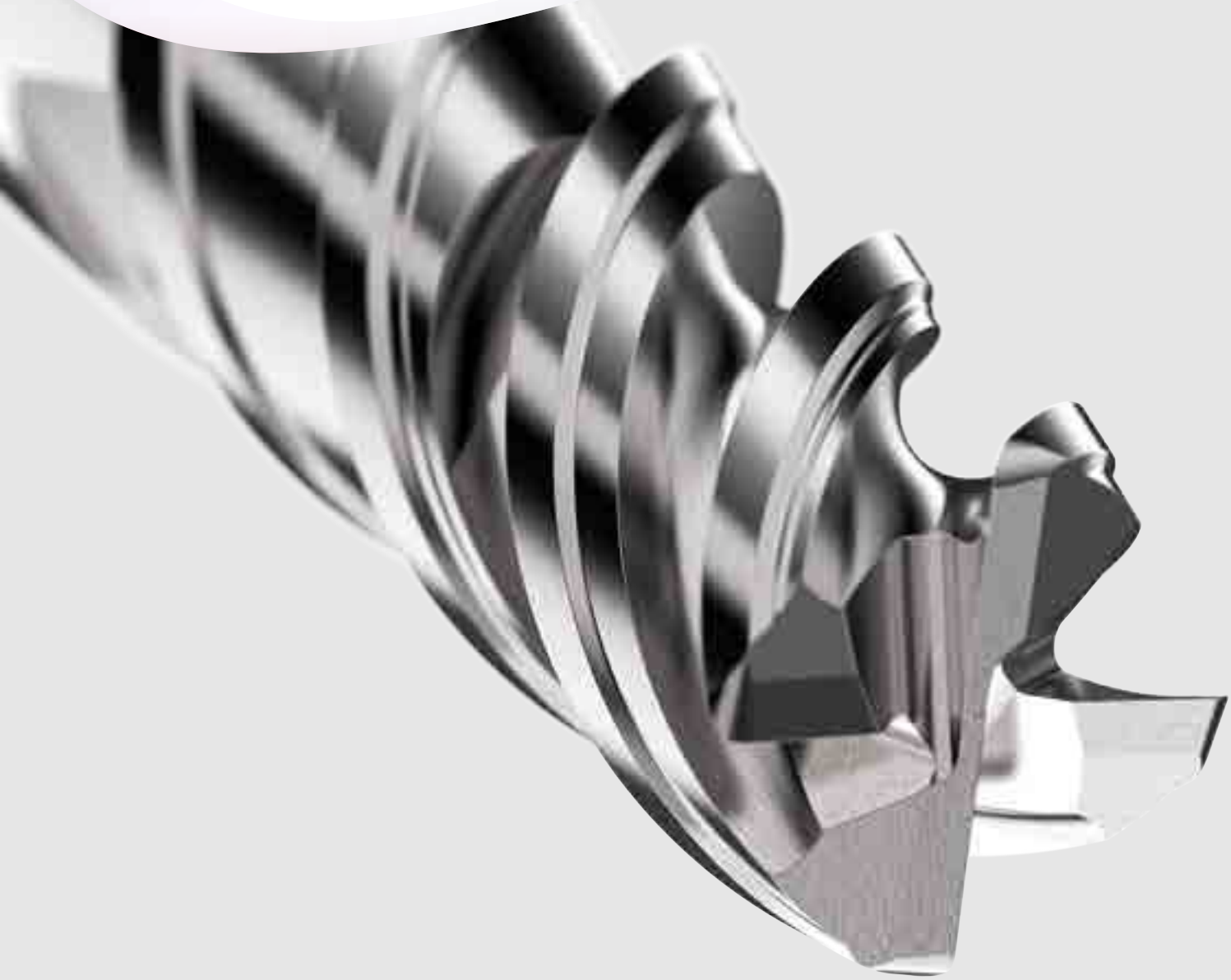
Seco

uemme TOOLS and EQUIPMENT

Catalogo e guida tecnica 2024.1

Frese integrali



In Seco, realizziamo utensili, tecnologie e soluzioni per le sfide di produzione più avanzate al mondo. Dalla nascita della casamadre a Fagersta, in Svezia, fino alla società internazionale che siamo oggi, il nostro business è sempre stato fondato sulla fiducia e sulle esigenze del cliente.

Combinando utensili di precisione all'avanguardia con collaborazioni durature, siamo un' azienda di persone che aiuta i nostri partner a vincere le sfide dell'industria manifatturiera.

Siamo orgogliosi di essere Made for maker. Aprire la strada al futuro e all'innovazione. In breve - se esiste l'utensile giusto per la lavorazione, lo forniremo ai nostri clienti. Se non esiste, lo creeremo.

Siamo orgogliosi di porre la sostenibilità al centro di tutto ciò che facciamo, sfidando le percezioni del nostro settore, cambiando il processo di produzione e giocando il nostro piccolo ruolo nel plasmare un futuro più luminoso.

Made for Makers

BENVENUTI NEL MONDO DELLA FRESATURA INTEGRALE SECO



JABRO venne fondata nel 1976 a Lottum, nei Paesi Bassi.
JABRO è il centro di competenza del gruppo Seco per le frese in metallo duro ed è responsabile dello sviluppo e della produzione delle stesse.

Seco-JABRO offre al mercato una vasta gamma di prodotti standard e di soluzioni personalizzate, ripristino incluso, principalmente per i settori delle lavorazioni generiche, aerospaziale, della generazione di energia, medicale e stampisti.

Tecnologie di lavorazioni avanzate ed attenzione all'ambiente consentono a Seco di produrre in modo sostenibile utensili che rispondono alle richieste del mercato, per fresatura di materiali sia ferrosi che non ferrosi.

- Lavorazioni generiche
- Stampisti
- Aerospaziale
- Medicale
- Generazione di energia
- Computer, elettronica di consumo e comunicazioni (segmento 3C)

Generale

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Panoramica della famiglia di prodotti

SOLID²



Jabro-Solid² è una gamma di frese integrali in metallo duro per applicazioni generiche che garantisce flessibilità, velocità ed ottimizzazione dei costi. Le frese Jabro-Solid² sono disponibili in diametri di ∅1-∅32 mm e di ∅1/32 - 1 1/4 *pollici*.
Jabro-Solid² comprende anche frese specifiche per lavorazioni di sgrossatura avanzata (JS564 e JS565).
Le frese 564 e 565 offrono prestazioni eccellenti quando utilizzate con percorsi utensile ben definiti con arco di contatto costante, in lavorazioni a velocità e profondità di taglio alte (sgrossatura avanzata).
Su tutta la gamma JS500, lo smusso (c*45°) ha le seguenti tolleranze: c = DC</=3=+0,01, 3<DC</=6=+0,02, 6<DC</=10=+0,03,
10<DC</=14=+0,04, 14<DC</=18=+0,05, 18<DC</=24=+0,06,
Tutte le frese Jabro-Solid² hanno codice di ordinazione che inizia con JS.
Alla pagina 9 si trova una panoramica delle frese JS².

HSM/TORNADO



Questi utensili sono caratterizzati da tolleranze strette, tagliente corto, codolo scaricato e nocciolo robusto, per massimizzare la rigidità. Questi utensili sono stati sviluppati per eccellere in lavorazioni di contornatura e di copiatura.
Alla pagina 9 si trova una panoramica delle frese HSM/TORNADO (lavorazioni ad alta velocità).

HPM



Queste frese integrali ottimizzate sono dedicate ai produttori di componenti originali (OEM) ed ai fornitori di primo livello, dove vengono lavorati grandi lotti di componenti e dove i processi devono essere completamente ottimizzati per ridurre i tempi ciclo, abbassando quindi il costo per componente prodotto.
Alla pagina 10 si trova una panoramica delle frese HPM (lavorazioni ad alte prestazioni).

HFM



Le lavorazioni ad elevato avanzamento sono la prima scelta in applicazioni profonde e poco profonde, nella profilatura 3D per applicazioni su stampi e nelle lavorazioni in condizioni instabili. Gli utensili ad elevato avanzamento sono eccellenti nelle lavorazioni di penetrazione assiale.
Alla pagina 10 si trova una panoramica delle frese HFM (lavorazioni ad elevato avanzamento).

Panoramica della famiglia di prodotti

MINI



La gamma Seco di micro frese in metallo duro integrale è formata da frese toriche e da frese a testa sferica con piccoli diametri di taglio. Gli utensili universali sono adatti ai comuni materiali da lavorare, mentre gli utensili specifici sono dedicati alla lavorazione di grafite e di acciai temprati. Tutti hanno un sottile strato di rivestimento, per prestazioni ottimali nella lavorazione di componenti di piccole dimensioni.
Alla pagina 10 si trova una panoramica delle frese MINI (micro lavorazioni).

DIAMOND



Disponibili in una varietà di geometrie ed in una vasta gamma di diametri, questi utensili hanno il miglior substrato per assicurare la perfetta adesione del rivestimento diamond per un'ampia gamma di parametri di taglio. In generale, queste frese integrali aumentano sensibilmente la produttività e riducono i costi degli utensili grazie al minor numero di cambi utensile, e sono in grado di produrre componenti di precisione ad alti avanzamenti.
Alla pagina 10 si trova una panoramica delle frese DIAMOND (rivestite Diamond).

COMPOSITE



Si tratta di frese rivestite al diamante, non rivestite e con PCD; comprendono differenti geometrie e differenti soluzioni con PCD saldobrasato. Questa gamma è composta da utensili ottimizzati per condizioni di lavorazione difficoltose o per materiali impegnativi.
Alla pagina 10 si trova una panoramica delle frese COMPOSITE (JC).

VHM



Questa linea comprende frese integrali universali rivestite e non rivestite, una gamma di prodotti dedicata alla lavorazione di plastiche e di alluminio, con frese per smussi ed utensili conici. Questi prodotti sono caratterizzati da metallo duro e rivestimenti di alta qualità, per una durata lunga e prevedibile.
Alla pagina 11, 12 si trova una panoramica delle frese VHM (lavorazioni generiche).

Panoramica della famiglia di prodotti

INSERTI CERAMICI



Per lavorare rapidamente le superleghe resistenti al calore più tenaci al mondo (HRSA), è necessario un utensile resistente ed avanzato tanto quanto i materiali stessi. Queste frese integrali ceramiche ad alte prestazioni consentono di snellire i processi e lavorare le parti in HRSA molto più velocemente.
Vedere pagina 11, 12 per una panoramica delle frese CERAMICHE.

HSS-CO



L'acciaio rapido al cobalto è un materiale di qualità che offre prestazioni superiori a quelle degli acciai rapidi tradizionali. Grazie alla maggiore durezza, queste frese integrali durano più a lungo sugli odierni materiali abrasivi, resistenti al calore ed esotici.
L'elevata qualità e i bassi costi di produzione di queste frese integrali derivano direttamente dal disegno delle eliche, dai rivestimenti resistenti all'usura e dalle caratteristiche ottimizzate come i canali interni per adduzione refrigerante per questi materiali impegnativi.
Vedere pagina 11, 12 per una panoramica delle frese HSS-CO.

X-Heads



Con il sistema di fresatura a testina intercambiabile Seco, è possibile alternare rapidamente e facilmente vari profili e tipi in metallo duro integrale per ottimizzare tutte le operazioni di fresatura e ridurre i costi di produzione e le scorte di utensili. Le frese integrali X-Heads si montano su una varietà di lunghezze degli attacchi disponibili per una versatilità ancora maggiore, con capacità di sporgenza lunga. I cambi di frese integrali richiedono solo la semplice rotazione di una chiave e l'attacco rimane nella macchina. Eliminano la necessità di reimpostare la lunghezza dell'utensile, grazie a una connessione sicura e affidabile che garantisce precisione di sostituzione entro 50 micron.
Vedere pagina 487 per una panoramica dei prodotti X-Heads (testine intercambiabili).

Panoramica della famiglia di prodotti

Famiglia prodotti	Tecnologia	Prodotto	1xx	4xx	5xx	6xx	7xx	8xx	9xx
Jabro-Solid[2]	Lavorazioni generiche	JS		■	■		■		
Jabro - HPM	Lavorazioni ad alte prestazioni	JHP	■	■			■		■
Jabro - HFM	Lavorazioni ad elevato avanzamento	JHF	■						■
Jabro - Mini	Micro lavorazioni	JM	■	■	■	■			■
Jabro - HSM/Tornado	Lavorazioni ad alta velocità	JH	■	■			■		■
Jabro - Ceramic	Lavorazioni ad alte prestazioni	JCG					■		
Jabro - Diamond	Lavorazioni della grafite	JD				■			
Jabro - Composite	Lavorazioni di compositi	JC, JPD						■	
Jabro - VHM	Lavorazioni generiche	J		■					■
Jabro - HSS-E	Lavorazioni generiche	JCO					■		
X-Heads - Solid[2]	Lavorazioni ad alte prestazioni	XS		■	■		■		
X-Heads - HFM	Lavorazioni ad elevato avanzamento	XHF			■		■		
X-Heads - HSM/Tornado	Lavorazioni ad alta velocità	XH			■		■		
X-Heads - VHM	Lavorazioni generiche	XV			■		■		
SMG									
P1-8					■				■
P11-12					■				■
M1-3					■		■		
M4-5					■		■		
K1-7					■				■
S1-3					■		■		
S11-13					■		■		
H			■		■				
N1				■	■				
N2-3				■	■				
N11				■	■				
TS				■				■	
TP				■				■	
GR						■			
Per ulteriori spiegazioni su SMG (gruppo materiale) vedere pagina 676									

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	37	SOLID[2]	JSE512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	41		JSE513	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	47		JSE514	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	117		JSB512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	57		JS553	●	●	●	●	●	●	●	●	●	●	●	●			●				○
	77		JS554	●	●	●	●	●	●	●	●	●	●	●	●			●				○
	338		JS412						●	●					●			●				
	341		JS413						●	●					●			●				
	344		JS452						●	●					●			●				
	349		JS453						●	●					●			●				
	110		JS520	●	○	○	○	●	●	●	●	○	●	○	●			●				○
	114		JS522	●	●	●	●	●	●	●	●	○	●		●			●				○
	119		JS532	●	○	●	●	●	●	●	●	○	●		●			●				○
	123		JS533	●	○	●	●	●	●	●	●	○	●		●			●				○
	127		JS534	●	○	●	●	●	●	●	●	○	●		●			●				○
	131		JS506	●	○	●	●	●	●	●	●	○	●	●	●			●				○
	135		JS509	●	○	●	●	●	●	●	●	○	●	●	●			●				○
	102		JS564	●	○	●	●	●	●	●	●	●	●	●								
	106		JS565	●	○	●	●	●	●	●	●	●	●	●								
	249		JS720			●	●					●	●									
	269		JS730			●	●					●	●									
	221		JS754		○	●	●					●	●									
	238		JS755		○	●	●					●	●									
	358	HSM/TORNADO	JH40					●	●		●				●							
	208, 398		JH112					●						●								
	388		JH120											●								
	390		JH130											●								
	203, 395		JH142	●	●			●						●								
	401		JH150					●						●								
	403		JH160	●	○									●								
	365		JH410						●		●				●							
	361		JH421						●		●				●			●				
	367		JH440						●	●	●				●			●				
	369		JH450						●	●	●				●			●				
	371		JH460						●		●		●		●			●				
	312		JH710									●	●									
	322		JHB720			●	●		●	●	●	○	●		●			●				
	324		JH721									●	●									
	326		JH722									●	●									
	326		JH724			●	●					●	●									
	326		JH726			●	●					●	●									
	316		JH730									●	●									
	300		JH734	○	●	●						○	●									
	302		JH736	○	●	●						○	●									
	310		JH740									●	●									
	304		JH744	○	●	●						○	●									
	306		JH746	○	●	●						○	●									
	308		JH770									●	●									
	320		JH780									●	●									
	314		JH790									●	●									
	139		JH910	●	○	●	●	●				●	●					●				●
	143, 392		JH930	●	○			●				●	●	●								
	145, 206		JHB970	●	○	●	●					●	●									

