boehlerit

Drehbearbeitung von Rostfreimaterialien

Machining of stainless steel materials

Programmerweiterung

Programme extension

Leistung wenn es drauf ankommt / MRM - Geometrie
Performance when needed / MRM - Geometry

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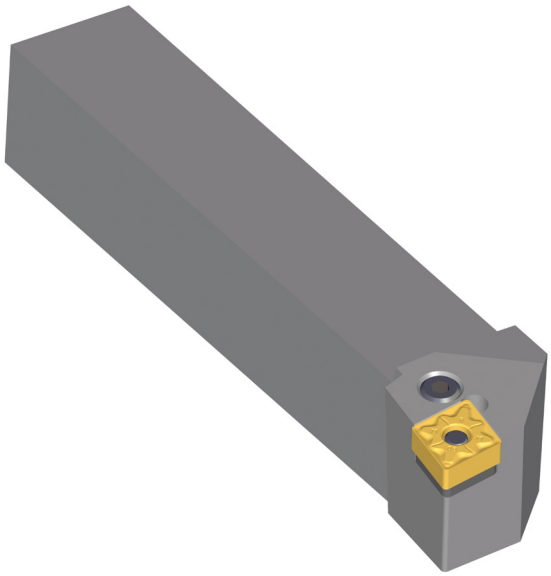

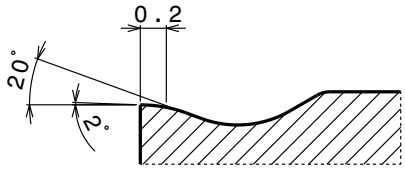

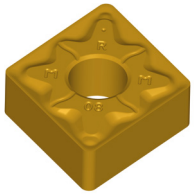

Mit der neuesten Wendeschneidplatten-Geometrie „MRM“, ergänzt Boehlerit das ISO Drehprogramm im mittleren bis schweren Schrupp-Bereich für rostfreie Materialien und setzt neue Maßstäbe. Damit stehen in breiten Anwendungsbereichen auf rostfreien Stählen optimale Wendeschneidplatten Geometrien zur Verfügung.
Der neue Spanbrecher „MRM“ ist eine Ergänzung der am Markt etablierten „BMRS“, Geometrie welche zwar einen ähnlichen Vorschubbereich kennzeichnet, sich durch den tieferen Spanwinkel jedoch stark in der Mikro-Geometrie unterscheidet. Somit wird eine Verringerung der Schnittkräfte erreicht, woraus sowohl eine Erhöhung der Prozesssicherheit, als auch eine Standzeiterhöhung auf rostfreien Stählen mit hohen Härtegraden resultieren.
Der neue Spanformer der MRM-Geometrie, mit einem Vorschubbereich von 0,20 - 0,50 mm/U, ist eine optimale Erweiterung zur erfolgreichen „MM“ Geometrie, die einen (überlappenden) Vorschubbereich von 0,15 - 0,35 mm/U aufweist.

Für die neue MRM Wendeschneidplattengeometrie sind folgende Werkstoffsorten verfügbar:

LCM20T mittleres Substrat mit dünner CVD-Beschichtung
BCM25T mittleres Substrat mit dicker PVD Beschichtung
BCM40T zähes Substrat mit dicker PVD Beschichtung

With its latest indexable insert geometry MRM, Boehlerit has added yet another innovation to its ISO turning programme for the medium to rough machining of stainless materials, setting new standards in the process and making optimised indexable inserts available for a wide range of applications using stainless steels.
The new MRM chip breaker complements the BMRS geometry, which is well established on the market and covers a similar feed rate range but differs in terms of micro geometry due to the deeper chipping angle. In this way, the cutting forces are reduced, resulting in increased process safety and a increased tool life on stainless steels with high hardness levels.
In addition, the new chip former with feed rates of 0.20 - 0.50 mm/rev is the ideal extension to the successful MM geometry with an overlapping feed rate range of 0.15 - 0.35 mm/rev.

The following material grades are available for the new MRM indexable insert geometry:

LCM20T medium substrate with thin CVD coating
BCM25T medium substrate with thick PVD coating
BCM40T tough substrate with thick PVD coating

Technische Änderungen und Druckfehler vorbehalten.
Subject to changes from technical development and printing errors.

Schneidstoffsortenübersicht
Turning grades overview

Sorte / Grade	ISO	Anwendungsbereich / Application range (01 05 10 15 20 25 30 35 40 45 50)	Werkstoffgruppe / Material group: P Stahl / Steel	M Rostfrei / Stainless	K Grauguss / Grey cast iron	N NE-Metalle / Non-ferrous metals	S Hochwarmfest / High temperature materials	H Harte Werkstoffe / Hard materials	Bearbeitungsverfahren / Application: T Drehen / Turning	M Fräsen / Milling	D Bohren / Drilling	S Gewinde-bearbeitung / Threading	Farbliche Darstellung der WSP je nach Beschichtung / Color guide for inserts depending on coating
LCM20T	HC-M20			■					●				
	HC-S20						□		●				
LC435D	HC-M25			■					●				
	HC-P30		□						●				
BCM25T	HC-M25			■					●				
	HC-P30		□						●				
BCM40T	HC-M35			■					●				
	HC-P35						□		●				

Anwendungsschwerpunkt / Application peak

Gesamtbereich nach ISO 513 / Full range to ISO 513

■ Hauptanwendung / Main application

□ Weitere Anwendungen / Further applications

● Standardsorte / Standard grade

LCM20T (HC-M20, HC-S20)
Drehsorte für die Bearbeitung von austenitischen Werkstoffen im hohen Schnittgeschwindigkeitsbereich von 170 - 220 m/min.

LC435D (HC-M35, HC-P35)
Hauptsorte zu Drehen von austenitischen rostfreien Stählen bei mittleren Schnittgeschwindigkeiten. Erweiterte Anwendung für Superlegierungen.

BCM25T (HC-M25, HC-P25)
Drehsorte für austenitische rostfreie Stähle im mittleren bis hohen Schnittgeschwindigkeitsbereich.

BCM40T (HC-M40, HC-S40)
Sehr zähe Rostfreisorte für niedrige Schnittgeschwindigkeiten geeignet, als Alternative auch auf Stahl und Superlegierungen einsetzbar.

LCM20T (HC-M20, HC-S20)
Turning grade for machining of austenitic materials in the high cutting speed area of 170 - 220 m/min.

LC435D (HC-M35, HC-P35)
Main grade for turning of austenitic stainless steels at medium cutting speeds. Applicable also for super alloys.

BCM25T (HC-M25, HC-P25)
Turning grade for austenitic stainless steels in medium and high cutting speed area.

BCM40T (HC-M40, HC-S40)
Very tough stainless grade for low cutting speeds suitable, also as alternative applicable on steel and super alloys.

