



Jongen Werkzeugtechnik GmbH & Co. KG

Product Information

The New Inserts

FP 339

a completion to the product
range Type 329

1. Technical Description

As a completion of our insert group FP 329, the FP 339 insert has been added to this product range. The 4-effective-edges insert with highly positive chip breaker is ground at the peripheral surface and depending on the different types it is polished at the rake face.

2. Application Areas

All usual steel types, stainless steel and aluminium

3. Coating Qualities

HT45



Code 31, ISO-Classification P30-P35

Very tough fine grain carbide with a AlTiN- Nanocomposit-coating for middle – high cutting speeds and high feed rates. This quality is suitable for dry milling and can also be adopted with cooling. Application areas are roughing and finishing of almost all steels and cast iron qualities such as: Structural steel, tool steel, heat-treatable steel, as well as unalloyed steel, low alloyed steel, high alloyed steel and also grey cast iron, globular graphite cast iron etc.

HT35



Code 19, ISO-Classification M20-M30

Hard wearing and tough finest grain carbide, with a multilayer TiAlN-coating, for middle cutting speeds and feed rates. This quality requires cooling adoption. Application areas are roughing and finishing stainless steel and high grade materials.

K15M



Code 8, ISO-Classification K10

Very hard wearing fine grain carbide, for high cutting speeds with high feed rates. This quality is suitable for dry milling and can also be adopted with cooling. Application areas are roughing and finishing non-ferrous heavy materials and aluminium up to an Si-component of approx. 8%.



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FP 339

HT45 = 8,70 € > Peripheral ground insert with highly positive chip breaker

HT35 = 8,70 € > Peripheral ground insert with highly positive chip breaker

K15M = 8,70 € > Peripheral ground insert with highly positive chip breaker, polished rake face

4. Cutting Data Recommendations

		HT45 (code 31)	HT35 (code 19)	K15M (code 8)				
	f_z [mm]	0,30 (0,20-0,50)	0,20 (0,15-0,45)					
				0,30 (0,20-0,50)				
	VPE	20	20	20				

V_c [m/min]	Steel	Stainless	Cast iron	Non-ferrous metals	Highly heat-resistant	Tempered
HT45	250 (200 - 350)	240 (140 - 300)	240 (130 - 280)			
HT35	160 (120 - 220)	200 (100 - 300)			60 (40 - 200)	
K15M				400 (300 - 600)		

axial depth of cut max. 4,1 mm

The above mentioned data are standard values.

Up and down corrections are admitted depending on the machine type, working piece and holding fixture.

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