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	382	HPM	JHP170											●								
	273		JHP751									●	●									
	276		JHP760			●	●															
	280		JHP770										●									
	287		JHP780									●										
	276		JHP794			●	●															
	354		JHP490						●	●												
	199		JHP951	●	○			●														
	193		JHP993	●	○			●														
	318		JHP994									●	●									
	385	HFM	JHF181	○	○			●				●	●	●								
	385		SHF712																			
	147		JHF980	●	○	●	●	●				●	●	○								
	412	MINI	JMB112											●								
	405		JME142											●								
	410		JME144											●								
	375		JM403/404/406						●	●												
	377		JM413/416						●	●	●				●		●					
	377		SMB413/414/416						●	●					●		●					
	181		JMB542	●	●	●	●		○	○	○		●	○								○
	184		JMB562	●	●	●	●		○	○	○		●	○								○
	188		JMB563	●	●	●	●		○	○	○		●	○								○
	171		JME542	●	●	●	●		○	○	○		●	○								○
	174		JME562	●	●	●	●		○	○	○		●	○								○
	178		JME564	●	●	●	●		○	○	○		●	○								○
	178		SMB713/714/416																			
	178		JME714/716									●	●									
	484	MINI DIAMOND	JMB642/JMB662																			●
	484		JMB662																			●
	482		JME642																			●
	482		SMB614/616																			●
	420	COMPOSITE	JC845													●		●				
	422		JC850													●		●				
	424		JC860													●		●			●	
	426		JC870													●		●			●	
	432		JC871													●		●			●	
	438		JC875													●		●				
	442		JC876													●		●				
	446		JC877													●		●				
	450		JC880													●		●				
	452		JC885													●		●				
	454		JC898																●	●		
	456		JC899																●	●		
	459	PCD	JPD850													●		●				
	461		JPD880													●		●				
	463		JPD890													●		●				
	472	DIAMOND	JD620																			●
	474		JD630																			●
	476		JD640																			●
	478		JD660																			●

● Prima scelta ○ Scelta alternativa

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	467	VHM	J28												●							
	154		J36	○	●	○	○	○	○	●	●	○	○		○			○				
	157		HK/HKM	●		●	●	●	●	○		●	●	●	●			●				
	168		V31	●	○	●	○	●	●	●	●	●	●	●	●			●				●
	151		J29	●	●	●	●	●	●	●	●	●	●	○	●			●				●
	465		J93F												●			●				
	294	Ceramic	JCG790									●										
	497-505	X-HEADS SOLID[2]	XSE550	●	●	●	●	●	●	●	●	●	●	●	●			●				○
	514		XSB540	●	○	●	●	●	●	●	●	○	●	○	●			●				○
	567		XSC509	●	●	●	●	●	○	○	○	○	○		●			●				○
	528-529		XSE450						●	●	●				●			●				
	516-517		XSE720	○	●	●	●					●	●									
	522		XSB720	○	●	●	●					●	●									
	304	X-HEADS HSM/TORNADO	XHT740	○	●	●						○	●									
	537	X-HEADS HFM	XHF580	●	●	●	●	●				○	○	○								
	542		XHF780	○	○	●	●					●	●	○								

	555	X-HEADS VHM	XVE540	●	●	●	●	●	●	●	●	○	○	○	●			●				○
	560		XVE510	●	●	●	●	●	○	○	○	○	○		●			●				○
	563-564		XVB510	●	●	●	●	●	○	○	○	○	○		●			●				○
	567		XVC506/509/512	●	●	●	●	●	○	○	○	○	○		●			●				○
	571		XVK310	●	●	●	●	●	●	●	●	○	○	○	●			●				○

● Prima scelta ○ Scelta alternativa

Chiavi di codifica

Frese in metallo duro integrale

R	JS	720	100	D	2	R050	.0	Z6	C	,	HXT
1	2	3	5	6	7	8	9	10	11		12

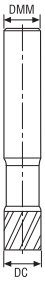
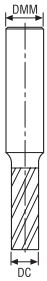
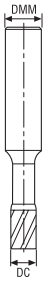
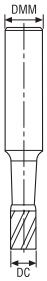
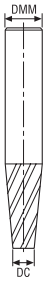
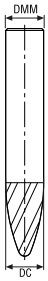
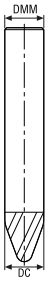
Teste X-Heads

R	XSE	550	E10	100	D	2	R050	Z4	A	,	SIRA
1	2	3	4	5	6	7	8	10	11		12

1. Tipo di prodotto	2. Gamma prodotti		3. Geometria
CAMPO VUOTO = Prodotto standard (da catalogo) R = Prodotto ripristinato (completamente) RK = Prodotto ripristinato (frontalmente)	J = JABRO® VHM JC = JABRO® Composites JD = JABRO® Diamond JH = JABRO® HSM/Tornado JHF = JABRO® HFM JHP = JABRO® HPM JM = JABRO® Mini JS = JABRO® SOLID²	JPD = JABRO® PCD JCO = JABRO® HSS-Co JCG = JABRO® Ceramic XS* = X-Head SOLID² XH* = X-Head HSM/Tornado XV* = X-Head VHM XHF = X-Head HFM	Combinazione di tre cifre per specificare la geometria di taglio. Esempio: 111, 950, 553, 514, ecc.

4. Dimensione filetto di connessione	5. Diametro
Questo dato indica la dimensione della connessione per la filettatura tra la testina e l'adattatore E10 = 10 mm E12 = 12 mm E16 = 16 mm E20 = 20 mm E25 = 25 mm	Metrico = numero a 3 cifre (in caso di 4 cifre – xx,xx mm) In pollici = un punto seguito da un numero a 3 cifre Esempio: (050 = metrico, 5 mm) / (.500 = in pollici, ½ pollice)

6. Forma utensile

(DC = DMM)		(DC < DMM)			(DC > DMM)
					
D	E	F	G	J	P
Forma					
					
N		X		T	

7. Lunghezza dello stelo

Cifra che dà un'indicazione della lunghezza della fresa rispetto ad altre frese con la stessa geometria di taglio.

9. Tipo di stelo

.0 = Cilindrico
.3 = Weldon
.5 = Whistle Notch
.9 = Safe-Lock

10. Numero di eliche

Questo dato indica il numero di eliche nell'utensile da taglio.
Esempio: PCEDC2 = 2 eliche, PCEDC6 = 6 eliche

11. Canali per adduzione del refrigerante

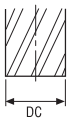
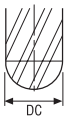
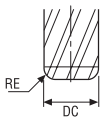
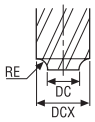
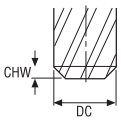
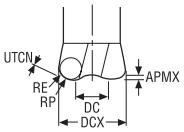
CAMPO VUOTO = Senza canali per refrigerante
A =Canale/i interno/i per adduzione refrigerante
C = Profilo rompitruciolo

12. Qualità

Codice a 4 caratteri che specifica il rivestimento della fresa.

MEGA =	MEGA	DURA =	DURA
MT =	MEGA-T	NXT =	NXT
M64 =	MEGA-64	HXT =	HXT
M64 T=	MEGA-64-T	STAX =	STAX
SIRA =	SIRON-A	TAN =	TAN
HEMI =	HEMI	M9 =	M9
DIA =	DIAMOND	AXT =	AXT

Descrizione

8. Geometria frontale					
Tagliente vivo	A testa sferica	Raggio di punta	Raggio concavo	Smusso	Elevato avanzamento
					
S	B	R...	K...	C	H

Raggio per frese con geometria frontale convessa e concava

000 = Per le frese in mm, la geometria frontale è indicata da un numero a tre cifre.
Dividendo questo valore per 100 si ottiene il valore in millimetri del raggio di punta.

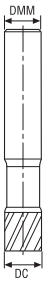
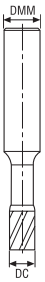
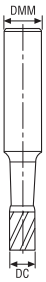
.000 = Per le frese in pollici, la geometria frontale è indicata da un punto, seguito da un numero a tre cifre.
Questo valore indica la dimensione del raggio di punta in *pollici* (per esempio R.100 indica un raggio di 0,100 *pollici*).

Chiavi di codifica

Attacchi X-Heads

X	E10	100	E	2	-	055	-	00	.0	S
1	2	3	4	5		6		7	8	9

1. Gamma prodotti	2. Dimensione filetto di connessione	3. Diametro dello stelo
X = stelo cilindrico X-Head	Questo dato indica la dimensione della connessione per la filettatura tra la testina e l'adattatore E10 = 10 mm E12 = 12 mm E16 = 16 mm E20 = 20 mm E25 = 25 mm	Metrico = numero di 3 cifre In pollici = un punto seguito da un numero a 3 cifre Esempio: (050 = metrico, 5 mm) / (.500 = in pollici, 1/2 pollice)

4. Forma utensile		
(DC = DMM)	(DC < DMM)	
		
E	G	J

5. Lunghezza dello stelo	6. Lunghezza totale
Cifra che indica la lunghezza della fresa rispetto ad altre frese con la stessa geometria di taglio.	Metrico = numero di 3 cifre In pollici = un codice di 3 cifre con un punto dopo la prima cifra Esempio: (055 = metrico, 55 mm) / (2.50 = in pollici, 2 1/2 pollici)

7. Angolo di conicità	8. Tipo di stelo	9. Tipo di materiale
Indica il semi-angolo di conicità del corpo. Esempio: (00 = 0°;0°; 05 = 5°; 10 = 10°)	.0 = Cilindrico .3 = Weldon .5 = Whistle Notch .9 = Safe-Lock	Indica i diversi tipi di steli disponibili. S = Acciaio DM = Densimate E = Metallo duro integrale

I vantaggi delle nostre soluzioni

La soluzione individuale: utensili personalizzati e modificati



Se i requisiti sono molto speciali, abbiamo la soluzione giusta con i nostri utensili individuali e personalizzati – soluzioni realizzate su misura in base alle vostre esigenze specifiche. Ciò consentirà di portare la produttività di lavorazione a un livello completamente nuovo.
Oltre alle soluzioni standard, la nostra offerta include:

Utensili personalizzati
Si tratta di geometrie modificate o di utensili progettati per soddisfare le esigenze specifiche dei clienti. Attraverso la nostra collaborazione totale con i clienti, siamo in grado di progettare utensili specifici che rispondano alle loro esigenze. Alcuni esempi:

- Strumenti modificati all'interno di una geometria standard
- MEP (Mechanized Edge Profiling)
- Pino
- Coda di rondine
- Testa sferica conica
- Fresa a condilo
- Utensili formati
- Barile

Utensili modificati
Seco offre soluzioni a consegna rapida per gli utensili standard che necessitano di modifiche
finalizzate a soddisfare requisiti specifici di natura dimensionale:

- Raggio (completo)/rinforzo frontale/smusso/concavo
- Codolo scaricato (diametro scarico codolo), inclusa la maggiore lunghezza
- Rivestimento (solo per frese non rivestite)
- Diametro ridotto
- Formatruciolo
- Aggiunta di Weldon / Safelock
- Canali adduzione refrigerante esterna

Il ripristino riduce i costi ed il magazzino utensili

I moderni utensili in metallo duro Seco offrono prestazioni notevoli utilizzando le migliori combinazioni di substrati in metallo duro e di rivestimenti con alta resistenza all'usura, geometria di taglio ottimizzata e preparazione del tagliente.

In ogni caso, pur buono che sia l'utensile, finirà per mostrare segni di usura sul tagliente. Controllando quest'usura e sostituendo tempestivamente l'utensile si permetterà allo stesso di essere ripristinato, riducendo così i costi. Inoltre, per ricondizionare gli utensili in metallo duro integrale utilizziamo la stessa tecnologia avanzata e la stessa cura che usiamo per la produzione di nuovi prodotti.

Benefici del ripristino

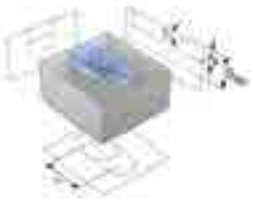
- I più elevati standard Seco con geometria originale Seco, preparazione del tagliente e rivestimento.
- Risparmi sui costi utensile grazie all'uso ripetuto della stessa fresa integrale.
- Il nostro "set di ricondizionamento" è facile da usare e gratuito ed include una bolla di consegna già pronta.
- Ritiro gratuito e sicuro il giorno successivo alla vostra chiamata a Seco.
- Una procedura semplice grazie al servizio di confezionamento, alla scatola ed alla bolla di consegna già pronta.
- Riconsegna tramite i canali Seco abituali.
- Trasporto e stoccaggio sicuri degli utensili ricondizionati grazie all'imballaggio in confezioni simili a quelle degli utensili nuovi.
- È inclusa anche una nuova etichetta.
- Per un ambiente più verde e più pulito. I processi Seco sono certificati secondo la norma ISO14001.
- La qualità è garantita, poiché tutti i processi sono certificati ISO9001.

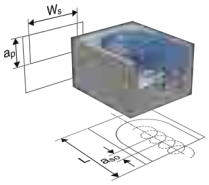
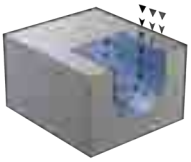
Operazioni base:

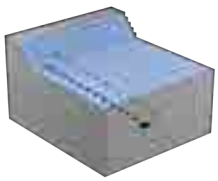
Spianatura:	**Scanalatura:**
Operazione in cui la fresa è impegnata con un arco di contatto inferiore a 180°. Impegno dell'utensile: Piccola a_p e grande a_e. 	Operazione in cui la fresa è completamente impegnata, a_e è uguale a DC ed a_p fino a 2xDC, a seconda della strategia scelta. 

Contornatura:	Copiatura:
Operazione in cui viene impegnato il fianco dell'utensile, a_p è grande mentre a_e è piccolo. 	Operazione in cui il raggio utensile è completamente impegnato, a_p ed a_e sono entrambi piccoli. 

Strategie di lavorazione avanzate:

Entrata in rampa:	**Interpolazione elicoidale:**
Apertura di una tasca sull'asse Z con un certo angolo. 	Apertura di una tasca attraverso un movimento circolare con l'utensile mentre è in rampa sull'asse Z. 

Fresatura trocoidale:	**Push-pull (spingi-tira):**
Apertura di una scanalatura attraverso una contornatura, con movimenti circolari parziali sugli assi X o Y. (si passa da scanalatura a contornatura). 	Lavorazione di una forma 3D in copiatura, contornatura invece di scanalatura, seguendo il profilo del pezzo. 

Penetrazione assiale:	Per piani paralleli:
Apertura di una scanalatura tramite movimento in Z. 	Lavorazione di una superficie mediante una piccola foratura o rampa in Z e quindi apertura della tasca con movimenti X e Y. 

Foratura:	**Sgrossatura avanzata / sgrossatura ottimizzata**
Realizzazione di un foro sull'asse Z. 	Percorsi utensile ottimizzati con arco di contatto costante per un'affidabile sgrossatura di forme sia semplici che complesse. Grandi profondità di taglio assiali (a_p) e piccole profondità di taglio radiali (a_e) combinate con alti avanzamenti al dente (f_z) e con alte velocità (V_c) per alta produttività. 

Definizioni, strategie di lavorazione:

Lavorazioni generiche:
Si tratta di strategie di lavorazione per uso generico. Il rapporto tra a_e e a_p può variare a seconda dell'operazione.
Caratteristiche dell'utensile: Gli utensili hanno lunghezze taglienti relativamente lunghe e diametro di nocciolo ridotto. Non sono richieste tolleranze particolarmente strette.
Caratteristiche della macchina: non sono richieste caratteristiche particolari.
Con la tecnologia CNC di base, non è possibile applicare metodi di programmazione particolarmente avanzati.
Si possono ottenere valori medi di asportazione Q (cm^3/min).
L'area di applicazione include piccoli lotti di produzione ed una vasta gamma di materiali.