Wendeschneidplatten für die Bearbeitung von rostfreien Stählen
Indexable inserts for machining stainless steels

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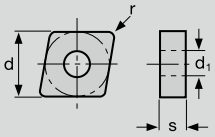
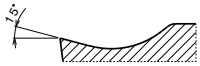
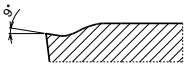
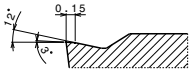
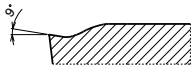
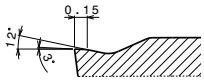


Sorte Grade	ISO-Klasse ISO-class
LCM20T LC435D BCM25T BCM40T	HC-M20 HC-M35 HC-M25 HC-M40

CCGT....-E.-BC	CCGT....-FM	CCMT....-BSMS	CCMT....-FM	CCMT.....MM
				
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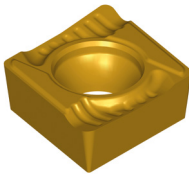
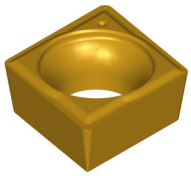
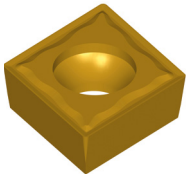
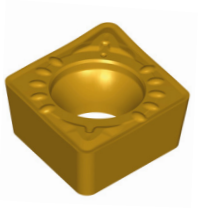
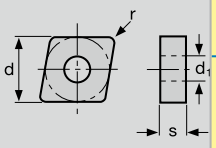
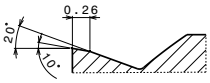
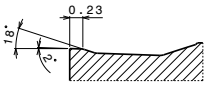
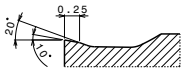
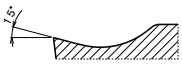
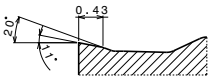
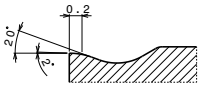
				

Type Type	Geometrie Geometry	Vorschub Feed f [mm / U rev]	Schnitttiefe cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm]			LCM20T	LC435D	BCM25T	BCM40T
				d	s	r				
CCGT 060204	**EL-BC**	0,10 - 0,25	0,40 - 2,50	6,35	2,38	0,4		6413126		
CCGT 060204	**ER-BC**	0,10 - 0,25	0,40 - 2,50	6,35	2,38	0,4		6413130		
CCGT 060208	**EL-BC**	0,10 - 0,30	0,80 - 2,50	6,35	2,38	0,8		6413134		
CCGT 060208	**ER-BC**	0,10 - 0,30	0,80 - 2,50	6,35	2,38	0,8		6413138		
CCGT 09T304	**EL-BC**	0,10 - 0,25	0,40 - 3,00	9,52	3,97	0,4		6413139		
CCGT 09T304	**ER-BC**	0,10 - 0,25	0,40 - 3,00	9,52	3,97	0,4		6413140		
CCGT 09T308	**EL-BC**	0,20 - 0,45	0,80 - 3,00	9,52	3,97	0,8		6413141		
CCGT 09T308	**ER-BC**	0,20 - 0,45	0,80 - 3,00	9,52	3,97	0,8		6413142		
CCGT 120408	**ER-BC**	0,20 - 0,45	0,80 - 4,00	12,7	4,76	0,8		6413150		
CCGT 120412	**EL-BC**	0,20 - 0,45	1,20 - 4,00	12,7	4,76	1,2		6413154		
CCGT 030101	**FM**	0,02 - 0,06	0,10 - 0,80	3,52	1,4	0,1			5140563	
CCGT 030102	**FM**	0,05 - 0,13	0,20 - 1,50	3,52	1,4	0,2			5140564	
CCMT 09T304	**BSMS**	0,10 - 0,25	0,40 - 3,00	9,52	3,97	0,4		6400352		
CCMT 09T308	**BSMS**	0,12 - 0,30	0,80 - 3,00	9,52	3,97	0,8		6400353		
CCMT 120404	**BSMS**	0,12 - 0,30	0,40 - 4,00	12,7	4,76	0,4		6400354		
CCMT 120408	**BSMS**	0,15 - 0,35	0,80 - 4,00	12,7	4,76	0,8		6400355		
CCMT 060202	**FM**	0,07 - 0,13	0,20 - 2,50	6,35	2,38	0,2			5106897	5106721
CCMT 060204	**FM**	0,08 - 0,15	0,40 - 2,50	6,35	2,38	0,4			5106898	5106896
CCMT 09T304	**FM**	0,08 - 0,20	0,40 - 3,00	9,52	3,97	0,4	5093104	5073343	5166564	
CCMT 060202	**MM**	0,07 - 0,13	0,20 - 2,50	6,35	2,38	0,2	5093105	5073333	5090769	
CCMT 060204	**MM**	0,10 - 0,25	0,40 - 2,50	6,35	2,38	0,4	5093106	5064302	5090778	
CCMT 09T304	**MM**	0,10 - 0,25	0,40 - 3,00	9,52	3,97	0,4	5064531		5090779	
CCMT 09T308	**MM**	0,15 - 0,40	0,80 - 3,00	9,52	3,97	0,8	5064532		5090780	
CCMT 120404	**MM**	0,15 - 0,40	0,40 - 4,00	12,7	4,76	0,4			5090782	
CCMT 120408	**MM**	0,15 - 0,40	0,80 - 4,00	12,7	4,76	0,8			5090783	

Bestellbeispiel Order example: 10 Stück 10 pieces CCGT 060204-EL-BC LC435D oder or 6413126
Abbildung der Wendeschneiplatten können vom Lagerartikel in Ausführung und Farbe abweichen!
Colours and execution of the original indexable inserts, may deviate from the illustration!

Verfügbar ab Lager Available from stock

Wendeschneidplatten für die Bearbeitung von rostfreien Stählen
Indexable inserts for machining stainless steels

	Sorte Grade			ISO-Klasse ISO-class	
	LCM20T LC435D BCM25T BCM40T			HC-M20 HC-M35 HC-M25 HC-M40	
CNMG....-BFMS	**CNMG....-BMRS**	**CNMG....-BMS**	**CNMG.... E.-BC**	**CNMG.... MM**	**CNMG....MRM**
					
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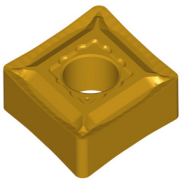	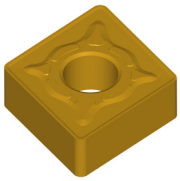	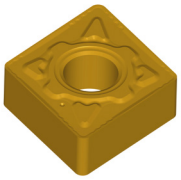		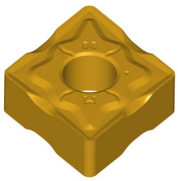	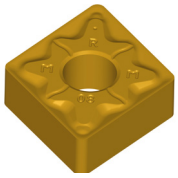

