applications with small dimensions and high cutting speeds. This multirange grade stands out with its high resistance to wear.
- LCP30C.1 (HC-P30)
Carbide grade for milling hard to machine steels. For special applications with high demands on wear resistance. Excellent for applications that tend to vibrate and for machining at high feed speeds.
- LCP35C.1 (HC-P35)
Main grade for milling steels at medium cutting speed. This multirange grade stands out with its resistance to wear and excellent toughness properties.
- LC609T (HC-K10)
Carbide grade for the milling of grey cast and spheroidal cast iron, for finishing and the medium machining range. This grade stands out with its high resistance to wear.
- LC619T (HC-K20)
Main grade for the milling for grey cast and spheroidal cast iron, for medium to heavy-duty machining. This grade stands out with its wear resistance and good toughness properties.

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