Lavorazioni ad alte prestazioni:
Si tratta di una strategia di lavorazione con la quale si possono ottenere elevatissimi volumi di truciolo. Caratteristica di questa lavorazione è che il valore di a_e è uguale a DC ed a_p vale da una a una volta e mezzo DC a seconda del materiale da lavorare.
Con HPM (lavorazione ad alte prestazioni) si possono rimuovere elevati volumi di truciolo utilizzando parametri di taglio più alti rispetto alle lavorazioni generiche.
Caratteristiche dell'utensile: Formatrucioli principalmente sviluppati nell'elica dell'utensile, protezione placchetta con piccolo raggio di punta a 45°, vano truciolo speciale dolce e rivestito, con o senza attacco Weldon.
Caratteristiche della macchina: elevata stabilità, elevata potenza richiesta, controllo CNC, attacco rigido.
Le aree di applicazione sono: produzioni in serie dove è determinante il tempo per pezzo, singole lavorazioni dove è richiesta l'asportazione di elevati volumi di truciolo Q (cm^3/min).

Lavorazioni ad elevato avanzamento:
Si tratta di una strategia di lavorazione in cui si ottengono elevati avanzamenti con grandi impegni radiali (a_e) e con una bassa a_p.
Con HFM (lavorazione ad elevato avanzamento) si raggiunge un elevato tasso di rimozione del materiale e/o una finitura superficiale impiegando avanzamenti molto più elevati rispetto alla lavorazione generica.
Caratteristiche dell'utensile: taglienti frontali appositamente studiati, tagliente particolarmente corto e rivestimento.

Caratteristiche della macchina: buona stabilità, veloce controllo numerico CNC, elevati avanzamenti (v_f).
Il grande vantaggio di questa tecnologia è l'impiego molto facile, sicuro e facile da programmare in CAM. Utilizzando una strategia per piani paralleli, è relativamente semplice programmare forme complesse senza la necessità di avere particolare esperienza di programmazione.
L'area di applicazione è: acciai teneri e temprati, titanio ed acciaio inossidabile. È l'ideale per operazioni di semifinitura prima di impiegare lavorazioni ad alta velocità. Può essere applicata anche per lavorazioni di tasche profonde.

Micro lavorazioni:
È una strategia di lavorazione con la quale si impiegano utensili estremamente piccoli.
Caratteristiche dell'utensile: gamma di diametri da 0,1 a 2,0 mm, tagliente corto, vasta gamma di disimpegni radiali, elevata accuratezza, rivestimento.

Caratteristiche della macchina: elevata precisione ed elevato numero di giri mandrino, controllo CNC, controllo dilatazione termica.
L'area di applicazione è: esecuzione di scanalature, tasche, fori o incisioni su materiali differenti.

Lavorazioni ad elevata velocità:
Si tratta di una strategia di lavorazione in cui si combinano una piccola profondità di taglio radiale ed alte velocità di taglio e di avanzamento tavola.
A seconda del metodo si possono raggiungere elevate asportazioni e bassi valori di R_a.
Queste lavorazioni si distinguono per ridotti sforzi di taglio, minor calore accumulato sull'utensile e sul pezzo, ridotta formazione di bave ed elevata accuratezza dimensionale.

Con HSM (lavorazione ad alta velocità) si ottengono elevate asportazioni e/o una buona finitura superficiale con velocità di taglio più alte rispetto alle lavorazioni generiche.
Caratteristiche dell'utensile: stabilità (grande sezione di nocciolo e tagliente corto), vano evacuazione truciolo ottimizzato, rivestimento.

Caratteristiche della macchina: veloce controllo numerico CNC, elevato numero di giri del mandrino, elevati avanzamenti tavola.
L'area di applicazione è: settore stampi con operazioni di semifinitura e finitura di acciai temprati (48-62 HRc) in tempi ridotti.
Questa tecnica può essere applicata con molti altri materiali usando il giusto utensile e la corretta strategia di lavoro.

Sgrossatura avanzata / sgrossatura ottimizzata:
Percorsi utensile ottimizzati con arco di contatto costante per un'affidabile sgrossatura di forme sia semplici che complesse. Grandi profondità di taglio assiali (ap) e piccole profondità di taglio radiali (ae) combinate con elevati avanzamenti al dente (fz) e con alte velocità di taglio (Vc) per alta produttività.

Queste tecnologie di sgrossatura basate su CAM, o fresatura dinamica, hanno come base l'arco di contatto dell'utensile ed il volume medio di truciolo asportato.

Quando si riduce l'arco di contatto, si riduce anche la generazione di calore. Al diminuire della profondità radiale, diminuisce anche l'arco di contatto. Un contatto più piccolo significa meno attrito e, di conseguenza, meno calore tra i taglienti dell'utensile ed il componente in lavoro. Queste temperature di lavoro più basse, alla fine, consentono velocità di taglio superiori e tempi ciclo inferiori.

Spiegazione della sgrossatura avanzata

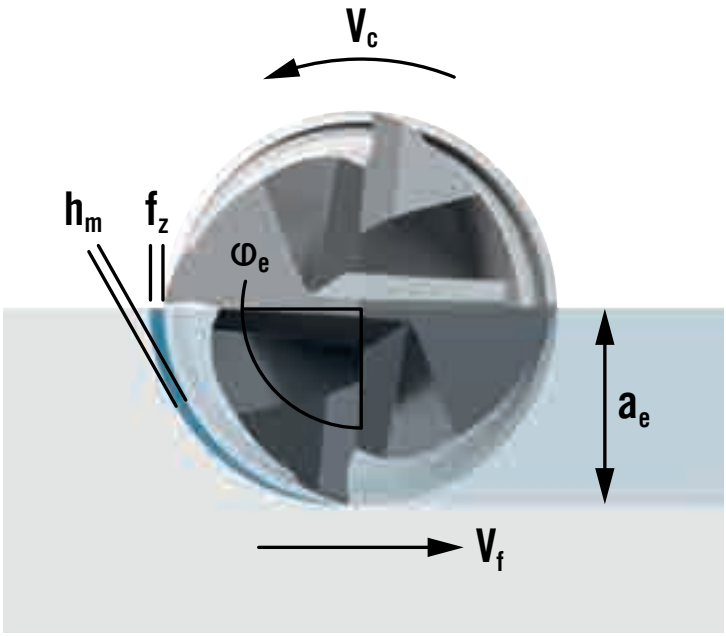
Sgrossatura avanzata, che cosa significa?

I pacchetti CAM di oggi offrono strategie di lavorazione specifiche per raggi sia interni che esterni, dove il cambiamento degli archi di contatto è comune, utilizzando strategie tradizionali. Questi pacchetti software applicano automaticamente avanzamenti differenti per controllare l'arco di contatto e mantenere costante il volume di truciolo asportato.
Queste tecnologie di sgrossatura basate su CAM, o sgrossatura avanzata, si concentrano sull'arco di contatto dell'utensile da taglio e sul volume medio di truciolo asportato. Quando si riduce l'arco di contatto, si riduce anche la generazione di calore. Al diminuire della profondità radiale, diminuisce anche l'arco di contatto. Un contatto più piccolo significa meno attrito e, di conseguenza, meno calore tra i taglienti dell'utensile ed il componente in lavoro. Queste temperature di lavoro più basse, alla fine, consentono velocità di taglio superiori e tempi ciclo inferiori. Inoltre, la forza di taglio risultante è inferiore e consente la programmazione di APMXS o profondità di taglio elevati.

Nella sgrossatura avanzata, per mantenere costante l'arco di contatto, i pacchetti CAM applicano strategie di lavorazione trocoidale quando si è in un raggio.

Quando si utilizza una strategia di sgrossatura ottimizzata che mantenga un arco di contatto costante, il raggio della fresa può essere uguale al raggio interno del componente senza rischi di sovraccarico della fresa. Questa caratteristica consente ai nostri utensili per la sgrossatura avanzata (JS554-3C, JS564, JS656, JS754, JS755 e JS720) di effettuare maggiori asportazioni in sgrossatura e consente di ridurre l'asportazione da effettuare durante la finitura, con una conseguente velocizzazione dei tempi di lavorazione e una durata utensile prolungata. Inoltre, anche se l'asportazione rimanente è costante, l'utensile di finitura può generare una migliore qualità della superficie finale e, allo stesso tempo, una maggiore durata utensile.

Impatto dell'arco di contatto sulla velocità di taglio e sull'avanzamento al dente



I vantaggi dei nostri prodotti

Velocità rivoluzionarie nella lavorazione delle superleghe con le frese integrali JABRO® Ceramic



Le ceramiche SiAlON, le geometrie ad alta resistenza ed un tagliente rinforzato sono alcune delle caratteristiche principali di questi utensili altamente ottimizzati e consentono l'utilizzo completo di macchine utensili ad alta velocità e ad alte prestazioni. Gli utensili possono funzionare a velocità di taglio fino a 1200 m/min e possono offrire un notevole aumento della produttività rispetto alle soluzioni in metallo duro integrale standard.

Poiché sono necessarie temperature elevate, è necessaria anche una quantità significativa di giri al minuto per raggiungere un valore vc elevato. Le alte temperature sono necessarie per raggiungere un livello in cui l'HRSA si ammorbidisce (850c +). Con questi utensili, è possibile applicare più strategie a condizione che venga massimizzato un taglio costante e un contatto costante con il pezzo.

L'utensile è progettato per contornatura, fresatura a spallamento, fresatura ad elevato avanzamento e sgrossatura avanzata! Queste lavorazioni sono tutte possibili. Per mantenere l'elevata temperatura di taglio nella zona di taglio, il refrigerante utilizzato è l'aria compressa. Poiché l'utensile funziona a velocità elevate, il run-out è altrettanto importante.

Gli utensili JABRO®Ceramic sono disponibili a pagina 294.

Semplificazione delle lavorazioni di foratura di materiali ibridi aerospaziali con la geometria "due in uno"

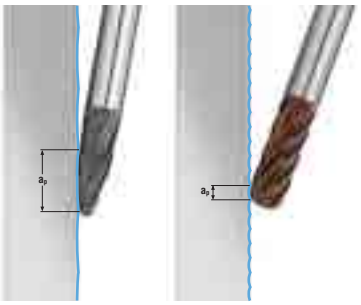


JC899 dispone di una soluzione brevettata con geometria doppia "due in uno", progettata per la lavorazione di combinazioni ibride di materiali stratificati come CFRP-Ti e CFRP-Alu. Grazie alla geometria di taglio destra con elica sinistrorsa, questo utensile impedisce alla delaminazione, allo strappo delle fibre e ai segni del truciolo di danneggiare la superficie del pezzo (in quanto i trucioli vengono spinti verso il basso fuori dal foro). Di conseguenza, il finitore con geometria di taglio destra STAX con elica sinistrorsa JC899 offre una perfetta finitura superficiale e previene l'inquinamento da trucioli tra i due strati.

Ciò significa che la post-lavorazione, la destratificazione, la pulizia, la sbavatura e la ristratificazione non sono più necessarie. Questo consente di aumentare l'efficienza dei processi fino al 200-300%, garantendo una durata utensile da tre a sei volte superiore rispetto agli alesatori convenzionali.
Allo stesso tempo, il processo di foratura viene sostituito applicando lo sgrossatore a elevato avanzamento JC898. L'accelerazione per interpolazione elicoidale dell'utensile consente a JC899 di lavorare in condizioni di asportazione continua, ottimizzando la qualità dei risultati e riducendo al minimo la correlazione nelle dimensioni e nella tolleranza dei fori.

Gli utensili JABRO® JC898/JC899 sono disponibili alle pagine 454 - 456.

Usare incrementi di passata più elevati per una maggiore produttività in finitura



Per le operazioni di finitura più veloci e affidabili, i nuovi utensili a barile utilizzano un'innovativa geometria "a cono" o "a goccia" per consentire grandi incrementi di profondità di passata. Ciò è possibile grazie all'uso di sistemi CAD/CAM avanzati o di nuovi plug-in creati per l'uso di questi utensili. Utilizzando il movimento della macchina a 5 assi, il profilo di taglio dell'utensile può rimanere sempre impegnato con la superficie del pezzo con l'angolo corretto.
Oltre alle nostre forme standard a barile, Seco può anche offrire tutti i tipi di geometria a botte come prodotti personalizzati, come le forme a lente, garantendo sempre l'accesso agli utensili ideali per le diverse esigenze di produzione di pezzi.

Eliminazione dei rischi nelle microlavorazioni di fresatura



Ottenete accuratezza, precisione e un'elevata qualità della finitura superficiale fin dall'inizio della lavorazione di superfici piccole, con dimensioni micro, grazie alla gamma di frese integrali JABRO®. Le nuove gamme di prodotti SECO Mini garantiscono una maggiore durata utensile, stabilità e tranquillità per le lavorazioni in cui è generalmente impossibile vedere effettivamente il pezzo e l'utensile da taglio mentre lavorano.

Le geometrie di precisione, virtualmente esenti da errori di run-out, i rivestimenti avanzati e le rigide tolleranze del raggio sono alla base dell'incredibile durata e dell'affidabilità delle gamme Mini. È fondamentale applicare questi utensili in condizioni adatte, dove i vantaggi possono essere massimizzati. Ridurre al minimo il run-out dell'utensile e il portautensile è fondamentale.
Anche il programma CAM può essere ottimizzato con l'ottimizzatore di avanzamento SECO JABRO® che calcola i giri al minuto e la velocità di avanzamento (vf) ideali per ogni applicazione. L'utensile contribuisce così ad eliminare problemi imprevisti durante la sgrossatura, la pre-finitura e la finitura nelle microlavorazioni di fresatura.

Una panoramica degli utensili ABRO®Mini è disponibile a pagina 10.

Finitore ad elica lunga JS522



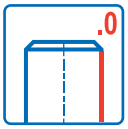
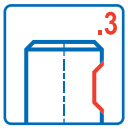
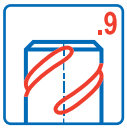
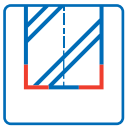
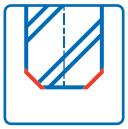
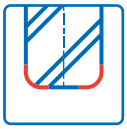
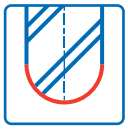
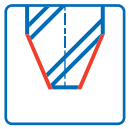
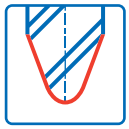
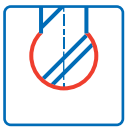
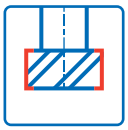
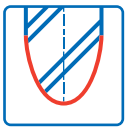
La fresa di finitura ad elica lunga JS522 è in grado di soddisfare i severi requisiti di perpendicolarità dell'industria aerospaziale e garantisce un'ottima finitura superficiale, un'elevata asportazione e lavorazioni più efficienti.

Con una lunghezza di taglio di 5*Dc, una sezione del nocciolo maggiorata e una conicità leggermente negativa per compensare la flessione, l'utensile JS522 è progettato appositamente per la lavorazione di spallamenti alti in operazioni di finitura a singola passata. Questa passata singola consente di risparmiare tempo (fino all'80%) ma, soprattutto, garantisce anche una qualità istantanea. Questo utensile viene spesso utilizzato nelle aree di produzione di massa.

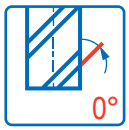
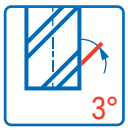
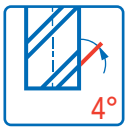
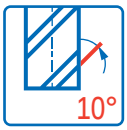
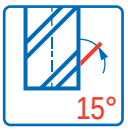
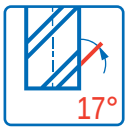
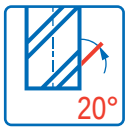
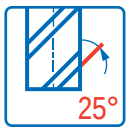
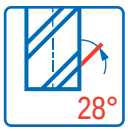
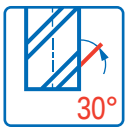
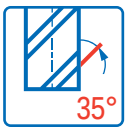
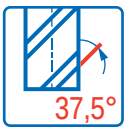
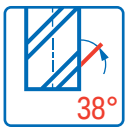
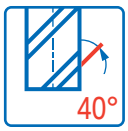
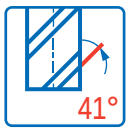
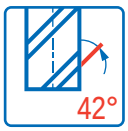
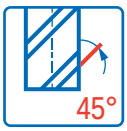
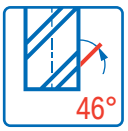
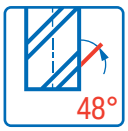
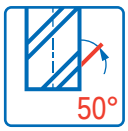
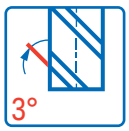
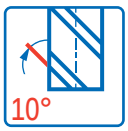
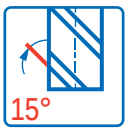
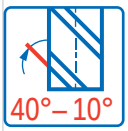
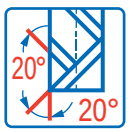
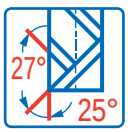
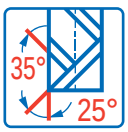
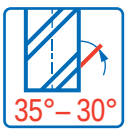
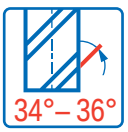
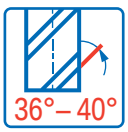
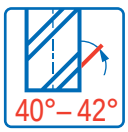
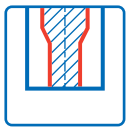
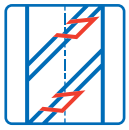
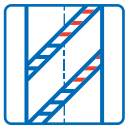
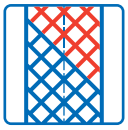
Una volta posizionato e ottimizzato, si è dimostrato la soluzione migliore in termini di risparmio economico in molteplici applicazioni.