Type Type	Geometrie Geometry	Vorschub Feed f [mm / U rev]	Schnitttiefe cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm] d	s	r	LCM20T	LC435D	BCM25T	BCM40T
CNMG 090304	**BFMS**	0,10 - 0,30	0,40 - 3,00	9,52	3,18	0,4	5093116	6400356	5090787	
CNMG 120404	**BFMS**	0,10 - 0,30	0,40 - 4,50	12,7	4,76	0,4	5093117	6400357	5090790	
CNMG 120408	**BFMS**	0,10 - 0,30	0,80 - 4,50	12,7	4,76	0,8	5093119	6400358	5090791	
CNMG 120412	**BFMS**	0,10 - 0,30	0,80 - 4,50	12,7	4,76	0,8	5093120	6400359	5090794	
CNMG 120408	**BMRS**	0,15 - 0,40	0,80 - 5,00	12,7	4,76	0,8		6400363	5107398	5102375
CNMG 120412	**BMRS**	0,15 - 0,40	1,20 - 5,00	12,7	4,76	1,2		6400364	5107406	5102373
CNMG 160612	**BMRS**	0,32 - 0,70	1,20 - 9,00	15,87	6,35	1,2		6400365	5107400	5092797
CNMG 160616	**BMRS**	0,32 - 0,70	1,60 - 9,00	15,87	6,35	1,6			5107397	5093135
CNMG 190612	**BMRS**	0,32 - 0,70	1,20 - 12,0	19,05	6,35	1,2		6400417	5107405	5092822
CNMG 120408	**BMS**	0,16 - 0,40	0,80 - 5,00	12,7	4,76	0,8		6400360		
CNMG 120412	**BMS**	0,16 - 0,40	1,20 - 5,00	12,7	4,76	1,2		6400361		
CNMG 160612	**BMS**	0,16 - 0,40	1,20 - 9,00	15,87	6,35	1,2		6400362		
CNMG 120404	**EL-BC**	0,10 - 0,25	1,20 - 5,00	12,7	4,76	0,4		6410867		
CNMG 120404	**ER-BC**	0,10 - 0,25	1,20 - 5,00	12,7	4,76	0,4		6410871		
CNMG 120408	**EL-BC**	0,20 - 0,45	0,80 - 5,00	12,7	4,76	0,8		6410875		
CNMG 120408	**ER-BC**	0,20 - 0,45	0,80 - 5,00	12,7	4,76	0,8		6410879		
CNMG 120408	**MM**	0,15 - 0,40	0,80 - 4,00	12,7	4,76	0,8	5047846		5090793	5093132
CNMG 120412	**MM**	0,15 - 0,40	1,20 - 4,00	12,7	4,76	1,2	5047848		5091978	5093134
CNMG 160612	**MM**	0,15 - 0,40	1,20 - 9,00	15,87	6,35	1,2	5074538		5092372	5092802
CNMG 160616	**MM**	0,15 - 0,40	1,60 - 9,00	15,87	6,35	1,6	5074537		5092377	5092821
CNMG 190612	**MM**	0,15 - 0,40	1,20 - 12,0	19,05	6,35	1,2	5074485		5166566	5092853
CNMG 190616	**MM**	0,15 - 0,40	1,60 - 12,0	19,05	6,35	1,6	5074529		5166567	5092861
CNMG 120408	**MRM**	0,20 - 0,50	0,80 - 5,00	12,7	4,76	0,8	5151880		5151881	5151883
CNMG 120412	**MRM**	0,20 - 0,50	1,20 - 5,00	12,7	4,76	1,2	5151885		5151886	5151888
CNMG 160608	**MRM**	0,20 - 0,50	0,80 - 9,00	15,87	6,35	0,8	5151889		5151890	5151894
CNMG 160612	**MRM**	0,20 - 0,50	1,20 - 9,00	15,87	6,35	1,2	5151895		5151897	5151902

Bestellbeispiel Order example: 10 Stück 10 pieces CNMG 090304-BFMS LCM20T oder or 5093116

Verfügbar ab Lager Available from stock

Wendeschneidplatten für die Bearbeitung von rostfreien Stählen
Indexable inserts for machining stainless steels

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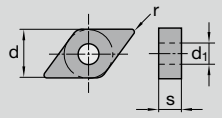
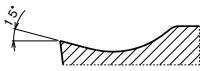
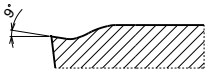
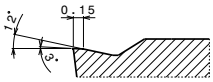
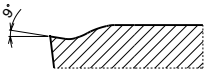
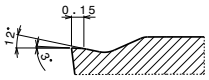


Sorte Grade	ISO-Klasse ISO-class
LCM20T LC435D BCM25T BCM40T	HC-M20 HC-M35 HC-M25 HC-M40

DCGT....E.-BC	DCGT....-FM	DCMT....-BSMS	DCMT....-FM	DCMT....-MM
				
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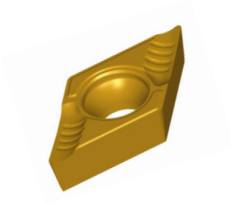
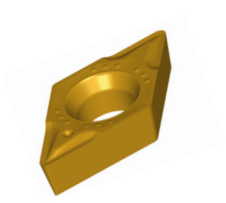
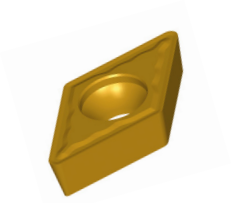
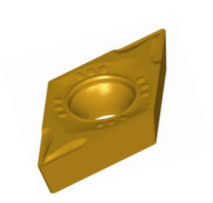
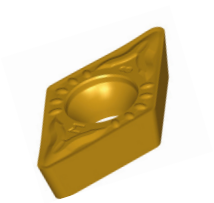
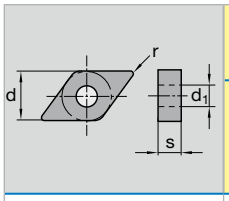
				

Type Type	Geometrie Geometry	Vorschub Feed f [mm / U rev]	Schnitttiefe cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm]			LCM20T	LC435D	BCM25T	BCM40T
				d	s	r				
DCGT 070204	**EL-BC**	0,10 - 0,28	0,40 - 1,50	6,35	2,38	0,4		6413173		
DCGT 070204	**ER-BC**	0,10 - 0,28	0,40 - 1,50	6,35	2,38	0,4		6413177		
DCGT 11T304	**EL-BC**	0,10 - 0,28	0,40 - 2,00	9,52	3,97	0,4		6413178		
DCGT 11T304	**ER-BC**	0,10 - 0,28	0,40 - 2,00	9,52	3,97	0,4		6413179		
DCGT 11T308	**EL-BC**	0,20 - 0,45	0,80 - 2,00	9,52	3,97	0,8		6413180		
DCGT 11T308	**ER-BC**	0,20 - 0,45	0,80 - 2,00	9,52	3,97	0,8		6413181		
DCGT 04T002	**FM**	0,05 - 0,13	0,20 - 1,50	3,12	1,2	0,2			5131355	
DCMT 11T304	**BSMS**	0,15 - 0,25	0,40 - 2,00	9,52	3,97	0,4		6400366		
DCMT 11T308	**BSMS**	0,15 - 0,35	0,80 - 2,00	9,52	3,97	0,8		6400367		
DCMT 070202	**FM**	0,07 - 0,13	0,20 - 1,50	6,35	2,38	0,2	5093121	5076858	5166570	
DCMT 070204	**FM**	0,08 - 0,15	0,20 - 1,50	6,35	2,38	0,4			5106904	5106901
DCMT 11T302	**FM**	0,05 - 0,13	0,20 - 2,00	9,52	3,97	0,2	5085216	5077020	5166572	
DCMT 11T304	**FM**	0,05 - 0,20	0,40 - 2,00	9,52	3,97	0,4			5106906	5106905
DCMT 070204	**MM**	0,15 - 0,25	0,40 - 1,50	6,35	2,38	0,4		5064311	5166568	
DCMT 11T304	**MM**	0,15 - 0,25	0,40 - 2,00	9,52	3,97	0,4	5064535		5092380	
DCMT 11T308	**MM**	0,15 - 0,40	0,80 - 2,00	9,52	3,97	0,8	5064533		5092382	

