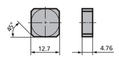
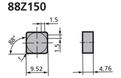
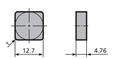
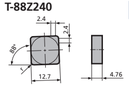
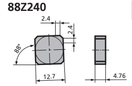
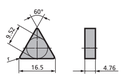
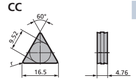
LKM 880 Inserts

Insert	ISO	Grade	K																						H		S	P	SPK-Ref. No.
			GJL					GJS					ADI				SI GJS			GJV									
			EN-GJL 150	EN-GJL 200	EN-GJL 250	EN-GJL 300	EN-GJL 350	EN-GJS 400-15	EN-GJS 500-7	EN-GJS 600-3	EN-GJS 700-2	EN-GJS 800-2	EN-GJS 800-8	EN-GJS 1000-5	EN-GJS 1200-2	EN-GJS 1400-0	EN-GJS 450-18	EN-GJS 500-14	EN-GJS 600-10	EN-GJV 300	EN-GJV 350	EN-GJV 400	EN-GJV 450	EN-GJV 500	HARD STEEL	CHILLED CAST IRON	DIE CASTING	HRSA	STEEL	
SNCN 12 04 ZN T 	SNCN 12 04 ZN T00520	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦					◇	◇	◇											23.10.409.03.9
SNGN 090404 T 88Z150 	SNGN 09 04 04 T01020 88Z150	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦					◇	◇	◇											23.10.490.20.9
SNGN 0904 .. T 	SNGN 09 04 08 T01020	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦					◇	◇	◇											23.10.490.20.9
SNGN 120408 .. T-88Z240 	SNGN 12 04 08 T01020 88Z240	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦					◇	◇	◇											33.02.272.09.0
SNGN 1204 ZN T-88Z240 	SNGN 12 04 ZN T01020 88Z240	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦					◇	◇	◇											33.02.272.09.0
TNCN 1604 .. T 	TNCN 16 04 08 T01020	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦					◇	◇	◇											33.02.272.09.0
TNCN 160408 T01020-CC 	TNCN 16 04 08 T01020-CC	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦					◇	◇	◇											33.02.272.09.0

ISO Application group

K ■ Cast Iron | H ■ Hard materials | S ■ HSRA | P ■ Steel | Main application ✦ | Secondary applitcation ◇

SPK Cutting Tools
by CeramTec GmbH
Hauptstraße 56
73061 Ebersbach / Fils, Germany

Phone: +49 7163 166-239
info@spk-tools.com
www.spk-tools.com

Website
www.spk-tools.com

YouTube Kanal:
SPKCuttingTools

EN / 2407 / IM

CUTTING TOOLS

Milling of Cast Iron Materials

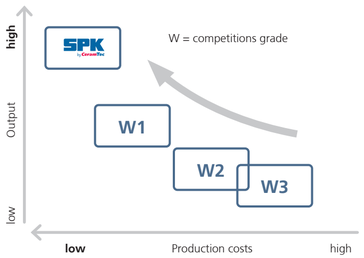
LKM 880

THE CERAMIC EXPERTS

LKM 880 – High-performance ceramics for milling

Optimal toughness combined with excellent wear resistance make the ceramic grade LKM 880 a high-performance cutting material for the rough milling of GJL (GG) and GJS (GGG) materials. The LKM 880 permits high machining speeds due to its good wear behaviour. As a result, large stock removal rates are achieved while maintaining excellent process reliability. The achievable tool life can be significantly increased when machining cast iron materials with the LKM 880.

Higher productivity along with simultaneous reduction of manufacturing times and costs – all this is offered by the LKM 880, the high-performance cutting material for enhancing the added value when milling.



Good to know
- High machining speed
- Excellent wear resistance
- Best process reliability

LKM 880
Recommended cutting data

GJL (GG)	Recommended value v_c	Overall range v_c	Recommended value f_z	Overall range f_z
Hardness (HB)	**m/min.**	**m/min.**	**mm/z**	
190 - 210	1000	800 - 1200	0,20	0,1 - 0,25
220 - 240	800	500 - 1000	0,20	0,1 - 0,25
250 - 280	650	450 - 750	0,20	0,1 - 0,25

GJS (GGG)	Recommended value v_c	Overall range v_c	Recommended value f_z	Overall range f_z
Tensile strength RM (N/mm²)	**m/min.**	**m/min.**	**mm/z**	
400 - 500	800	600 - 1000	0,16	0,1 - 0,25
500 - 700	700	500 - 800	0,16	0,1 - 0,25

LKM 880 Inserts

Insert	ISO	Grade	K: GJL EN-GJL 150	GJL EN-GJL 200	GJL EN-GJL 250	GJL EN-GJL 300	GJL EN-GJL 350	GJS EN-GJS 400-15	GJS EN-GJS 500-7	GJS EN-GJS 600-3	GJS EN-GJS 700-2	GJS EN-GJS 800-2	ADI EN-GJS 1050-6	ADI EN-GJS 1200-2	SI GJS EN-GJS 1400-0	SI GJS EN-GJS 450-18	SI GJS EN-GJS 500-14	SI GJS EN-GJS 600-10	GJV EN-GJV 300	GJV EN-GJV 350	GJV EN-GJV 400	GJV EN-GJV 450	GJV EN-GJV 500	H HARD STEEL	S DIN 1.4542 (17-4PH)	S DIN 1.4462 (2205)	S HRSA	P STEEL	SPK-Ref. No.
HNGX 10 05 .. T	**HNGX 10 05 12 T01020**	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦				✧	✧	✧											23.60.123.20.9
HNGX 100516 T47Z125	**HNGX 10 05 16 T01020 - 47Z125**	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦				✧	✧	✧											23.60.120.20.9
ONHN 05 04 .. T01020	**ONHN 05 04 08 T01020**	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦				✧	✧	✧											23.70.008.20.9
ONHX 06 06 .. T01020	**ONHX 06 06 16 T01020**	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦				✧	✧	✧											23.76.017.20.9
OPHN 0504 .. T01020	**OPHN 05 04 12 T01020**	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦				✧	✧	✧											23.72.001.20.9
OPHN 0504 ZZ T01020	**OPHN 05 0 4ZZ T01020**	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦				✧	✧	✧											23.72.002.20.9
SNCN 12 04 .. T	**SNCN 12 04 04 T00520**	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦				✧	✧	✧											23.10.431.03.9
	SNCN 12 04 08 T01020	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦				✧	✧	✧											23.10.528.20.9
	SNCN 12 04 12 T01020	LKM 880	✦	✦	✦	✦	✦	✦	✦	✦	✦	✦				✧	✧	✧											23.10.505.20.9

ISO Application group

K Cast Iron | H Hard materials | S HSRA | P Steel | Main application ✦ | Secondary applitcation ✧