Gli utensili JABRO® JS522 sono disponibili alla pagina 114.

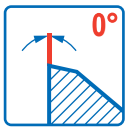
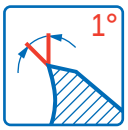
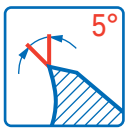
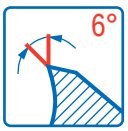
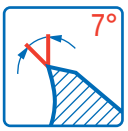
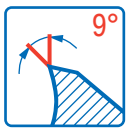
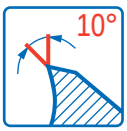
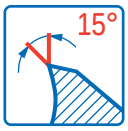
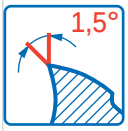
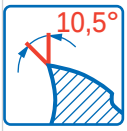
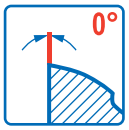
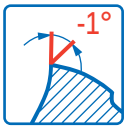
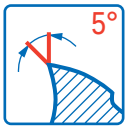
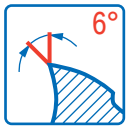
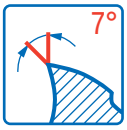
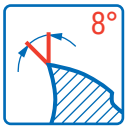
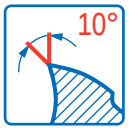
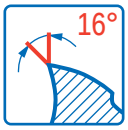
Simboli chiave

 **Tagliente al centro** PCEDC 1	 **Tagliente al centro PCEDC 2**	 **No tagliente al centro PCEDC 2**	 **Tagliente al centro** PCEDC 3	 **No tagliente al centro** PCEDC 3	 **Tagliente al centro** PCEDC 4
 **No tagliente al centro** PCEDC 4	 **Tagliente al centro PCEDC 5**	 **No tagliente al centro PCEDC 5**	 **Tagliente al centro** PCEDC 6	 **No tagliente al centro** PCEDC 6	 **No tagliente al centro** PCEDC 7
 **No tagliente al centro** PCEDC 8	 **No tagliente al centro** PCEDC 9				
 **Codolo cilindrico**	 **Attacco Weldon**	 **Attacco Safelock**			
 **Spigolo vivo**	 Smusso	 **Raggio di punta**	 **A testa sferica**	 **Spigolo vivo conico**	 **Frese sferico-coniche**
 **Fresa 250°**	 Frese a T	 **A barile**			

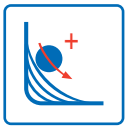
Simboli chiave

 Angolo dell'elica 0°	 Angolo dell'elica 3°	 Angolo dell'elica 4°	 Angolo dell'elica 10°	 Angolo dell'elica 15°	 Angolo dell'elica 17°	 Angolo dell'elica 20°
 Angolo dell'elica 25°	 Angolo dell'elica 28°	 Angolo dell'elica 30°	 Angolo dell'elica 35°	 Angolo dell'elica 37,5°	 Angolo dell'elica 38°	 Angolo dell'elica 40°
 Angolo dell'elica 41°	 Angolo dell'elica 42°	 Angolo dell'elica 44°	 Angolo dell'elica 45°	 Angolo dell'elica 46°	 Angolo dell'elica 48°	 Angolo dell'elica 50°
 Angolo dell'elica Sinistro 3°	 Angolo dell'elica Sinistro 10°	 Angolo dell'elica Sinistro 15°				 Doppia elica sinistra 40° - 10°
 Doppia elica 20° - 20°	 Doppia elica 27° - 25°	 Doppia elica 35° - 25°	 Doppia elica 35° - 30°	 Doppia elica 34° - 36°	 Doppia elica 36° - 40°	 Doppia elica 40° - 42°
 Doppia anima	 Anima conica					
 Rompitruciolo	 Profilo di sgrossatura	 Geometria di sgrossatura				

Simboli chiave

 Angolo di taglio 0° Rinforzo angolare	 Angolo di taglio 1° Rinforzo angolare	 Angolo di taglio -1° Rinforzo angolare	 Angolo di taglio 2° Rinforzo angolare	 Angolo di taglio 3° Rinforzo angolare	 Angolo di taglio 4° Rinforzo angolare	 Angolo di taglio 4-6° Rinforzo angolare
 Angolo di taglio 5° Rinforzo angolare	 Angolo di taglio 6° Rinforzo angolare	 Angolo di taglio 7° Rinforzo angolare	 Angolo di taglio 8° Rinforzo angolare	 Angolo di taglio 9° Rinforzo angolare	 Angolo di taglio 10° Rinforzo angolare	 Angolo di taglio 11° Rinforzo angolare
 Angolo di taglio 12° Rinforzo angolare	 Angolo di taglio -12° Rinforzo angolare	 Angolo di taglio 14° Rinforzo angolare	 Angolo di taglio 15° Rinforzo angolare	 Angolo di taglio 16° Rinforzo angolare	 Angolo di taglio 18° Rinforzo angolare	 Angolo di taglio 20° Rinforzo angolare
 Angolo di taglio -24° Rinforzo angolare				 Angolo di taglio 1,5° Rinforzo radiale	 Angolo di taglio 10,5° Rinforzo radiale	 Angolo di taglio 13° Rinforzo radiale
 Angolo di taglio 0° Rinforzo radiale	 Angolo di taglio -1° Rinforzo radiale	 Angolo di taglio 3° Rinforzo radiale	 Angolo di taglio 5° Rinforzo radiale	 Angolo di taglio 6° Rinforzo radiale	 Angolo di taglio 7° Rinforzo radiale	 Angolo di taglio 8° Rinforzo radiale
 Angolo di taglio 10° Rinforzo radiale	 Angolo di taglio 11° Rinforzo radiale	 Angolo di taglio 15° Rinforzo radiale	 Angolo di taglio 16° Rinforzo radiale	 Angolo di taglio 20° Rinforzo radiale	 Angolo di taglio 7-11° Rinforzo radiale	
 ICC dritto	 ICC e Y					
Radiale	Radiale/Entrata in rampa	Radiale/Entrata in rampa/ Penetrazione assiale				

Simboli chiave

 Diamond	 Dura	 Hemi	 **HSCO**	 HXT
 **Mega**	 **Mega-T**	 **Mega-64**	 **Mega-64-T**	 NXT
 Stax	 **SIRA**	 **TAN**	 **AXT**	 **Ceramica**
 PCD	 M9			
 Riaffilatura possibile	 Sgrossatura avanzata			

Attributi di fresatura integrale e X-Heads

Caratteristiche	Spiegazione
AP1	Profondità di taglio massima
APMXS	Profondità di taglio massima in direzione radiale
BHTA	Conicità
CA	Angolo conicità
CHW	Larghezza smusso frontale
CSP	Proprietà di alimentazione del refrigerante
CZCMS	Codice dimensione connessione lato macchina
CZCWS	Codice dimensione connessione lato pezzo in lavorazione
DC	Diametro di taglio
DCSFMS	Diametro superficie di contatto lato macchina
DCSFWS	Diametro superficie di contatto lato pezzo in lavorazione
DCX	Diametro di taglio massimo
DMM	Diametro stelo
DN	Diametro collo
FCEDC	Numero taglienti frontali
ICC	Adduzione interna refrigerante
L	Lunghezza del tagliente
L2	Lunghezza tagliente 2
LF	Lunghezza funzionale
LN	Lunghezza scarico
LN2	Lunghezza scarico 2
LSCN	Minima lunghezza presa
NA	Angolo scarico
OAL	Lunghezza complessiva
PCEDC	Numero taglienti periferici
PRFA/2	Angolo profilo diviso per due
PRFRAD1	Raggio profilo 1
PRFRAD2	Raggio profilo 2
PRFRAD3	Raggio profilo 3
PSIR	Angolo attacco utensile
RE	Raggio di punta
RE2	Raggio di punta 2
RP	Raggio di programmazione
SA	Angolo sfera
SIG	Angolo punta
SW	Dimensione chiave
TQ	Coppia
TQN	Coppia minima
TQX	Coppia massima
UTCN	Sezione non asportata

Caratteristiche Minimaster

Caratteristiche	Spiegazione
APMXE	Profondità di taglio massima in direzione assiale
APMXS	Profondità di taglio massima in direzione radiale
AZ	Profondità di penetrazione massima
BEC	Angolo di smusso estremità posteriore
BHTA	Conicità
CCER	Raggio tagliente curvo
Cmax	Diametro massimo del foro in interpolazione elicoidale
Cmin	Diametro minimo del foro in interpolazione elicoidale
DC	Diametro di taglio
DCSFMS	Diametro superficie di contatto lato macchina
DCSFWS	Diametro superficie di contatto lato utensile
DCX	Diametro di taglio massimo
DMM	Diametro stelo
DN	Diametro collo
FCEDC	Numero taglienti frontali
FHA	Angolo dell'elica
KAPRS	Angolo di attacco radiale
LE	Lunghezza effettiva del tagliente
LF	Lunghezza funzionale
LPR	Lunghezza sporgenza
OAL	Lunghezza complessiva
RA	Angolo di spoglia
RE	Raggio di punta
RMPX	Massimo angolo di rampa
RP	Raggio di programmazione
RPMX	Massima velocità di rotazione
SA	Angolo sfera
SIG	Angolo punta
UTCN	Sezione non asportata
ZEFP	Numero di denti effettivo



UNIVERSALE

Seco offre una gamma completa di frese a spallamento retto in metallo duro integrale ad alte prestazioni, frese a testa sferica e frese integrali per finitura che aumentano la produttività e prolungano la durata. Questa gamma copre prodotti universali e frese integrali ottimizzate per materiali da lavorare specifici.

I prodotti universali offrono la massima flessibilità di lavorazione con un eccellente rapporto prezzo/prestazioni.

- JSE512, JSE513, JSE514, JS553, JS554, JS564, JS565 e JS520 con tipo di smusso a 45°.
- JS522, JS553, JS554, JH910, JH930, JHF980, J36, V31, JME542, JME562 e JME564 per tipo con raggio.
- JS506, JS509, HK, HKM e J29 per tipo conico.
- JSB512, JS532, JS533, JS534, JHB970, JMB542, JMB562 e JMB563 per tipo a testa sferica.

Selezione utensile universale

						
Nome		JSE512	JSE513	JSE514	JS553	JS554
Pag.		37	41	47	57	77
Famiglia		SOLID²	SOLID²	SOLID²	SOLID²	SOLID²
Tipo di fresa						
Attacco	Cilindrico	■	■	■	■	■
	Weldon	■	■	■	■	■
Numero di eliche		2	2	4	3	4
Adduz. refrig. interna						
	Metrico	2-12	2-20	2-25	2-25	3-25
	Pollici				1/8-1	1/4-1
Lunghezze disponibili		2	2,3	2,3	1,2,3	1,2,3
Operazione						
						
						
SMG						
P1-8		●	●	●	●	●
P11-12		○	○	○	●	●
M1-3		●	●	●	●	●
M4-5		○	○	○	●	●
K1-7		●	●	●	●	●
S1-3		○	○	○	●	●
S11-13		○	○	○	●	●
H3 H5 H8 H11 H12 H21 H31		○	○	○	●	●
N1		○	○	○	●	●
N2-3		○	○	○	●	●
N11		○	○	○	●	●
TS1		○	○	○	●	●
TP1		○	○	○	●	●
GR		○	○	○	○	○

■ Prodotto standard ☐ **Weldon disponibile, tempo di consegna 3 giorni.**
● **Prima scelta** ○ **Scelta alternativa**
***Anche JS554 3C disponibile. Può essere applicata nella sgrossatura avanzata.**

Selezione utensile universale

						
Nome		JS564	JS565	JS520	JS522	JSB512
Pag.		102	106	110	114	117
Famiglia		SOLID²	SOLID²	SOLID²	SOLID²	SOLID²
Tipo di fresa						
Attacco	Cilindrico	■	■	■	■	■
	Weldon	■	■	□		
Numero di eliche		4	5	5,6,8	2	2
Adduz. refrig. interna						
	Metrico	3-20	4-20	4-25	6-32	2-12
	Pollici					
Lunghezze disponibili		2,3	2,3	2,3	4	2
Operazione						
						
						
SMG						
P1-8		●	●	●	●	●
P11-12		○	○	○	●	○
M1-3		●	●	○	●	●
M4-5		●	●	○	●	○
K1-7		●	●	●	●	●
S1-3		●	●	○	○	○
S11-13		●	●	●	●	○
H3 H5 H8 H11 H12 H21 H31		●	●	○		○
N1		●	●	●	●	○
N2-3		●	●	●	●	○
N11		●	●	●	●	○
TS1				●	●	○
TP1				●	●	○
GR				○	○	○

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

Selezione utensile universale

						
Nome		JS532	JS533	JS534	JS506	JS509
Pag.		119	123	127	131	135
Famiglia		SOLID²	SOLID²	SOLID²	SOLID²	SOLID²
Tipo di fresa						
Attacco	Cilindrico	■	■	■	■	■
	Weldon	□	■	■	■	■
Numero di eliche		2	3	4	3-4	3-4
Adduz. refrig. interna						
	Metrico	1-20	1-20	2-20	3-12	3-12
	Pollici					
Lunghezze disponibili		1,2,3	1,2	1,2,3	2	2
Operazione						
						
SMG						
P1-8		●	●	●	●	●
P11-12		○	○	○	○	○
M1-3		●	●	●	●	●
M4-5		●	●	●	●	●
K1-7		●	●	●	●	●
S1-3		○	○	○	○	○
S11-13		●	●	●	●	●
H3 H5 H8 H11 H12 H21 H31					●	●
N1		●	●	●	●	●
N2-3		●	●	●	●	●
N11		●	●	●	●	●
TS1		●	●	●	●	●
TP1		●	●	●	●	●
GR		○	○	○	○	○

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

Selezione utensile universale

					
Nome		JH910	JH930	JHB970	JHF980
Pag.		139	143, 392	145, 206	147
Famiglia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HFM
Tipo di fresa					
Attacco	Cilindrico	■	■	■	■
	Weldon				
Numero di eliche		3	5-6, 8	2	2,3,4,5
Adduz. refrig. interna					
	Metrico	2-20	6-20	2-16	1-12
	Pollici				
Lunghezze disponibili		2,3,4	2	1,2,3	1,2,3,4
Operazione					
					
					
SMG					
P1-8		●	●	●	●
P11-12		○	○	○	○
M1-3		●		●	●
M4-5		●		●	●
K1-7		●	●		●
S1-3		●	●	●	●
S11-13		●	●	●	●
H3 H5 H8 H11 H12 H21 H31			●		○
N1					
N2-3					
N11					
TS1					
TP1		●			
GR		●			

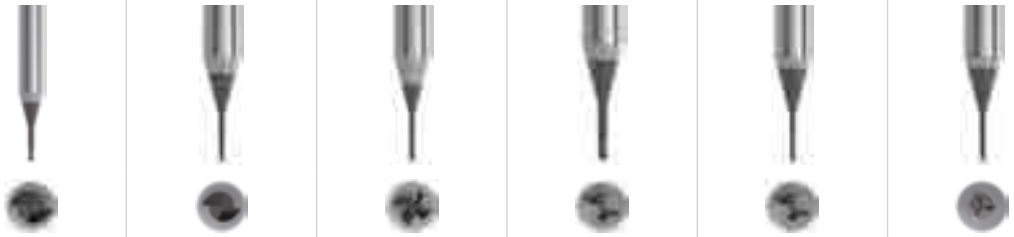
■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