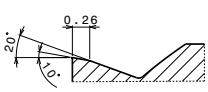
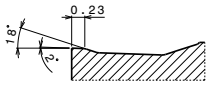
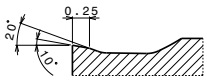
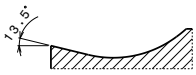
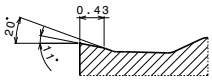
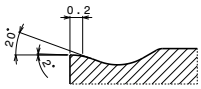
Bestellbeispiel Order example: 10 Stück 10 pieces DCGT 070204 EL-BC LC435D oder or 6413173

Verfügbar ab Lager Available from stock

Wendeschneidplatten für die Bearbeitung von rostfreien Stählen
Indexable inserts for machining stainless steels



Sorte Grade	ISO-Klasse ISO-class
LCM20T LC435D BCM25T BCM40T	HC-M20 HC-M35 HC-M25 HC-M40

DNMG....-BFMS	DNMG....-BMRS	DNMG....-BMS	DNMG....E.-BC	DNMG.... MM	DNMG....MRM
					
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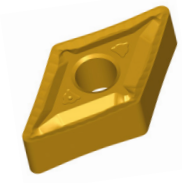	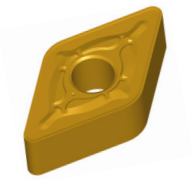	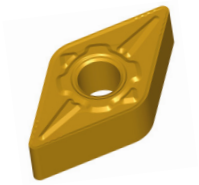		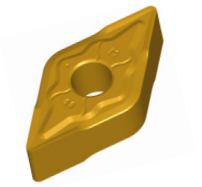	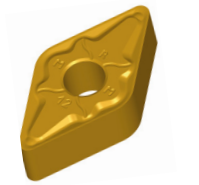

Type Type	Geometrie Geometry	Vorschub Feed f [mm / U rev]	Schnitttiefe cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm] d	s	r	LCM20T	LC435D	BCM25T	BCM40T
DNMG 110404	**BFMS**	0,10 - 0,30	0,40 - 4,50	9,52	3,97	0,4	5093128	6400368	5092387	
DNMG 110408	**BFMS**	0,10 - 0,30	0,80 - 4,50	9,52	3,97	0,8			5092488	
DNMG 150604	**BFMS**	0,10 - 0,30	0,40 - 6,00	12,7	6,35	0,4	5093130	6400369	5092639	
DNMG 150608	**BFMS**	0,10 - 0,30	0,80 - 6,00	12,7	6,35	0,8	5093131	6400370	5092641	
DNMG 150608	**BMRS**	0,32 - 0,70	0,80 - 6,00	12,7	6,35	0,8		6400408	5107402	5101436
DNMG 150612	**BMRS**	0,32 - 0,70	1,20 - 6,00	12,7	6,35	1,2		6400375	5107403	5092864
DNMG 110408	**BMS**	0,14 - 0,35	0,80 - 4,50	9,52	3,97	0,8		6400372		
DNMG 150408	**BMS**	0,16 - 0,40	0,80 - 6,00	12,7	4,76	0,8		6400445		
DNMG 150608	**BMS**	0,16 - 0,40	0,80 - 6,00	12,7	6,35	0,8		6400373		
DNMG 150612	**BMS**	0,16 - 0,40	1,20 - 6,00	12,7	6,35	1,2		6400374		
DNMG 150604	**EL-BC**	0,15 - 0,35	0,40 - 6,00	12,7	6,35	0,4		6400785		
DNMG 150604	**ER-BC**	0,15 - 0,35	0,40 - 6,00	12,7	6,35	0,4		6400786		
DNMG 150608	**EL-BC**	0,20 - 0,45	0,80 - 6,00	12,7	6,35	0,8		6400787		
DNMG 150608	**ER-BC**	0,20 - 0,45	0,80 - 6,00	12,7	6,35	0,8		6400788		
DNMG 110404	**MM**	0,15 - 0,30	0,40 - 4,50	9,52	3,97	0,4			5092413	
DNMG 110408	**MM**	0,15 - 0,30	0,80 - 4,50	9,52	3,97	0,8			5092416	
DNMG 150404	**MM**	0,10 - 0,25	0,40 - 6,00	12,7	4,76	0,4	5079009		5093129	
DNMG 150408	**MM**	0,15 - 0,40	0,80 - 6,00	12,7	4,76	0,8	5078339		5092497	
DNMG 150604	**MM**	0,10 - 0,25	0,40 - 6,00	12,7	6,35	0,4	5078794		5101437	
DNMG 150608	**MM**	0,15 - 0,40	0,80 - 6,00	12,7	6,35	0,8	5047849		5092642	5092863
DNMG 150612	**MM**	0,15 - 0,40	1,20 - 6,00	12,7	6,35	1,2	5060170		5092726	5092866
DNMG 150608	**MRM**	0,20 - 0,50	0,8 - 5,0	12,7	6,35	0,8	5151903		5151904	5151906
DNMG 150612	**MRM**	0,20 - 0,50	1,2 - 5,0	12,7	6,35	1,2	5151907		5151908	5151910

Bestellbeispiel Order example: 10 Stück 10 pieces DNMG 110404-BFMS LCM20T oder or 5093128

Verfügbar ab Lager Available from stock

Wendeschneidplatten für die Bearbeitung von rostfreien Stählen
Indexable inserts for machining stainless steels

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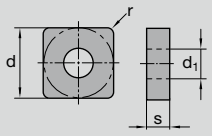
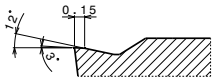
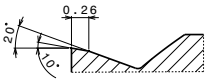
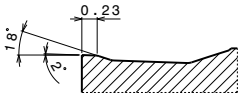
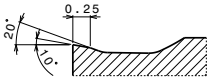
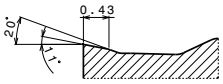


Sorte Grade	ISO-Klasse ISO-class
LCM20T LC435D BCM25T BCM40T	HC-M20 HC-M35 HC-M25 HC-M40

