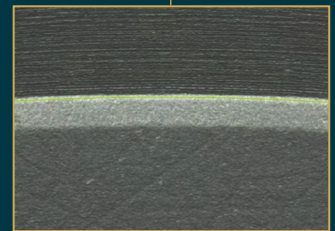
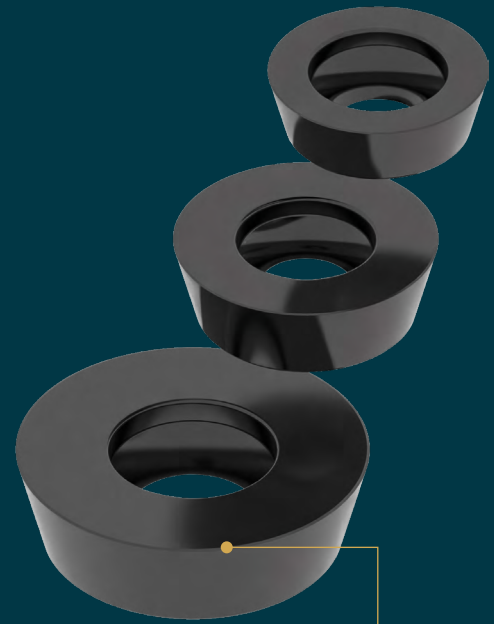


ACU-Jet Premium

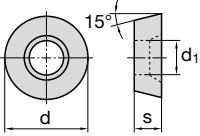
New Grade LCPK35M



Precision-sintered chamfer

Features:

- Optimized precision sintered insert type RDMW..
- New grade LCPK35M
- High-performance grade for roughing and semi-finishing in ISO P and ISO K
- Wear resistant HiPIMS coating
- Up to 60 % longer tool life compared to LCP35M

							Cutting materials Ident No.	For cutter
N = Number of cutting edges	LMT-Code	l	d	s	d ₁	r	LCKP35M	Cat-No.
 	RDMW 1003 M0 S	–	10	3.18	3.8	–	7498456	ECC FCC ECZ
	RDMW 12T3 M0 S	–	12	3.97	3.8	–	7498457	
	RDMW 1604 M0 S	–	16	4.76	5.2	–	7498458	
							■	P
							■	M
							■	K
								N
								S
								H

■ = First choice
□ = Alternativ

Laboratory test against existing grade

Tool:

ACU-Jet Premium
Ø 52 mm, z = 1

Insert:

RDMW 12T3 | LCPK35M

Material:

1.2379

Machine:

DMG | DMC 635 V

Cutting data:

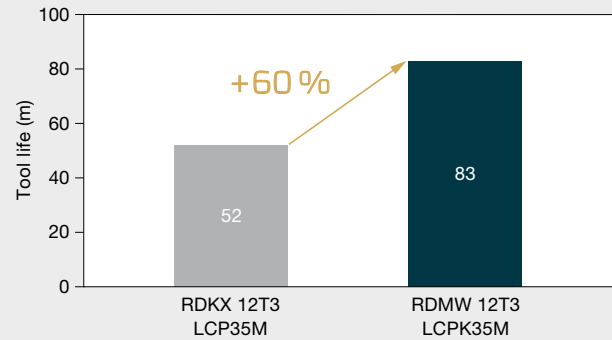
$v_c = 175$ m/min
 $f_z = 1.2$ mm
 $a_e = 13$ mm
 $a_p = 0.6$ mm

Coolant:

dry

Result:

Tool life +60 %



Field test against ground geometry

Tool:

ACU-Jet Premium
Ø 52 mm, z = 6

Insert:

RDMW 12T3 | LCPK35M

Material:

1.2312 (30 HRC)

Machine:

FP30

Cutting data:

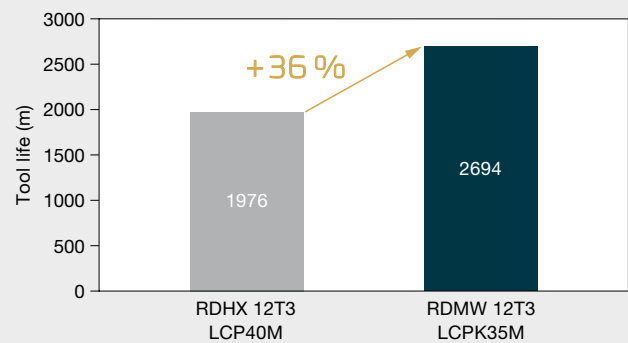
$v_c = 168$ m/min
 $f_z = 0.5$ mm
 $a_e = 37.6$ mm
 $a_p = 0.7$ mm

Coolant:

Emulsion (7 %)

Result:

Tool life +36 %



Customer trial against competition

Component bearing housing

Tool:

ACU-Jet Premium
Ø 63 mm
z = 6 (LMT Tools)
z = 7 (Competitor)

Insert:

RDMW 12T3 | LCPK35M

Material:

1.7225, $R_m = 900-1100$ N/mm²

Machine:

DMG | DMU60

Cutting data:

$v_c = 175$ m/min
 $f_z = 0.4$ mm (LMT Tools)
0.3 mm (Competitor)
 $a_e = 31.5$ mm
 $a_p = 1.8$ mm

Coolant:

dry

Result:

Tool life +200 %
Cycle time -28 %