Selezione utensile universale

					
Nome		J29	J36	HK/HKM	V31
Pag.		151	154	157	168
Famiglia		VHM	VHM	VHM	VHM
Tipo di fresa					
Attacco	Cilindrico	■	■	■	■
	Weldon				
Numero di eliche		1	3	2,3,4	4
Adduz. refrig. interna					
	Metrico	0,2-6	2-20	1-10	6-28
	Pollici				
Lunghezze disponibili		2	2	2	2
Operazione					
					
					
SMG					
P1-8		●	○	●	●
P11-12		●	●		○
M1-3		●	○	●	●
M4-5		●	○	●	○
K1-7		●	○	●	●
S1-3		●	○	●	●
S11-13		●	○	●	●
H3 H5 H8 H11 H12 H21 H31		○		●	●
N1		●	○	●	●
N2-3		●	●	○	●
N11		●	●		●
TS1		●	○	●	●
TP1		●	○	●	●
GR		●			●

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

Selezione utensile universale

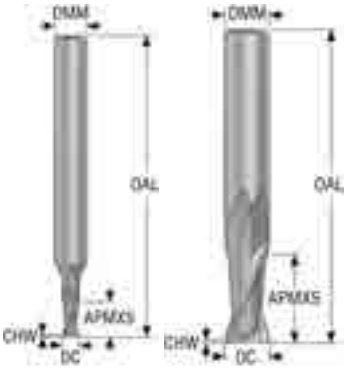


		JME542	JME562	JME564	JMB542	JMB562	JMB563
Nome							
Pag.		171	174	178	181	184	188
Famiglia		MINI	MINI	MINI	MINI	MINI	MINI
Tipo di fresa							
Attacco	Cilindrico	■	■	■	■	■	■
	Weldon						
Numero di eliche		2	2	4	2	2	3
Adduz. refrig. interna							
	Metrico	2-20	0,5-3,0	0,5-3,0	0,2-3,0	0,5-3,0	1,0-3,0
	Pollici						
Lunghezze disponibili		1,3,4,5,6	2,4,5,6,7	2,4	1,3,4,5,6	1,2,3,4,5,6	2,4
Operazione							
							
							
SMG							
P1-8		●	●	●	●	●	●
P11-12		●	●	●	●	●	●
M1-3		●	●	●	●	●	●
M4-5		●	●	●	●	●	●
K1-7							
S1-3							
S11-13		●	●	●	●	●	●
H3 H5 H8 H11 H12 H21 H31							
N1		○	○	○	○	○	○
N2-3		○	○	○	○	○	○
N11		○	○	○	○	○	○
TS1							
TP1							
GR		○	○	○	○	○	○

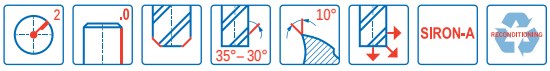
■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

JSE512

Uso generico – Universale – Spallamento – 2 Eliche – Cilindrico – smusso



F D





- Tolleranze:
- DMM=h5
- DC=e8
- Riaffilatura possibile se DC è ≥Ø10

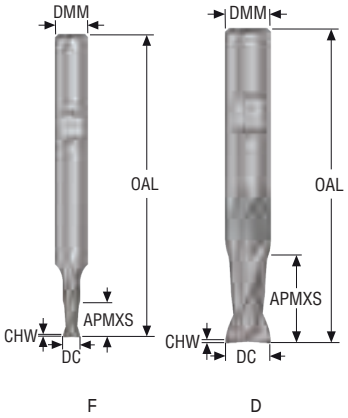
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm		
JSE512021F2C.0Z2	SIRA	10052986	2	F	2,0	3,0	4,0	50,0	0,02	2	■
JSE512020F2C.0Z2	SIRA	10052990	2	F	2,0	6,0	4,0	57,0	0,02	2	■
JSE512030D2C.0Z2	SIRA	10052987	2	D	3,0	3,0	6,0	50,0	0,03	2	■
JSE512030F2C.0Z2	SIRA	10052991	2	F	3,0	6,0	6,0	57,0	0,03	2	■
JSE512040D2C.0Z2	SIRA	10052988	2	D	4,0	4,0	8,0	50,0	0,04	2	■
JSE512040F2C.0Z2	SIRA	10052992	2	F	4,0	6,0	8,0	57,0	0,04	2	■
JSE512050D2C.0Z2	SIRA	10052989	2	D	5,0	5,0	10,0	50,0	0,05	2	■
JSE512060D2C.0Z2	SIRA	10052993	2	D	6,0	6,0	12,0	57,0	0,06	2	■
JSE512080D2C.0Z2	SIRA	10052994	2	D	8,0	8,0	16,0	63,0	0,08	2	■
JSE512100D2C.0Z2	SIRA	10052995	2	D	10,0	10,0	20,0	72,0	0,1	2	■
JSE512120D2C.0Z2	SIRA	10052996	2	D	12,0	12,0	24,0	83,0	0,12	2	■

■ Prodotto standard.

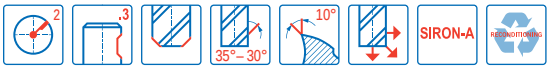
JSE512

Uso generico – Universale – Spallamento – 2 Eliche – Weldon – smusso





- Tolleranze:
- DMM=h5
- DC=e8
- Riaffilatura possibile se DC è ≥Ø10



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JSE512020F2C.3Z2	SIRA	10053113	2	F	2,0	6,0	4,0	57,0	0,02	2	■
JSE512030F2C.3Z2	SIRA	10053114	2	F	3,0	6,0	6,0	57,0	0,03	2	■
JSE512040F2C.3Z2	SIRA	10053115	2	F	4,0	6,0	8,0	57,0	0,04	2	■
JSE512060D2C.3Z2	SIRA	10053116	2	D	6,0	6,0	12,0	57,0	0,06	2	■
JSE512080D2C.3Z2	SIRA	10053117	2	D	8,0	8,0	16,0	63,0	0,08	2	■
JSE512100D2C.3Z2	SIRA	10053118	2	D	10,0	10,0	20,0	72,0	0,1	2	■
JSE512120D2C.3Z2	SIRA	10053119	2	D	12,0	12,0	24,0	83,0	0,12	2	■

■ Prodotto standard.

Parametri di taglio – JSE512 Contornatura

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P2	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P3	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P4	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P5	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P6	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P7	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P8	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P11	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
P12	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M1	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M2	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M3	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M4	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M5	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
K1	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K2	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K3	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K4	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K5	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K6	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K7	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
N1	E/M/A	0.200 *0,200*	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	500 (380 — 630) *1650 (1300 — 2000)*
N11	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	365 (250 — 480) *1200 (830 — 1500)*
S11	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
S12	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
S13	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JSE512 Scanalatura

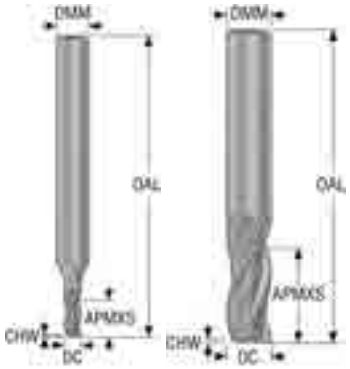
SMG		a_p/DC	f_z								v_c
			2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P2	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P3	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P4	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P5	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P6	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P7	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P8	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P11	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (51 — 100) *230 (170 — 320)*
P12	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M1	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M2	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M3	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M4	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M5	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
K1	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K2	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K3	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K4	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K5	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K6	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K7	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
N1	E/M/A	0.40 *0,40*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	400 (300 — 500) *1300 (990 — 1600)*
N11	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	300 (200 — 390) *980 (660 — 1200)*
S11	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
S12	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
S13	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

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F D



- Tolleranze:
- DMM=h5
- DC=e8
- Riaffilatura possibile se DC è ≥Ø10

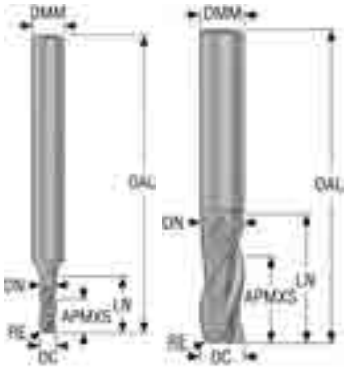
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm		
JSE513020F2C.0Z3	SIRA	10053000	2	F	2,0	6,0	4,0	57,0	0,02	3	■
JSE513025F2C.0Z3	SIRA	10053001	2	F	2,5	6,0	5,0	57,0	0,025	3	■
JSE513030D2C.0Z3	SIRA	10052998	2	D	3,0	3,0	6,0	50,0	0,03	3	■
JSE513030F2C.0Z3	SIRA	10053002	2	F	3,0	6,0	6,0	57,0	0,03	3	■
JSE513040D2C.0Z3	SIRA	10052999	2	D	4,0	4,0	8,0	50,0	0,04	3	■
JSE513040F2C.0Z3	SIRA	10053003	2	F	4,0	6,0	8,0	57,0	0,04	3	■
JSE513050F2C.0Z3	SIRA	10053004	2	F	5,0	6,0	10,0	57,0	0,05	3	■
JSE513060D2C.0Z3	SIRA	10053005	2	D	6,0	6,0	12,0	57,0	0,06	3	■
JSE513070F2C.0Z3	SIRA	10053006	2	F	7,0	8,0	14,0	63,0	0,07	3	■
JSE513080D2C.0Z3	SIRA	10053007	2	D	8,0	8,0	16,0	63,0	0,08	3	■
JSE513090F2C.0Z3	SIRA	10053008	2	F	9,0	10,0	18,0	72,0	0,09	3	■
JSE513100D2C.0Z3	SIRA	10053009	2	D	10,0	10,0	20,0	72,0	0,1	3	■
JSE513110F2C.0Z3	SIRA	10053010	2	F	11,0	12,0	22,0	83,0	0,11	3	■
JSE513120D2C.0Z3	SIRA	10053011	2	D	12,0	12,0	24,0	83,0	0,12	3	■
JSE513140D2C.0Z3	SIRA	10053012	2	D	14,0	14,0	28,0	80,0	0,14	3	■
JSE513160D2C.0Z3	SIRA	10053013	2	D	16,0	16,0	32,0	92,0	0,16	3	■
JSE513180D2C.0Z3	SIRA	10053014	2	D	18,0	18,0	35,0	100,0	0,18	3	■
JSE513200D2C.0Z3	SIRA	10053015	2	D	20,0	20,0	35,0	104,0	0,2	3	■
JSE513030F3C.0Z3	SIRA	10053038	3	F	3,0	6,0	10,0	57,0	0,03	3	■
JSE513040F3C.0Z3	SIRA	10053039	3	F	4,0	6,0	14,0	57,0	0,04	3	■
JSE513050F3C.0Z3	SIRA	10053040	3	F	5,0	6,0	18,0	57,0	0,05	3	■
JSE513060D3C.0Z3	SIRA	10053046	3	D	6,0	6,0	20,0	63,0	0,06	3	■
JSE513080D3C.0Z3	SIRA	10053047	3	D	8,0	8,0	28,0	80,0	0,08	3	■
JSE513100D3C.0Z3	SIRA	10053048	3	D	10,0	10,0	35,0	89,0	0,1	3	■
JSE513120D3C.0Z3	SIRA	10053049	3	D	12,0	12,0	42,0	100,0	0,12	3	■
JSE513160D3C.0Z3	SIRA	10053050	3	D	16,0	16,0	50,0	115,0	0,16	3	■
JSE513200D3C.0Z3	SIRA	10053052	3	D	20,0	20,0	60,0	125,0	0,2	3	■
JSE513030F4C.0Z3	SIRA	10201454	4	F	3,0	6,0	15,0	57,0	0,03	3	■
JSE513040F4C.0Z3	SIRA	10201455	4	F	4,0	6,0	20,0	63,0	0,04	3	■
JSE513050F4C.0Z3	SIRA	10201456	4	F	5,0	6,0	25,0	75,0	0,05	3	■
JSE513060D4C.0Z3	SIRA	10201457	4	D	6,0	6,0	30,0	75,0	0,06	3	■
JSE513080D4C.0Z3	SIRA	10201458	4	D	8,0	8,0	40,0	87,0	0,08	3	■
JSE513100D4C.0Z3	SIRA	10201459	4	D	10,0	10,0	50,0	104,0	0,1	3	■
JSE513120D4C.0Z3	SIRA	10201460	4	D	12,0	12,0	60,0	125,0	0,12	3	■
JSE513160D4C.0Z3	SIRA	10201461	4	D	16,0	16,0	80,0	150,0	0,16	3	■
JSE513200D4C.0Z3	SIRA	10201462	4	D	20,0	20,0	100,0	170,0	0,2	3	■

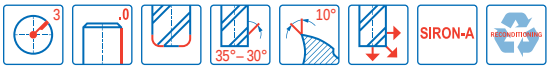
■ Prodotto standard.

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Uso generico – Universale – Spallamento – 3 Eliche – Cilindrico – Raggio di punta







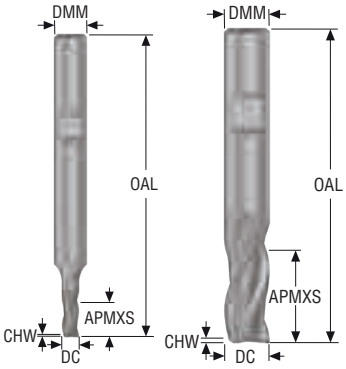
- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø10

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JSE513030G2R050.0Z3	SIRA	10053023	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	3	■
JSE513040G2R050.0Z3	SIRA	10053024	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	3	■
JSE513050G2R050.0Z3	SIRA	10053025	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	3	■
JSE513060E2R050.0Z3	SIRA	10053026	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	3	■
JSE513060E2R100.0Z3	SIRA	10053032	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	3	■
JSE513080E2R050.0Z3	SIRA	10053027	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	■
JSE513080E2R100.0Z3	SIRA	10053033	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	■
JSE513100E2R050.0Z3	SIRA	10053028	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	3	■
JSE513100E2R100.0Z3	SIRA	10053034	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	3	■
JSE513120E2R050.0Z3	SIRA	10053029	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	3	■
JSE513120E2R100.0Z3	SIRA	10053035	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	3	■
JSE513160E2R050.0Z3	SIRA	10053030	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	3	■
JSE513160E2R100.0Z3	SIRA	10053036	2	E	16,0	16,0	28,0	92,0	42,0	15,2	1,0	3	■
JSE513200E2R050.0Z3	SIRA	10053031	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	3	■
JSE513200E2R100.0Z3	SIRA	10053037	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	3	■

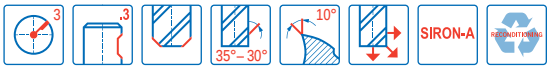
■ Prodotto standard.