SCMT....BSMS	SNMG...-BFMS	SNMG....-BMRS	SNMG....-BMS	SNMG....-MM
				
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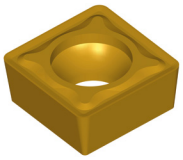	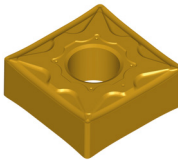	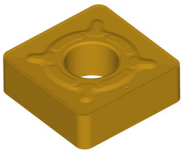	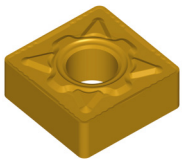	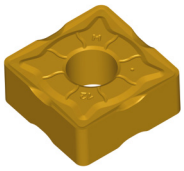

Type Type	Geometrie Geometry	Vorschub Feed f [mm / U rev]	Schnitttiefe cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm]			LCM20T	LC435D	BCM25T	BCM40T
				d	s	r				
SCMT 120408	**BSMS**	0,15 - 0,35	0,80 - 3,50	12,7	4,76	0,8		6400376		
SNMG 090304	**BFMS**	0,10 - 0,30	0,40 - 4,50	9,52	3,18	0,4		6400377	5092728	
SNMG 120408	**BMRS**	0,32 - 0,60	0,80 - 7,00	12,7	4,76	0,8		6400380		
SNMG 120412	**BMRS**	0,32 - 0,70	1,20 - 7,00	12,7	4,76	1,2		6400421		5092867
SNMG 190612	**BMRS**	0,32 - 0,70	1,20 - 10,0	19,05	6,35	1,2		6400422	5168815	5092893
SNMG 190616	**BMRS**	0,32 - 0,70	1,60 - 10,0	12,7	4,76	1,6			5168816	5092902
SNMG 120408	**BMS**	0,16 - 0,40	0,80 - 7,00	12,7	4,76	0,8		6400378		
SNMG 120412	**BMS**	0,16 - 0,40	1,20 - 7,00	12,7	4,76	1,2		6400379		
SNMG 120408	**MM**	0,15 - 0,40	0,80 - 7,00	12,7	4,76	0,8			5092732	5101438
SNMG 120412	**MM**	0,15 - 0,40	1,20 - 7,00	12,7	4,76	1,2			5092733	5101439
SNMG 150612	**MM**	0,15 - 0,40	1,20 - 7,50	15,87	6,35	1,2	5074534		5092737	5092889
SNMG 150616	**MM**	0,15 - 0,40	1,60 - 7,50	15,87	6,35	1,6	5074531		5092747	5092892
SNMG 190612	**MM**	0,15 - 0,40	1,20 - 10,0	19,05	6,35	1,2	5074536		5166574	5092901
SNMG 190616	**MM**	0,15 - 0,40	1,60 - 10,0	19,05	6,35	1,6	5074535		5166576	5092946

Bestellbeispiel Order example: 10 Stück 10 pieces SCMT 120408-BSMS LC435D oder or 6400376

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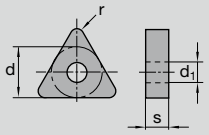
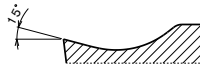
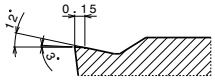
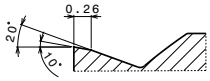
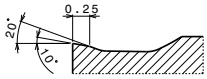
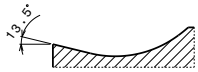
Wendeschneidplatten für die Bearbeitung von rostfreien Stählen
Indexable inserts for machining stainless steels



Sorte Grade	ISO-Klasse ISO-class
LCM20T LC435D BCM25T BCM40T	HC-M20 HC-M35 HC-M25 HC-M40

TCGT....-E.-BC	TCMT....-BSMS	TNMG....-BFMS	TNMG....-BMS	TNMG....E.-BC
				
medium	medium	medium fine	medium	copy

Type Type	Geometrie Geometry	Vorschub Feed f [mm / U rev]	Schnitttiefe cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm] d	s	r	LCM20T	LC435D	BCM25T	BCM40T
TCGT 110204	**EL-BC**	0,10 - 0,25	0,40 - 2,00	6,35	2,38	0,4		6413218		
TCGT 16T304	**ER-BC**	0,10 - 0,25	0,40 - 3,00	9,52	3,97	0,4		6413230		
TCGT 16T308	**EL-BC**	0,15 - 0,30	0,80 - 3,00	9,52	3,97	0,8		6413234		
TCGT 16T308	**ER-BC**	0,15 - 0,30	0,80 - 3,00	9,52	3,97	0,8		6413238		
TCMT 110204	**BSMS**	0,10 - 0,25	0,40 - 2,00	6,35	2,38	0,4		6400381		
TCMT 110208	**BSMS**	0,10 - 0,30	0,80 - 2,00	6,35	2,38	0,8		6400382		
TCMT 16T304	**BSMS**	0,10 - 0,25	0,40 - 3,00	9,52	3,97	0,4		6400383		
TCMT 16T308	**BSMS**	0,15 - 0,35	0,80 - 3,00	9,52	3,97	0,8		6400384		
TNMG 160404	**BFMS**	0,10 - 0,30	0,40 - 6,00	9,52	4,76	0,4		6400385	5092749	
TNMG 160408	**BFMS**	0,10 - 0,30	0,80 - 6,00	9,52	4,76	0,8		6400386	5092750	
TNMG 160408	**BMS**	0,16 - 0,40	0,80 - 6,00	9,52	4,76	0,8		6400424	5092757	
TNMG 160412	**BMS**	0,16 - 0,40	1,20 - 6,00	9,52	4,76	1,2		6400425	5092759	
TNMG 220408	**BMS**	0,16 - 0,40	0,80 - 7,00	12,7	4,76	0,8		6400387	5092761	
TNMG 220412	**BMS**	0,16 - 0,40	1,20 - 7,00	12,7	4,76	1,2		6400407	5092766	
TNMG 160404	**EL-BC**	0,10 - 0,25	0,40 - 6,00	9,52	4,76	0,4		6411834		
TNMG 160404	**ER-BC**	0,10 - 0,25	0,40 - 6,00	9,52	4,76	0,4		6411838		
TNMG 160408	**ER-BC**	0,15 - 0,35	0,80 - 6,00	9,52	4,76	0,8		6410961		

Bestellbeispiel Order example: 10 Stück 10 pieces TCGT 110204 EL-BC LC435D oder or 6413218

Verfügbar ab Lager Available from stock

Wendeschneidplatten für die Bearbeitung von rostfreien Stählen
Indexable inserts for machining stainless steels

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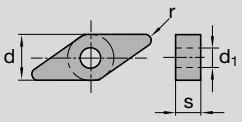
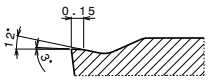
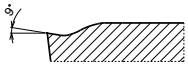
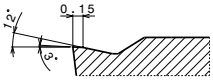
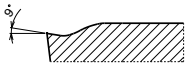
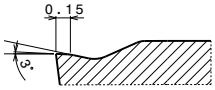
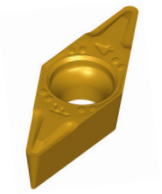


Sorte Grade	ISO-Klasse ISO-class
LCM20T LC435D BCM25T BCM40T	HC-M20 HC-M35 HC-M25 HC-M40

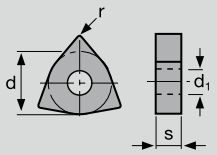
VBMT....-MM	VCGT....-FM	VCMT....-BSMS	VCMT....-FM	VCMT....-MM
				
medium	fine	medium	fine	medium
				

Type Type	Geometrie Geometry	Vorschub Feed f [mm / U rev]	Schnitttiefe cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm]			LCM20T	LC435D	BCM25T	BCM40T
				d	s	r				
VBMT 160404	**MM**	0,12 - 0,25	0,4 - 3,00	9,52	4,76	0,4		5073346	5101440	
VBMT 160408	**MM**	0,15 - 0,30	0,8 - 3,00	9,52	4,76	0,8		5073345	5101442	
VCGT 050102	**FM**	0,07 - 0,13	0,2 - 1,00	3,1	1,59	0,2			5120563	5124312
VCMT 160404	**BSMS**	0,10 - 0,25	0,40 - 4,00	9,52	4,76	0,4		6407783		
VCMT 160408	**BSMS**	0,15 - 0,35	0,80 - 4,00	9,52	4,76	0,8		6407790		
VCMT 160412	**BSMS**	0,15 - 0,35	1,20 - 4,00	9,52	4,76	1,2		6407798		
VCMT 070202	**FM**	0,05 - 0,13	0,20 - 1,50	3,97	2,38	0,2			5106924	5106923
VCMT 070204	**FM**	0,08 - 0,20	0,40 - 1,50	3,97	2,38	0,4			5106926	5106925
VCMT 110302	**FM**	0,05 - 0,13	0,20 - 1,50	6,35	3,18	0,2			5106939	5106931
VCMT 110304	**FM**	0,08 - 0,20	0,40 - 1,50	6,35	3,18	0,4			5106947	5106945
VCMT 160404	**MM**	0,15 - 0,40	0,40 - 3,00	9,52	4,76	0,4	5113372		5092767	
VCMT 160408	**MM**	0,15 - 0,40	0,80 - 3,00	9,52	4,76	0,8	5113374		5092770	
VCMT 160412	**MM**	0,15 - 0,40	1,20 - 3,00	9,52	4,76	1,2			5092771	

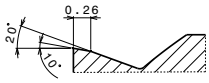
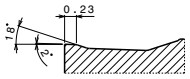
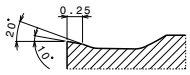
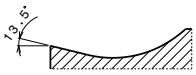
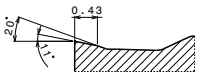
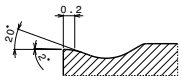
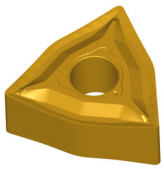
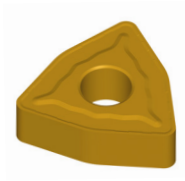
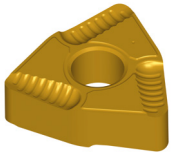
Bestellbeispiel Order example: 10 Stück 10 pieces VBMT 160404-MM LC435D oder or 5073346

Verfügbar ab Lager Available from stock

Wendeschneidplatten für die Bearbeitung von rostfreien Stählen
Indexable inserts for machining stainless steels



Sorte Grade	ISO-Klasse ISO-class
LCM20T LC435D BCM25T BCM40T	HC-M20 HC-M35 HC-M25 HC-M40

WNMG....-BFMS	WNMG....-BMRS	WNMG....-BMS	WNMG....E.-BC	WNMG....-MM	WNMG....-MRM
					
medium fine	medium rough	medium	copy	medium	medium rough
					

Type Type	Geometrie Geometry	Vorschub Feed f [mm / U rev]	Schnitttiefe cutting depth ap max. [mm]	Abmessungen [mm] Dimensions [mm]			LCM20T	LC435D	BCM25T	BCM40T
				d	s	r				
WNMG 060404	**BFMS**	0,10 - 0,30	0,40 - 4,00	9,52	4,76	0,4		6400388		
WNMG 080404	**BFMS**	0,10 - 0,30	0,40 - 5,50	12,7	4,76	0,4		6400389	5092773	
WNMG 080408	**BFMS**	0,10 - 0,30	0,80 - 5,50	12,7	4,76	0,8		6400390	5092774	
WNMG 080408	**BMRS**	0,32 - 0,60	0,80 - 5,50	12,7	4,76	0,8		6400428	5101443	5101444
WNMG 080412	**BMRS**	0,32 - 0,60	1,20 - 5,50	12,7	4,76	1,2		6400429	5101445	5101446
WNMG 060408	**BMS**	0,16 - 0,40	0,80 - 4,00	9,52	4,76	0,8		6400391		
WNMG 080408	**BMS**	0,16 - 0,40	0,80 - 5,50	12,7	4,76	0,8		6400392		
WNMG 080412	**BMS**	0,20 - 0,45	1,20 - 5,50	12,7	4,76	1,2		6400393		
WNMG 080416	**BMS**	0,25 - 0,45	1,60 - 5,50	12,7	4,76	1,6		6400427		
WNMG 080404	**ER-BC**	0,10 - 0,25	0,40 - 5,50	12,7	4,76	0,4		6410972		
WNMG 080408	**EL-BC**	0,20 - 0,45	0,80 - 5,50	12,7	4,76	0,8		6410976		
WNMG 080408	**ER-BC**	0,20 - 0,45	0,80 - 5,50	12,7	4,76	0,8		6410980		
WNMG 080412	**EL-BC**	0,20 - 0,45	1,20 - 5,50	12,7	4,76	1,2		6411651		
WNMG 080412	**ER-BC**	0,20 - 0,45	1,20 - 5,50	12,7	4,76	1,2		6411654		
WNMG 060404	**MM**	0,15 - 0,25	0,40 - 4,00	9,52	4,76	0,4			5092772	
WNMG 080408	**MM**	0,15 - 0,30	0,80 - 5,50	12,7	4,76	0,8	5060171		5092775	
WNMG 080412	**MM**	0,15 - 0,40	1,20 - 5,50	12,7	4,76	1,2	5060526		5092788	
WNMG 080416	**MM**	0,15 - 0,40	1,60 - 5,50	12,7	4,76	1,6			5092789	
WNMG 080408	**MRM**	0,20 - 0,50	0,80 - 5,00	12,7	4,76	0,8	5151912		5151913	5151915
WNMG 080412	**MRM**	0,20 - 0,50	1,20 - 5,00	12,7	4,76	1,2	5151916		5151917	5151919

Bestellbeispiel Order example: 10 Stück 10 pieces WNMG 060404-BFMS LC435D oder or 6400388