JSE513

Uso generico – Universale – Spallamento – 3 Eliche – Weldon – smusso







- Tolleranze:
- DMM=h5
- DC=e8
- Riaffilatura possibile se DC è ≥Ø10

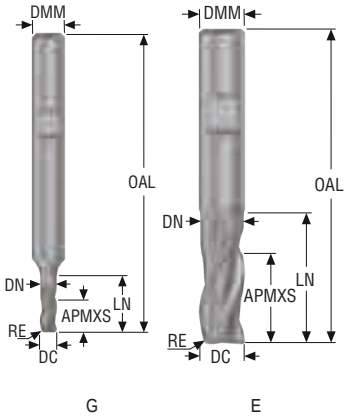
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JSE513020F2C.3Z3	SIRA	10053120	2	F	2,0	6,0	4,0	57,0	0,02	3	■
JSE513025F2C.3Z3	SIRA	10053121	2	F	2,5	6,0	5,0	57,0	0,025	3	■
JSE513030F2C.3Z3	SIRA	10053122	2	F	3,0	6,0	6,0	57,0	0,03	3	■
JSE513040F2C.3Z3	SIRA	10053123	2	F	4,0	6,0	8,0	57,0	0,04	3	■
JSE513050F2C.3Z3	SIRA	10053124	2	F	5,0	6,0	10,0	57,0	0,05	3	■
JSE513060D2C.3Z3	SIRA	10053125	2	D	6,0	6,0	12,0	57,0	0,06	3	■
JSE513070F2C.3Z3	SIRA	10053126	2	F	7,0	8,0	14,0	63,0	0,07	3	■
JSE513080D2C.3Z3	SIRA	10053127	2	D	8,0	8,0	16,0	63,0	0,08	3	■
JSE513090F2C.3Z3	SIRA	10053128	2	F	9,0	10,0	18,0	72,0	0,09	3	■
JSE513100D2C.3Z3	SIRA	10053129	2	D	10,0	10,0	20,0	72,0	0,1	3	■
JSE513110F2C.3Z3	SIRA	10053130	2	F	11,0	12,0	22,0	83,0	0,11	3	■
JSE513120D2C.3Z3	SIRA	10053131	2	D	12,0	12,0	24,0	83,0	0,12	3	■
JSE513140D2C.3Z3	SIRA	10053132	2	D	14,0	14,0	28,0	80,0	0,14	3	■
JSE513160D2C.3Z3	SIRA	10053133	2	D	16,0	16,0	32,0	92,0	0,16	3	■
JSE513180D2C.3Z3	SIRA	10053258	2	D	18,0	18,0	35,0	100,0	0,18	3	■
JSE513200D2C.3Z3	SIRA	10053259	2	D	20,0	20,0	35,0	104,0	0,2	3	■
JSE513030F3C.3Z3	SIRA	10053275	3	F	3,0	6,0	10,0	57,0	0,03	3	■
JSE513040F3C.3Z3	SIRA	10053276	3	F	4,0	6,0	14,0	57,0	0,04	3	■
JSE513050F3C.3Z3	SIRA	10053277	3	F	5,0	6,0	18,0	57,0	0,05	3	■
JSE513060D3C.3Z3	SIRA	10053283	3	D	6,0	6,0	20,0	63,0	0,06	3	■
JSE513080D3C.3Z3	SIRA	10053284	3	D	8,0	8,0	28,0	80,0	0,08	3	■
JSE513100D3C.3Z3	SIRA	10053285	3	D	10,0	10,0	35,0	89,0	0,1	3	■
JSE513120D3C.3Z3	SIRA	10053286	3	D	12,0	12,0	42,0	100,0	0,12	3	■
JSE513160D3C.3Z3	SIRA	10053287	3	D	16,0	16,0	50,0	115,0	0,16	3	■
JSE513200D3C.3Z3	SIRA	10053288	3	D	20,0	20,0	60,0	125,0	0,2	3	■
JSE513030F4C.3Z3	SIRA	10201463	4	F	3,0	6,0	15,0	57,0	0,03	3	■
JSE513040F4C.3Z3	SIRA	10201464	4	F	4,0	6,0	20,0	63,0	0,04	3	■
JSE513050F4C.3Z3	SIRA	10201465	4	F	5,0	6,0	25,0	75,0	0,05	3	■
JSE513060D4C.3Z3	SIRA	10201466	4	D	6,0	6,0	30,0	75,0	0,06	3	■
JSE513080D4C.3Z3	SIRA	10201467	4	D	8,0	8,0	40,0	87,0	0,08	3	■
JSE513100D4C.3Z3	SIRA	10201468	4	D	10,0	10,0	50,0	104,0	0,1	3	■
JSE513120D4C.3Z3	SIRA	10201469	4	D	12,0	12,0	60,0	125,0	0,12	3	■
JSE513160D4C.3Z3	SIRA	10201470	4	D	16,0	16,0	80,0	150,0	0,16	3	■
JSE513200D4C.3Z3	SIRA	10201471	4	D	20,0	20,0	100,0	170,0	0,2	3	■

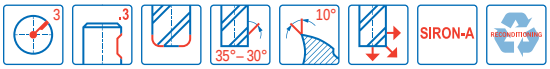
■ Prodotto standard.

JSE513

Uso generico – Universale – Spallamento – 3 Eliche – Weldon – Raggio di punta







- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø10

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JSE513030G2R050.3Z3	SIRA	10053260	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	3	■
JSE513040G2R050.3Z3	SIRA	10053261	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	3	■
JSE513050G2R050.3Z3	SIRA	10053262	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	3	■
JSE513060E2R050.3Z3	SIRA	10053263	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	3	■
JSE513060E2R100.3Z3	SIRA	10053269	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	3	■
JSE513080E2R050.3Z3	SIRA	10053264	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	■
JSE513080E2R100.3Z3	SIRA	10053270	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	■
JSE513100E2R050.3Z3	SIRA	10053265	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	3	■
JSE513100E2R100.3Z3	SIRA	10053271	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	3	■
JSE513120E2R050.3Z3	SIRA	10053266	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	3	■
JSE513120E2R100.3Z3	SIRA	10053272	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	3	■
JSE513160E2R050.3Z3	SIRA	10053267	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	3	■
JSE513160E2R100.3Z3	SIRA	10053273	2	E	16,0	16,0	28,0	92,0	42,0	15,2	1,0	3	■
JSE513200E2R050.3Z3	SIRA	10053268	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	3	■
JSE513200E2R100.3Z3	SIRA	10053274	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	3	■

■ Prodotto standard.

Parametri di taglio – JSE513 Contornatura

SMG		a_e/DC	a_p/DC	f_z														v_c
				2	3	4	5	6	7	8	9	10	11	12	14	16	18	20	
P1	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P2	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P3	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P4	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P5	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P6	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P7	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P8	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P11	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
P12	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (64 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (210 — 390)*
M1	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M2	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M3	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M4	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M5	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
K1	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K2	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K3	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K4	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K5	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K6	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K7	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
N1	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	510 (390 — 630)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*1675 (1300 — 2000)*
N11	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	385 (260 — 510)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*1275 (860 — 1600)*
S11	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
S12	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
S13	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JSE513 Scanalatura

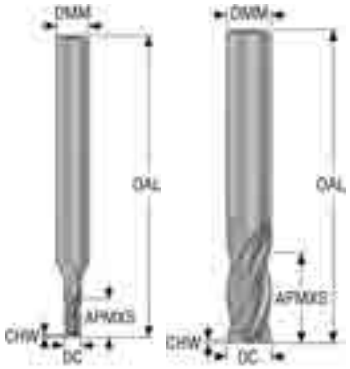
SMG		a_p/DC	f_z															v_c
			2	3	4	5	6	7	8	9	10	11	12	14	16	18	20	
P1	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P2	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P3	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P4	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P5	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P6	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P7	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P8	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P11	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (51 — 100)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
P12	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M1	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M2	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M3	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M4	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M5	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
K1	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K2	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K3	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K4	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K5	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K6	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K7	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
N1	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	400 (310 — 500)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*1300 (1100 — 1600)*
N11	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	300 (200 — 400)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*980 (660 — 1300)*
S11	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
S12	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
S13	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

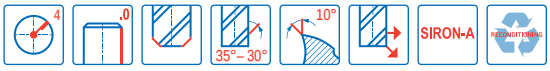
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F D





- Tolleranze:
- DMM=h5
- DC=e8
- Riaffilatura possibile se DC è ≥Ø10

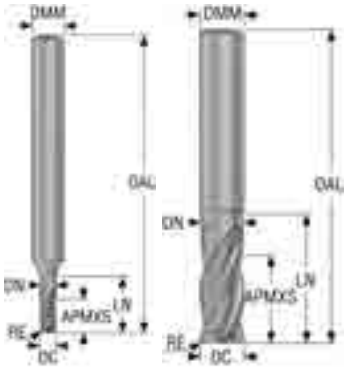
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm		
JSE514021F2C.0Z4	SIRA	10053053	2	F	2,0	3,0	4,0	50,0	0,02	4	■
JSE514020F2C.0Z4	SIRA	10053057	2	F	2,0	6,0	4,0	57,0	0,02	4	■
JSE514030D2C.0Z4	SIRA	10053054	2	D	3,0	3,0	6,0	50,0	0,03	4	■
JSE514030F2C.0Z4	SIRA	10053058	2	F	3,0	6,0	6,0	57,0	0,03	4	■
JSE514040D2C.0Z4	SIRA	10053055	2	D	4,0	4,0	8,0	50,0	0,04	4	■
JSE514040F2C.0Z4	SIRA	10053059	2	F	4,0	6,0	8,0	57,0	0,04	4	■
JSE514050D2C.0Z4	SIRA	10053056	2	D	5,0	5,0	10,0	50,0	0,05	4	■
JSE514050F2C.0Z4	SIRA	10053060	2	F	5,0	6,0	10,0	57,0	0,05	4	■
JSE514060D2C.0Z4	SIRA	10053061	2	D	6,0	6,0	12,0	57,0	0,06	4	■
JSE514080D2C.0Z4	SIRA	10053062	2	D	8,0	8,0	16,0	63,0	0,08	4	■
JSE514100D2C.0Z4	SIRA	10053063	2	D	10,0	10,0	20,0	72,0	0,1	4	■
JSE514120D2C.0Z4	SIRA	10053064	2	D	12,0	12,0	24,0	83,0	0,12	4	■
JSE514160D2C.0Z4	SIRA	10053067	2	D	16,0	16,0	32,0	92,0	0,16	4	■
JSE514180D2C.0Z4	SIRA	10053068	2	D	18,0	18,0	35,0	100,0	0,18	4	■
JSE514200D2C.0Z4	SIRA	10053069	2	D	20,0	20,0	35,0	104,0	0,2	4	■
JSE514250D2C.0Z4	SIRA	10053070	2	D	25,0	25,0	40,0	125,0	0,25	4	■
JSE514030F3C.0Z4	SIRA	10053090	3	F	3,0	6,0	10,0	57,0	0,03	4	■
JSE514040F3C.0Z4	SIRA	10053091	3	F	4,0	6,0	14,0	57,0	0,04	4	■
JSE514050F3C.0Z4	SIRA	10053092	3	F	5,0	6,0	18,0	57,0	0,05	4	■
JSE514060D3C.0Z4	SIRA	10053093	3	D	6,0	6,0	20,0	63,0	0,06	4	■
JSE514080D3C.0Z4	SIRA	10053094	3	D	8,0	8,0	28,0	80,0	0,08	4	■
JSE514100D3C.0Z4	SIRA	10053095	3	D	10,0	10,0	35,0	89,0	0,1	4	■
JSE514120D3C.0Z4	SIRA	10053096	3	D	12,0	12,0	42,0	100,0	0,12	4	■
JSE514160D3C.0Z4	SIRA	10053097	3	D	16,0	16,0	50,0	115,0	0,16	4	■
JSE514200D3C.0Z4	SIRA	10053098	3	D	20,0	20,0	60,0	125,0	0,2	4	■
JSE514030F4C.0Z4	SIRA	10201472	4	F	3,0	6,0	15,0	57,0	0,03	4	■
JSE514040F4C.0Z4	SIRA	10201473	4	F	4,0	6,0	20,0	63,0	0,04	4	■
JSE514050F4C.0Z4	SIRA	10201474	4	F	5,0	6,0	25,0	75,0	0,05	4	■
JSE514060D4C.0Z4	SIRA	10201475	4	D	6,0	6,0	30,0	75,0	0,06	4	■
JSE514080D4C.0Z4	SIRA	10201476	4	D	8,0	8,0	40,0	87,0	0,08	4	■
JSE514100D4C.0Z4	SIRA	10201477	4	D	10,0	10,0	50,0	104,0	0,1	4	■
JSE514120D4C.0Z4	SIRA	10201478	4	D	12,0	12,0	60,0	125,0	0,12	4	■
JSE514160D4C.0Z4	SIRA	10201479	4	D	16,0	16,0	80,0	150,0	0,16	4	■
JSE514200D4C.0Z4	SIRA	10201480	4	D	20,0	20,0	100,0	170,0	0,2	4	■

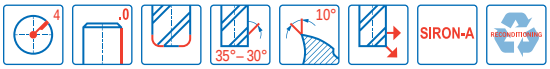
■ Prodotto standard.

JSE514

Uso generico – Universale – Spallamento – 4 Eliche – Cilindrico – Raggio di punta







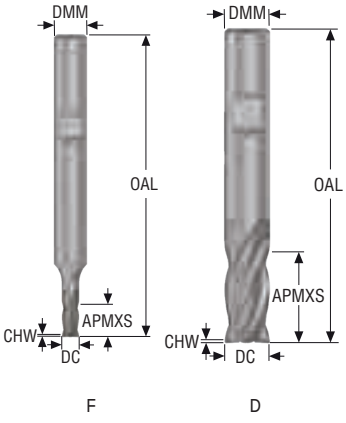
- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø10

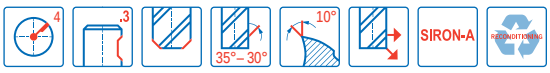
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JSE514030G2R050.0Z4	SIRA	10053071	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	■
JSE514040G2R050.0Z4	SIRA	10053072	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	4	■
JSE514050G2R050.0Z4	SIRA	10053073	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	4	■
JSE514060E2R050.0Z4	SIRA	10053074	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JSE514060E2R100.0Z4	SIRA	10053081	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JSE514080E2R050.0Z4	SIRA	10053075	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JSE514080E2R100.0Z4	SIRA	10053082	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JSE514100E2R050.0Z4	SIRA	10053076	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JSE514100E2R100.0Z4	SIRA	10053083	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JSE514120E2R050.0Z4	SIRA	10053077	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JSE514120E2R100.0Z4	SIRA	10053084	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JSE514160E2R050.0Z4	SIRA	10053078	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JSE514160E2R100.0Z4	SIRA	10053087	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JSE514200E2R050.0Z4	SIRA	10053079	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	4	■
JSE514200E2R100.0Z4	SIRA	10053088	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	4	■
JSE514250E2R050.0Z4	SIRA	10053080	2	E	25,0	25,0	40,0	125,0	66,0	23,8	0,5	4	■
JSE514250E2R100.0Z4	SIRA	10053089	2	E	25,0	25,0	40,0	125,0	66,0	23,8	1,0	4	■

■ Prodotto standard.