Verfügbar ab Lager Available from stock

Werkstoffgruppe Material group			Brinell Härte HB Brinell hardness HB	LCM20T Negative Wendeplatten Negative indexable inserts ISO-P-System Geometrie Geometry	Schnittgeschwindigkeit v_c (m/min) Cutting speed v_c (m/min)	LCM20T Positive Wendeplatten Positive indexable inserts ISO-S-System Geometrie Geometry	Schnittgeschwindigkeit v_c (m/min) Cutting speed v_c (m/min)
M	Ferritisch Ferritic	1.4000, 1.4002, 1.4003, 1.4006, 1.4016, 1.4104, 1.4113, 1.4313, 1.4742, 1.4762	180	MM	180 – 230	MM	180 – 230
				MRM	150 – 230	FM	180 – 230
	Martensitisch Martensitic	1.4006, 1.4014, 1.4021, 1.4024, 1.4027, 1.4028, 1.4031, 1.4034, 1.4057, 1.4122, 1.4724	320	MM	180 – 230	MM	180 – 230
				MRM	150 – 230	FM	180 - 230
	Austenitisch Austenitic	1.4300, 1.4301, 1.4303, 1.4305, 1.4306, 1.4308, 1.4310, 1.4311	180	MM	150 - 200	MM	150 – 200
				MRM	130 - 200	FM	130 - 200
		1.4321, 1.4401, 1.4404, 1.4406, 1.4428, 1.4435, 1.4436, 1.4438, 1.4449 1.4571	180	MM	150 – 200	MM	150 – 200
				MRM	130 - 200	FM	130 - 200

Die angegebenen Schnittdatenrichtwerte sind Empfehlungen für Anwendungen mit Kühlschmierstoff.
Bei Trockenbearbeitung reduzieren Sie die Schnittgeschwindigkeit v_c um ca. 20 %.
The above recommendations are given for wet machining. For dry machining the recommended values for the cutting speed have to be reduced by approx. 20 %.

Schnittwertempfehlungen für Drehen BCM25T
Turning data recommendations for BCM25T

Werkstoffgruppe / Material group			Brinell Härte HB / Brinell hardness HB	BCM25T Negative Wendeplatten / Negative indexable inserts ISO-P-System: Geometrie / Geometry	Schnittgeschwindigkeit v_c (m/min) / Cutting speed v_c (m/min)	BCM25T Positive Wendeplatten / Positive indexable inserts ISO-S-System: Geometrie / Geometry	Schnittgeschwindigkeit v_c (m/min) / Cutting speed v_c (m/min)
M	Ferritisch Ferritic	1.4000, 1.4002, 1.4003, 1.4006, 1.4113, 1.4313, 1.4742, 1.4762	180	MM	130 - 200	MM	130 - 200
				BFMS	130 - 200	FM	130 - 200
				BMS	130 - 200		
				BMRS	90 - 180		
	Martensitisch Martensitic	1.4006, 1.4014, 1.4021, 1.4024, 1.4027, 1.4028, 1.4031, 1.4034, 1.4057, 1.4122, 1.4724	320	MM	130 - 200	MM	130 - 200
				BFMS	130 - 200		
						FM	130 - 200
				BMS	130 -200		
				BMRS	90 - 180		
				MRM	90 - 180		
	Austenitisch Austenitic	1.4300, 1.4301, 1.4303, 1.4305, 1.4306, 1.4308, 1.4310, 1.4311	180	MM	100 - 180	MM	100 - 180
				BFMS	100 - 180	FM	100 - 180
				BMS	100 - 180		
		1.4321, 1.4401, 1.4404, 1.4406, 1.4428, 1.4435, 1.4436, 1.4438, 1.4449 1.4571	180	MM	100 - 180	MM	100 - 180
				BFMS	100 - 180	FM	100-180
				BMRS	90 - 180		
				MRM	90 - 180		

Die angegebenen Schnittdatenrichtwerte sind Empfehlungen für Anwendungen mit Kühlschmierstoff.
Bei Trockenbearbeitung reduzieren Sie die Schnittgeschwindigkeit v_c um ca. 20 %.
The above recommendations are given for wet machining. For dry machining the recommended values for the cutting speed have to be reduced by approx. 20 %.

Werkstoffgruppe / Material group			Brinell Härte HB / Brinell hardness HB	BCM40T / LC435D			
				Negative Wendeplatten / Negative indexable inserts ISO-P-System		Positive Wendeplatten / Positive indexable inserts ISO-S-System	
				Geometrie / Geometry	Schnittgeschwindigkeit v_c (m/min) / Cutting speed v_c (m/min)	Geometrie / Geometry	Schnittgeschwindigkeit v_c (m/min) / Cutting speed v_c (m/min)
M	Ferritisch / Ferritic	1.4000, 1.4002, 1.4003, 1.4006, 1.4016, 1.4104, 1.4113, 1.4313, 1.4742, 1.4762	180	MM	100 - 180	MM	100 - 180
				BMS	100 - 180	FM	100 - 180
				BMRS	100 - 180	BSMS	100 - 180
				MRM	100-180	E. - BC	80 - 160
				E. - BC	80 - 160		
	Martensitisch / Martensitic	1.4006, 1.4014, 1.4021, 1.4024, 1.4027, 1.4028, 1.4031, 1.4034, 1.4057, 1.4122, 1.4724	320	MM	100 - 180	MM	100 - 180
				BMS	100 -180	FM	100 - 180
				BMRS	100 - 180	BSMS	100 - 180
				MRM	100 - 180	E. - BC	80 - 160
				E. - BC	80 - 160		
	Austenitisch / Austenitic	1.4300, 1.4301, 1.4303, 1.4305, 1.4306, 1.4308, 1.4310, 1.4311	180	MM	90 - 160	MM	90 -160
				BMS	90 - 160	FM	90 - 160
				BMRS	80 - 160	BSMS	90 - 160
				MRM	80 - 160	E. - BC	70 - 140
				E. - BC	70 - 150		
		1.4321, 1.4401, 1.4404, 1.4406, 1.4428, 1.4435, 1.4436, 1.4438, 1.4449 1.4571	180	MM	90 - 160	MM	90 - 160
				BMS	90 - 160	FM	90 - 160
				BMRS	80 - 160	BSMS	90 - 160
				MRM	80 - 160	E. - BC	70 - 140
				E. - BC	70 - 150		

Die angegebenen Schnittdatenrichtwerte sind Empfehlungen für Anwendungen mit Kühlschmierstoff.
Bei Trockenbearbeitung reduzieren Sie die Schnittgeschwindigkeit v_c um ca. 20 %.
The above recommendations are given for wet machining. For dry machining the recommended values for the cutting speed have to be reduced by approx. 20 %.