JSE514

Uso generico – Universale – Spallamento – 4 Eliche – Weldon – smusso







- Tolleranze:
- DMM=h5
- DC=e8
- Riaffilatura possibile se DC è ≥Ø10

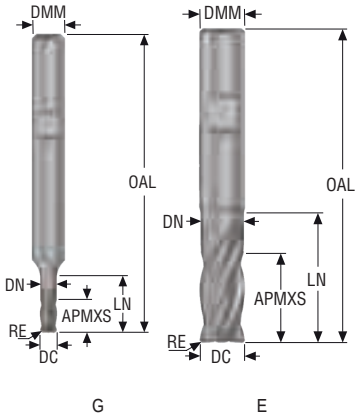
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JSE514020F2C.3Z4	SIRA	10053289	2	F	2,0	6,0	4,0	57,0	0,02	4	■
JSE514030F2C.3Z4	SIRA	10053290	2	F	3,0	6,0	6,0	57,0	0,03	4	■
JSE514040F2C.3Z4	SIRA	10053291	2	F	4,0	6,0	8,0	57,0	0,04	4	■
JSE514050F2C.3Z4	SIRA	10053292	2	F	5,0	6,0	10,0	57,0	0,05	4	■
JSE514060D2C.3Z4	SIRA	10053293	2	D	6,0	6,0	12,0	57,0	0,06	4	■
JSE514080D2C.3Z4	SIRA	10053294	2	D	8,0	8,0	16,0	63,0	0,08	4	■
JSE514100D2C.3Z4	SIRA	10053295	2	D	10,0	10,0	20,0	72,0	0,1	4	■
JSE514120D2C.3Z4	SIRA	10053296	2	D	12,0	12,0	24,0	83,0	0,12	4	■
JSE514160D2C.3Z4	SIRA	10053297	2	D	16,0	16,0	32,0	92,0	0,16	4	■
JSE514180D2C.3Z4	SIRA	10053298	2	D	18,0	18,0	35,0	100,0	0,18	4	■
JSE514200D2C.3Z4	SIRA	10053299	2	D	20,0	20,0	35,0	104,0	0,2	4	■
JSE514250D2C.3Z4	SIRA	10053300	2	D	25,0	25,0	40,0	125,0	0,25	4	■
JSE514030F3C.3Z4	SIRA	10053321	3	F	3,0	6,0	10,0	57,0	0,03	4	■
JSE514040F3C.3Z4	SIRA	10053322	3	F	4,0	6,0	14,0	57,0	0,04	4	■
JSE514050F3C.3Z4	SIRA	10053323	3	F	5,0	6,0	18,0	57,0	0,05	4	■
JSE514060D3C.3Z4	SIRA	10053324	3	D	6,0	6,0	20,0	63,0	0,06	4	■
JSE514080D3C.3Z4	SIRA	10053325	3	D	8,0	8,0	28,0	80,0	0,08	4	■
JSE514100D3C.3Z4	SIRA	10053326	3	D	10,0	10,0	35,0	89,0	0,1	4	■
JSE514120D3C.3Z4	SIRA	10053327	3	D	12,0	12,0	42,0	100,0	0,12	4	■
JSE514160D3C.3Z4	SIRA	10053328	3	D	16,0	16,0	50,0	115,0	0,16	4	■
JSE514200D3C.3Z4	SIRA	10053329	3	D	20,0	20,0	60,0	125,0	0,2	4	■
JSE514030F4C.3Z4	SIRA	10201481	4	F	3,0	6,0	15,0	57,0	0,03	4	■
JSE514040F4C.3Z4	SIRA	10201482	4	F	4,0	6,0	20,0	63,0	0,04	4	■
JSE514050F4C.3Z4	SIRA	10201483	4	F	5,0	6,0	25,0	75,0	0,05	4	■
JSE514060D4C.3Z4	SIRA	10201484	4	D	6,0	6,0	30,0	75,0	0,06	4	■
JSE514080D4C.3Z4	SIRA	10201485	4	D	8,0	8,0	40,0	87,0	0,08	4	■
JSE514100D4C.3Z4	SIRA	10201486	4	D	10,0	10,0	50,0	104,0	0,1	4	■
JSE514120D4C.3Z4	SIRA	10201487	4	D	12,0	12,0	60,0	125,0	0,12	4	■
JSE514160D4C.3Z4	SIRA	10201488	4	D	16,0	16,0	80,0	150,0	0,16	4	■
JSE514200D4C.3Z4	SIRA	10201489	4	D	20,0	20,0	100,0	170,0	0,2	4	■

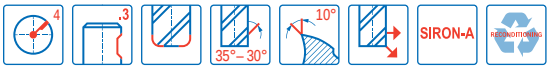
■ Prodotto standard.

JSE514

Uso generico – Universale – Spallamento – 4 Eliche – Weldon – Raggio di punta







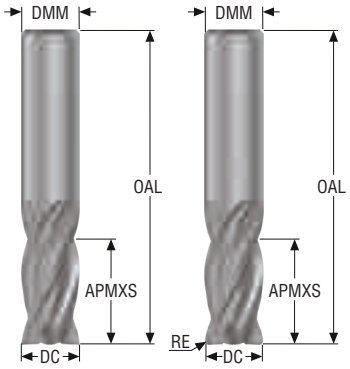
- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø10

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JSE514030G2R050.3Z4	SIRA	10053301	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	■
JSE514040G2R050.3Z4	SIRA	10053302	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	4	■
JSE514050G2R050.3Z4	SIRA	10053306	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	4	■
JSE514060E2R050.3Z4	SIRA	10053307	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JSE514060E2R100.3Z4	SIRA	10053314	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JSE514080E2R050.3Z4	SIRA	10053308	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JSE514080E2R100.3Z4	SIRA	10053315	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JSE514100E2R050.3Z4	SIRA	10053309	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JSE514100E2R100.3Z4	SIRA	10053316	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JSE514120E2R050.3Z4	SIRA	10053310	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JSE514120E2R100.3Z4	SIRA	10053317	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JSE514160E2R050.3Z4	SIRA	10053311	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JSE514160E2R100.3Z4	SIRA	10053318	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JSE514200E2R050.3Z4	SIRA	10053312	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	4	■
JSE514200E2R100.3Z4	SIRA	10053319	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	4	■
JSE514250E2R050.3Z4	SIRA	10053313	2	E	25,0	25,0	40,0	125,0	66,0	23,8	0,5	4	■
JSE514250E2R100.3Z4	SIRA	10053320	2	E	25,0	25,0	40,0	125,0	66,0	23,8	1,0	4	■

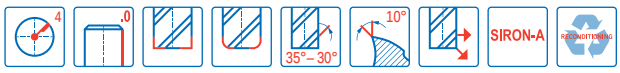
■ Prodotto standard.

JSE514

Uso generico – Universale – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo o raggio di punta – Pollici







- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±.002 Pollici
- Riaffilatura possibile se DC è ≥Ø.375

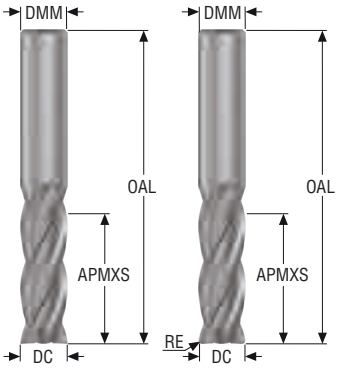
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
					inch	inch	inch	inch	inch		
JSE514.250D1S.0Z4	SIRA	10201805	1	D	0.250	0.250	0.375	2.000	–	4	■
JSE514.250D1R030.0Z4	SIRA	10201812	1	D	0.250	0.250	0.375	2.000	0.030	4	■
JSE514.375D1S.0Z4	SIRA	10201806	1	D	0.375	0.375	0.500	2.000	–	4	■
JSE514.375D1R030.0Z4	SIRA	10201813	1	D	0.375	0.375	0.500	2.000	0.030	4	■
JSE514.500D1S.0Z4	SIRA	10201807	1	D	0.500	0.500	0.625	2.500	–	4	■
JSE514.500D1R030.0Z4	SIRA	10201814	1	D	0.500	0.500	0.625	2.500	0.030	4	■
JSE514.500D1R060.0Z4	SIRA	10201815	1	D	0.500	0.500	0.625	2.500	0.060	4	■
JSE514.625D1S.0Z4	SIRA	10201808	1	D	0.625	0.625	0.750	3.000	–	4	■
JSE514.625D1R030.0Z4	SIRA	10201816	1	D	0.625	0.625	0.750	3.000	0.030	4	■
JSE514.625D1R060.0Z4	SIRA	10201817	1	D	0.625	0.625	0.750	3.000	0.060	4	■
JSE514.750D1S.0Z4	SIRA	10201809	1	D	0.750	0.750	0.875	3.000	–	4	■
JSE514.750D1R030.0Z4	SIRA	10201818	1	D	0.750	0.750	0.875	3.000	0.030	4	■
JSE514.750D1R060.0Z4	SIRA	10201819	1	D	0.750	0.750	0.875	3.000	0.060	4	■
JSE514.125D2S.0Z4	SIRA	10201803	2	D	0.125	0.125	0.250	1.500	–	4	■
JSE514.125D2R015.0Z4	SIRA	10201810	2	D	0.125	0.125	0.250	1.500	0.015	4	■
JSE514.188D2S.0Z4	SIRA	10201804	2	D	0.188	0.188	0.375	2.000	–	4	■
JSE514.188D2R020.0Z4	SIRA	10201811	2	D	0.188	0.188	0.375	2.000	0.020	4	■
JSE514.250D2S.0Z4	SIRA	10201822	2	D	0.250	0.250	0.500	2.000	–	4	■
JSE514.250D2R030.0Z4	SIRA	10201829	2	D	0.250	0.250	0.500	2.000	0.030	4	■
JSE514.375D2S.0Z4	SIRA	10201823	2	D	0.375	0.375	0.625	2.000	–	4	■
JSE514.375D2R030.0Z4	SIRA	10201830	2	D	0.375	0.375	0.625	2.000	0.030	4	■
JSE514.500D2S.0Z4	SIRA	10201824	2	D	0.500	0.500	1.000	3.000	–	4	■
JSE514.500D2R030.0Z4	SIRA	10201831	2	D	0.500	0.500	1.000	3.000	0.030	4	■
JSE514.500D2R060.0Z4	SIRA	10201832	2	D	0.500	0.500	1.000	3.000	0.060	4	■
JSE514.625D2S.0Z4	SIRA	10201825	2	D	0.625	0.625	1.250	3.500	–	4	■
JSE514.625D2R030.0Z4	SIRA	10201833	2	D	0.625	0.625	1.250	3.500	0.030	4	■
JSE514.625D2R060.0Z4	SIRA	10201834	2	D	0.625	0.625	1.250	3.500	0.060	4	■
JSE514.750D2S.0Z4	SIRA	10201826	2	D	0.750	0.750	1.500	4.000	–	4	■
JSE514.750D2R030.0Z4	SIRA	10201835	2	D	0.750	0.750	1.500	4.000	0.030	4	■
JSE514.750D2R060.0Z4	SIRA	10201836	2	D	0.750	0.750	1.500	4.000	0.060	4	■

■ Prodotto standard.

JSE514

Uso generico – Universale – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo o raggio di punta – *Inch*





- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±.002 Pollici
- Riaffilatura possibile se DC è ≥Ø.375



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
					inch	inch	inch	inch	inch		
JSE514.125D3S.0Z4	SIRA	10201820	3	D	0.125	0.125	0.500	1.500	–	4	■
JSE514.125D3R015.0Z4	SIRA	10201827	3	D	0.125	0.125	0.500	1.500	0.015	4	■
JSE514.188D3S.0Z4	SIRA	10201821	3	D	0.188	0.188	0.625	2.000	–	4	■
JSE514.188D3R020.0Z4	SIRA	10201828	3	D	0.188	0.188	0.625	2.000	0.020	4	■
JSE514.250D3S.0Z4	SIRA	10201837	3	D	0.250	0.250	0.750	2.500	–	4	■
JSE514.250D3R030.0Z4	SIRA	10201842	3	D	0.250	0.250	0.750	2.500	0.030	4	■
JSE514.375D3S.0Z4	SIRA	10201838	3	D	0.375	0.375	1.000	2.500	–	4	■
JSE514.375D3R030.0Z4	SIRA	10201843	3	D	0.375	0.375	1.000	2.500	0.030	4	■
JSE514.500D3S.0Z4	SIRA	10201839	3	D	0.500	0.500	2.000	4.000	–	4	■
JSE514.500D3R030.0Z4	SIRA	10201844	3	D	0.500	0.500	2.000	4.000	0.030	4	■
JSE514.500D3R060.0Z4	SIRA	10201845	3	D	0.500	0.500	2.000	4.000	0.060	4	■
JSE514.625D3S.0Z4	SIRA	10201840	3	D	0.625	0.625	2.250	5.000	–	4	■
JSE514.625D3R030.0Z4	SIRA	10201846	3	D	0.625	0.625	2.250	5.000	0.030	4	■
JSE514.625D3R060.0Z4	SIRA	10201847	3	D	0.625	0.625	2.250	5.000	0.060	4	■
JSE514.750D3S.0Z4	SIRA	10201841	3	D	0.750	0.750	2.250	5.000	–	4	■
JSE514.750D3R030.0Z4	SIRA	10201848	3	D	0.750	0.750	2.250	5.000	0.030	4	■
JSE514.750D3R060.0Z4	SIRA	10201849	3	D	0.750	0.750	2.250	5.000	0.060	4	■

■ Prodotto standard.

Parametri di taglio – JSE514 Contornatura

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	16	18	20	25	
P1	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P2	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.11 *0,0044*	0.13 *0,0050*	160 (67 — 190) *520 (220 — 620)*
P3	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P4	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P5	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P6	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P7	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P8	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P11	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
P12	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M1	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M2	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M3	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M4	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M5	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
K1	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K2	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K3	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K4	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K5	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K6	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K7	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
N1	E/M/A	0.150 *0,150*	1.5 *1,5*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	520 (400 — 650) *1700 (1400 — 2100)*
N11	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	410 (280 — 540) *1350 (920 — 1700)*
S11	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
S12	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
S13	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JSE514 Scanalatura

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	16	18	20	25	
P1	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51 — 150) *395 (170 — 490)*
P2	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51 — 150) *395 (170 — 490)*
P3	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51 — 150) *395 (170 — 490)*
P4	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50 — 140) *395 (170 — 450)*
P5	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51 — 150) *395 (170 — 490)*
P6	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50 — 140) *395 (170 — 450)*
P7	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51 — 150) *395 (170 — 490)*
P8	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51 — 150) *395 (170 — 490)*
P11	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (51 — 100) *230 (170 — 320)*
P12	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
M1	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
M2	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
M3	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
M4	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
M5	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
K1	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50 — 150) *395 (170 — 490)*
K2	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50 — 150) *395 (170 — 490)*
K3	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50 — 150) *395 (170 — 490)*
K4	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50 — 150) *395 (170 — 490)*
K5	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50 — 150) *395 (170 — 490)*
K6	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50 — 150) *395 (170 — 490)*
K7	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50 — 150) *395 (170 — 490)*
N1	E/M/A	0.30 *0,30*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	400 (300 — 500) *1300 (990 — 1600)*
N11	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	300 (200 — 390) *980 (660 — 1200)*
S11	E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
S12	E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
S13	E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS514 Contornatura – *Inch*

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/8	3/16	1.4	3/8	1/2	5/8	3/4	
P1	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (69 — 200) *540 (230 — 650)*
P2	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,022 *0.00085*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	160 (67 — 200) *520 (220 — 650)*
P3	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P4	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P5	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P6	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P7	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P8	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P11	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
P12	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M1	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M2	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M3	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M4	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M5	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
K1	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K2	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K3	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K4	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K5	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K6	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K7	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
N1	E/M/A	0,15 *0.15*	1,2 *1.2*	0,025 *0.0010*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	520 (400 — 650) *1700 (1400 — 2100)*
N11	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	410 (280 — 540) *1350 (920 — 1700)*
S11	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
S12	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
S13	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS514 Scanalatura – *Inch*

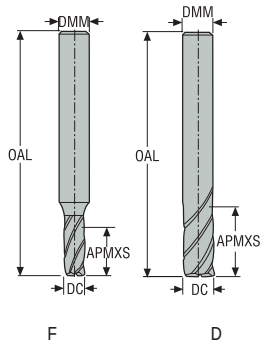
SMG		a_p/DC	f_z							v_c
			1/8	3/16	1/4	3/8	1/2	5/8	3/4	
P1	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P2	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P3	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P4	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P5	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P6	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P7	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P8	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P11	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
P12	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M1	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M2	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M3	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M4	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M5	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
K1	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K2	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K3	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K4	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K5	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K6	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K7	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
N1	E/M/A	0,30 *0.30*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	400 (310 — 500) *1300 (1100 — 1600)*
N11	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	300 (210 — 400) *980 (690 — 1300)*
S11	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
S12	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
S13	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Cilindrico – Spigolo vivo







- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile se DC è ≥Ø6

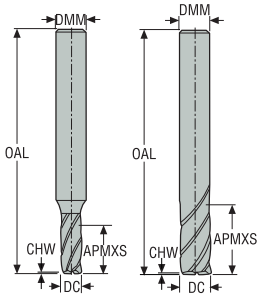
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
				mm	mm	mm	mm		
553020SZ3.0-SIRON-A	02733903	2	F	2,0	6,0	5,0	50,0	3	■
553030SZ3.0-SIRON-A	02733906	2	F	3,0	6,0	7,0	50,0	3	■
553040SZ3.0-SIRON-A	02733910	2	F	4,0	6,0	10,0	55,0	3	■
553050SZ3.0-SIRON-A	02733912	2	F	5,0	6,0	12,0	55,0	3	■
553060SZ3.0-SIRON-A	02733914	2	D	6,0	6,0	14,0	55,0	3	■
553080SZ3.0-SIRON-A	02733918	2	D	8,0	8,0	18,0	60,0	3	■
553100SZ3.0-SIRON-A	02733922	2	D	10,0	10,0	22,0	70,0	3	■

■ Prodotto standard.