Vergleich ISO - zu ANSI - Kennzeichnung
Designation: Comparison ISO and ANSI

Vergleich Comparison					
ISO	ANSI	ISO	ANSI	ISO	ANSI
CCGT 030101	CCGT (1.2) 1 (.2)	DCGT 04T002	-	SCMT 120408	SCMT 432
CCGT 030102	CCGT (1.2) 1 (.5)	DCGT 070204	DCGT 2 (1.5) 1		
CCGT 060204	CCGT 2 (1.5) 1	DCGT 11T304	DCGT 3 (2.5) 1	SNMG 090304	SNMG 321
CCGT 060208	CCGT 2 (1.5) 2	DCGT 11T308	DCGT 3 (2.5) 2		
CCGT 09T304	CCGT 3 (2.5) 1			SNMG 120408	SNMG 432
CCGT 09T308	CCGT 3 (2.5) 2	DCMT 070202	DCMT 2 (1.5) (.5)	SNMG 120412	SNMG 433
CCGT 120408	CCGT 432	DCMT 070204	DCMT 2 (1.5) 1	SNMG 150612	SNMG 543
CCGT 120412	CCGT 433	DCMT 11T302	DCMT 3 (2.5) (.5)	SNMG 150616	SNMG 544
		DCMT 11T304	DCMT 3 (2.5) 1	SNMG 190612	SNMG 643
CCMT 060202	CCMT 2 (1.5) (.5)	DCMT 11T308	DCMT 3 (2.5) 2	SNMG 190616	SNMG 644
CCMT 060204	CCMT 2 (1.5) 1				
CCMT 09T304	CCMT 3 (2.5) 1	DNMG 110404	DNMG 331		
CCMT 09T308	CCMT 3 (2.5) 2	DNMG 110408	DNMG 332		
CCMT 120404	CCMT 431	DNMG 150404	DNMG 431		
CCMT 120408	CCMT 432	DNMG 150408	DNMG 432		
		DNMG 150604	DNMG 441		
CNMG 090304	CNMG 321	DNMG 150608	DNMG 442		
CNMG 120404	CNMG 431	DNMG 150612	DNMG 443		
CNMG 120408	CNMG 432				
CNMG 120412	CNMG 433				
CNMG 160608	CNMG 542				
CNMG 160612	CNMG 543				
CNMG 160616	CNMG 544				
CNMG 190612	CNMG 643				
CNMG 190616	CNMG 644				

Vergleich Comparison					
ISO	ANSI	ISO	ANSI	ISO	ANSI
TCGT 110204	TCGT 2 (1.5) 1	VBMT 160404	VBMT 331	WNMG 060404	WNMG 331
		VBMT 160408	VBMT 332	WNMG 060408	WNMG 332
TCGT 16T304	TCGT 3 (2.5) 1			WNMG 080404	WNMG 431
TCGT 16T308	TCGT 3 (2.5) 2	VCGT 050102	-	WNMG 080408	WNMG 432
				WNMG 080412	WNMG 433
TCMT 110204	TCMT 2 (1.5) 1	VCMT 070202	-	WNMG 080416	WNMG 434
TCMT 110208	TCMT 2 (1.5) 2	VCMT 070204	-		
TCMT 16T304	TCMT 3 (2.5) 1	VCMT 160404	VCMT 331		
TCMT 16T308	TCMT 3 (2.5) 2	VCMT 160408	VCMT 332		
		VCMT 160412	VCMT 333		
TNMG 160404	TNMG 331				
TNMG 160408	TNMG 332				
TNMG 160412	TNMG 333				
TNMG 220408	TNMG 432				
TNMG 220412	TNMG 433				

Boehlerit GmbH & Co. KG
Werk VI-Strasse 100
8605 Kapfenberg
Österreich/Austria
Telefon +43 3862 300 - 0
Telefax +43 3862 300 - 793
info@boehlerit.com
www.boehlerit.com

Vertriebstöchter und Repräsentanten
Subsidiaries and representatives

Brasilien/*Brazil*
Boehlerit Brasil Ferramentas Ltda.
Rua Capricórnio 72
Alpha Conde Comercial I
06473-005 - Barueri -
São Paulo
Tel. +55 11 554 60 755
Fax +55 11 554 60 476
info@boehlerit.com.br
www.boehlerit.com.br

Deutschland/*Germany*
(Verschleiß/*Wear parts*)
Boehlerit GmbH & Co. KG
Heidenheimer Straße 108
D-73447 Oberkochen
Telefon +49 7364 950-700
Telefax +49 7364 950-720
bld@boehlerit.de
www.boehlerit.de

Indien/*India*
Boehlerit India
Otto Bilz Private Limited
No.5A-5B/6A,
KIADB Industrial Areea
Doddaballapur-561 203
Bangalore District, Karnataka
Tel. +91-080-22638700
Fax +91-080-22638702
Venkat@bilztool.com
www.boehlerit.com

Italien/*Italy*
Boehlerit Italy S.r.l.
Via Papa Giovanni XXIII, Nr. 45
20090 Rodano (MI)
Tel. +39 02 269 49 71
Fax +39 02 218 72 456
info@boehlerit.it
www.boehlerit.it

Mexiko/*Mexico*
Boehlerit S.A. de C.V.
Av. Acueducto No. 15
Parque Industrial Bernardo Quintana
El Marqués, Querétaro
México. C.P. 76246
Tel. +52 442 221 5706
Fax +52 442 221 5555
info@boehlerit.com.mx
www.boehlerit.com.mx

Österreich/Austria
Boehlerit GmbH & Co. KG
Werk VI-Straße 100
8605 Kapfenberg
Österreich/Austria
Telefon +43 3862 300 - 0
Telefax +43 3862 300 - 793
sales-at@boehlerit.com
www.boehlerit.com

Polen/*Poland*
Boehlerit Polska sp.z.o.o.
Złotniki, ul. Kobaltowa 6
62-002 Suchy Las
Tel. +48 61 659 38 00
Fax +48 61 623 20 14
info@boehlerit.pl
www.boehlerit.pl

Slowakei/*Slovakia*
Kancelár Boehlerit
Santraziny 753
760 01 Zlín
Tel. +420 577 214 989
Fax +420 577 219 061
boehlerit@boehlerit.sk
www.boehlerit.sk

Spanien/*Spain*
Boehlerit Spain S.L.C/
Tecnología, 82 Pasaje C Nave 22
08450 Llinars del Valles
Barcelona
Tel. +34 93 750 7907
info@boehlerit.es
www.boehlerit.es

Tschechien/*Czech Republic*
Kancelár Boehlerit
Santraziny 753
760 01 Zlín
Tel. +420 577 214 989
Fax +420 577 219 061
boehlerit@boehlerit.cz
www.boehlerit.cz

Türkei/*Turkey*
Boehlerit
Sert Metal ve Takım San. ve Tic. A.Ş.
Gosb 1600. Sok.No: 1602
41480 Gebze – Kocaeli
Tel. +90 262 677 1737
Fax +90 262 677 1746
info@boehlerit.com.tr
www.boehlerit.com.tr

Ungarn/*Hungary*
Boehlerit Hungária Kft.
2036 Érdliget Pf. 32
2030-Érd, Kis-Duna u.6.
Tel. +36 23 521 915
Fax +36 23 521 919
info@boehlerit.hu
www.boehlerit.hu

USA
Kanada/*Canada*
Boehlerit USA
Bilz USA
1140 No.Main St.
Lombard IL 60148
Tel. +1 847 734 9390
Fax 1 847 734 9391
www.boehlerit.com

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