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Cilindrico – Smusso





- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile se DC è ≥Ø6

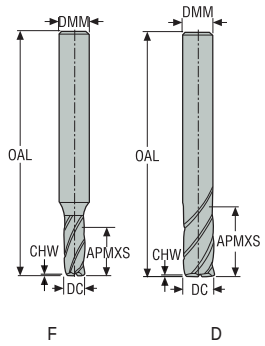


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JS553020F1C.0Z3-SIRA	10041466	1	F	2,0	6,0	3,0	40,0	0,025	3	■
JS553030F1C.0Z3-SIRA	10041467	1	F	3,0	6,0	4,0	40,0	0,035	3	■
JS553040F1C.0Z3-SIRA	10041468	1	F	4,0	6,0	6,0	40,0	0,045	3	■
JS553045F1C.0Z3-SIRA	10041469	1	F	4,5	6,0	6,0	40,0	0,045	3	■
JS553050F1C.0Z3-SIRA	10041470	1	F	5,0	6,0	7,0	40,0	0,055	3	■
JS553055F1C.0Z3-SIRA	10041472	1	F	5,5	6,0	8,0	40,0	0,055	3	■
JS553060D1C.0Z3-SIRA	10041473	1	D	6,0	6,0	8,0	40,0	0,075	3	■
JS553080D1C.0Z3-SIRA	10041474	1	D	8,0	8,0	11,0	50,0	0,1	3	■
JS553100D1C.0Z3-SIRA	10041475	1	D	10,0	10,0	13,0	57,0	0,125	3	■
JS553120D1C.0Z3-SIRA	10041476	1	D	12,0	12,0	15,0	65,0	0,15	3	■
553020Z3.0-SIRON-A	02679241	2	F	2,0	6,0	5,0	50,0	0,025	3	■
553025Z3.0-SIRON-A	02679352	2	F	2,5	6,0	7,0	50,0	0,025	3	■
553030Z3.0-SIRON-A	02679353	2	F	3,0	6,0	7,0	50,0	0,035	3	■
553035Z3.0-SIRON-A	02679359	2	F	3,5	6,0	9,0	55,0	0,035	3	■
553040Z3.0-SIRON-A	02679360	2	F	4,0	6,0	10,0	55,0	0,045	3	■
553045Z3.0-SIRON-A	02679361	2	F	4,5	6,0	12,0	55,0	0,045	3	■
553050Z3.0-SIRON-A	02679364	2	F	5,0	6,0	12,0	55,0	0,055	3	■
553055Z3.0-SIRON-A	02679365	2	F	5,5	6,0	14,0	55,0	0,055	3	■
553060Z3.0-SIRON-A	02679368	2	D	6,0	6,0	14,0	55,0	0,075	3	■
553075Z3.0-SIRON-A	02733916	2	F	7,5	8,0	18,0	60,0	0,1	3	■
553080Z3.0-SIRON-A	02679371	2	D	8,0	8,0	18,0	60,0	0,1	3	■
553095Z3.0-SIRON-A	02733920	2	F	9,5	10,0	22,0	70,0	0,125	3	■
553100Z3.0-SIRON-A	02679374	2	D	10,0	10,0	22,0	70,0	0,125	3	■
553115Z3.0-SIRON-A	02733925	2	F	11,5	12,0	26,0	80,0	0,15	3	■
553120Z3.0-SIRON-A	02679380	2	D	12,0	12,0	26,0	80,0	0,15	3	■
553140Z3.0-SIRON-A	02733932	2	D	14,0	14,0	30,0	85,0	0,175	3	■
553160Z3.0-SIRON-A	02679384	2	D	16,0	16,0	34,0	90,0	0,2	3	■
553200Z3.0-SIRON-A	02679389	2	D	20,0	20,0	42,0	110,0	0,25	3	■
553250Z3.0-SIRON-A	02679393	2	D	25,0	25,0	52,0	125,0	0,3	3	■

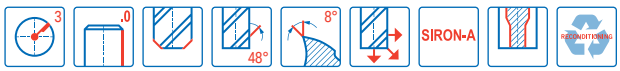
■ Prodotto standard.

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Cilindrico – Smusso







- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile se DC è ≥Ø6

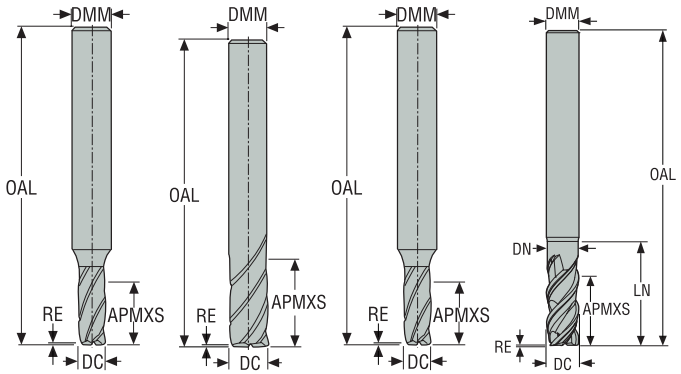
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
553L020Z3.0-SIRON-A	02733962	3	F	2,0	6,0	7,0	50,0	0,025	3	■
553L030Z3.0-SIRON-A	02733971	3	F	3,0	6,0	10,0	55,0	0,035	3	■
553L040Z3.0-SIRON-A	02733972	3	F	4,0	6,0	14,0	60,0	0,045	3	■
553L050Z3.0-SIRON-A	02733974	3	F	5,0	6,0	18,0	60,0	0,055	3	■
553L060Z3.0-SIRON-A	02733982	3	D	6,0	6,0	20,0	65,0	0,075	3	■
553L080Z3.0-SIRON-A	02733986	3	D	8,0	8,0	28,0	70,0	0,1	3	■
553L100Z3.0-SIRON-A	02733992	3	D	10,0	10,0	35,0	85,0	0,125	3	■
553L120Z3.0-SIRON-A	02733994	3	D	12,0	12,0	40,0	95,0	0,15	3	■
553L160Z3.0-SIRON-A	02733996	3	D	16,0	16,0	50,0	110,0	0,2	3	■
553L200Z3.0-SIRON-A	02733998	3	D	20,0	20,0	60,0	125,0	0,25	3	■
553L250Z3.0-SIRON-A	02734000	3	D	25,0	25,0	75,0	150,0	0,3	3	■

■ Prodotto standard.

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Cilindrico – Raggio di punta







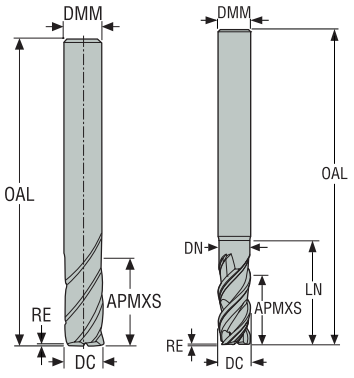
- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS553020F1R020.0Z3-SIRA	10194458	1	F	2,0	6,0	3,0	40,0	5,0	2,05	0,2	3	■
JS553030F1R020.0Z3-SIRA	10194459	1	F	3,0	6,0	4,0	40,0	6,0	3,05	0,2	3	■
JS553040F1R020.0Z3-SIRA	10194460	1	F	4,0	6,0	6,0	40,0	9,0	4,05	0,2	3	■
JS553050F1R020.0Z3-SIRA	10194461	1	F	5,0	6,0	7,0	40,0	10,0	5,05	0,2	3	■
JS553060D1R020.0Z3-SIRA	10194462	1	D	6,0	6,0	8,0	40,0	–	–	0,2	3	■
JS553060D1R050.0Z3-SIRA	10194463	1	D	6,0	6,0	8,0	40,0	–	–	0,5	3	■
JS553080D1R050.0Z3-SIRA	10194464	1	D	8,0	8,0	11,0	50,0	–	–	0,5	3	■
JS553100D1R050.0Z3-SIRA	10194465	1	D	10,0	10,0	13,0	57,0	–	–	0,5	3	■
JS553100D1R100.0Z3-SIRA	10194466	1	D	10,0	10,0	13,0	57,0	–	–	1,0	3	■
JS553120D1R050.0Z3-SIRA	10194467	1	D	12,0	12,0	15,0	65,0	–	–	0,5	3	■
JS553120D1R100.0Z3-SIRA	10194468	1	D	12,0	12,0	15,0	65,0	–	–	1,0	3	■
JS553020G2R050.0Z3-SIRA	02881683	2	G	2,0	6,0	5,0	57,0	8,0	1,9	0,5	3	■
553030R015Z3.0-SIRON-A	02733908	2	F	3,0	6,0	7,0	50,0	8,5	3,0	0,15	3	■
JS553030G2R050.0Z3-SIRA	02881684	2	G	3,0	6,0	7,0	57,0	11,0	2,85	0,5	3	■
553040R020Z3.0-SIRON-A	02733911	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,2	3	■
JS553040G2R050.0Z3-SIRA	02881685	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,5	3	■
553050R020Z3.0-SIRON-A	02687282	2	F	5,0	6,0	12,0	55,0	14,7	5,0	0,2	3	■
JS553050G2R050.0Z3-SIRA	02881686	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,5	3	■
553060R020Z3.0-SIRON-A	02679369	2	D	6,0	6,0	14,0	55,0	–	–	0,2	3	■
JS553060E2R050.0Z3-SIRA	02881687	2	E	6,0	6,0	14,0	57,0	19,0	5,7	0,5	3	■
JS553060E2R100.0Z3-SIRA	02881688	2	E	6,0	6,0	14,0	57,0	19,0	5,7	1,0	3	■
553080R050Z3.0-SIRON-A	02679372	2	D	8,0	8,0	18,0	60,0	–	–	0,5	3	■
553100R050Z3.0-SIRON-A	02679375	2	D	10,0	10,0	22,0	70,0	–	–	0,5	3	■
553100R100Z3.0-SIRON-A	02679376	2	D	10,0	10,0	22,0	70,0	–	–	1,0	3	■
553100R200Z3.0-SIRON-A	02810364	2	D	10,0	10,0	22,0	70,0	–	–	2,0	3	■
553100R250Z3.0-SIRON-A	02810365	2	D	10,0	10,0	22,0	70,0	–	–	2,5	3	■
553100R310Z3.0-SIRON-A	02810366	2	D	10,0	10,0	22,0	70,0	–	–	3,1	3	■
553120R050Z3.0-SIRON-A	02679381	2	D	12,0	12,0	26,0	80,0	–	–	0,5	3	■
553120R100Z3.0-SIRON-A	02679382	2	D	12,0	12,0	26,0	80,0	–	–	1,0	3	■
553120R200Z3.0-SIRON-A	02810367	2	D	12,0	12,0	26,0	80,0	–	–	2,0	3	■
553120R250Z3.0-SIRON-A	02810368	2	D	12,0	12,0	26,0	80,0	–	–	2,5	3	■
553120R310Z3.0-SIRON-A	02810369	2	D	12,0	12,0	26,0	80,0	–	–	3,1	3	■

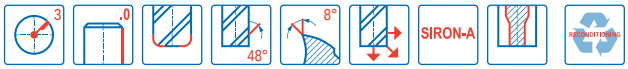
■ Prodotto standard.

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Cilindrico – Raggio di punta







- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile

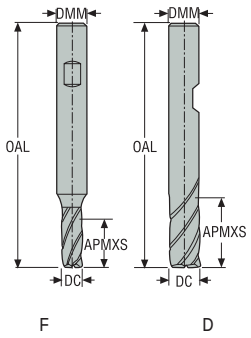
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
553160R050Z3.0-SIRON-A	02679385	2	D	16,0	16,0	34,0	90,0	–	–	0,5	3	■
553160R100Z3.0-SIRON-A	02679386	2	D	16,0	16,0	34,0	90,0	–	–	1,0	3	■
553160R200Z3.0-SIRON-A	02810370	2	D	16,0	16,0	34,0	90,0	–	–	2,0	3	■
553160R250Z3.0-SIRON-A	02810371	2	D	16,0	16,0	34,0	90,0	–	–	2,5	3	■
553160R310Z3.0-SIRON-A	02810372	2	D	16,0	16,0	34,0	90,0	–	–	3,1	3	■
553160R400Z3.0-SIRON-A	02810373	2	D	16,0	16,0	34,0	90,0	–	–	4,0	3	■
553200R050Z3.0-SIRON-A	02679390	2	D	20,0	20,0	42,0	110,0	–	–	0,5	3	■
553200R100Z3.0-SIRON-A	02679391	2	D	20,0	20,0	42,0	110,0	–	–	1,0	3	■
JS553200E2R200.0Z3-SIRA	02881689	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	3	■
553250R050Z3.0-SIRON-A	02679395	2	D	25,0	25,0	52,0	125,0	–	–	0,5	3	■
553250R100Z3.0-SIRON-A	02679396	2	D	25,0	25,0	52,0	125,0	–	–	1,0	3	■

■ Prodotto standard.

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Weldon – Spigolo vivo





- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile se DC è ≥Ø6

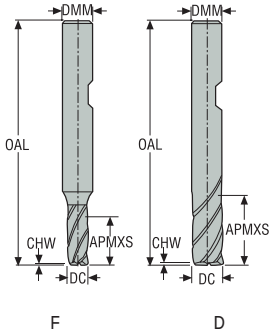


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
553020SZ3.0-SIRON-AW	02733936	2	F	2,0	6,0	5,0	50,0	3	■
553030SZ3.0-SIRON-AW	02733939	2	F	3,0	6,0	7,0	50,0	3	■
553040SZ3.0-SIRON-AW	02733943	2	F	4,0	6,0	10,0	55,0	3	■
553050SZ3.0-SIRON-AW	02733945	2	F	5,0	6,0	12,0	55,0	3	■
553060SZ3.0-SIRON-AW	02733946	2	D	6,0	6,0	14,0	55,0	3	■
553080SZ3.0-SIRON-AW	02733950	2	D	8,0	8,0	18,0	60,0	3	■
553100SZ3.0-SIRON-AW	02733952	2	D	10,0	10,0	22,0	70,0	3	■

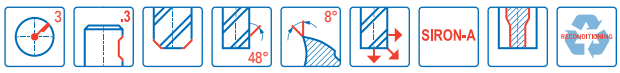
■ Prodotto standard.

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Weldon – Smusso







- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile se DC è ≥Ø6

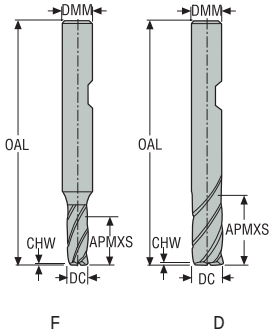
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS553020F1C.3Z3-SIRA	10041477	1	F	2,0	6,0	3,0	40,0	0,025	3	■
JS553030F1C.3Z3-SIRA	10041478	1	F	3,0	6,0	4,0	40,0	0,035	3	■
JS553040F1C.3Z3-SIRA	10041479	1	F	4,0	6,0	6,0	40,0	0,045	3	■
JS553045F1C.3Z3-SIRA	10041480	1	F	4,5	6,0	6,0	40,0	0,045	3	■
JS553050F1C.3Z3-SIRA	10041481	1	F	5,0	6,0	7,0	40,0	0,055	3	■
JS553055F1C.3Z3-SIRA	10041482	1	F	5,5	6,0	8,0	40,0	0,055	3	■
JS553060D1C.3Z3-SIRA	10041483	1	D	6,0	6,0	8,0	40,0	0,075	3	■
JS553080D1C.3Z3-SIRA	10041484	1	D	8,0	8,0	11,0	50,0	0,1	3	□
JS553100D1C.3Z3-SIRA	10041485	1	D	10,0	10,0	13,0	57,0	0,125	3	□
JS553120D1C.3Z3-SIRA	10041486	1	D	12,0	12,0	15,0	65,0	0,15	3	□
553020Z3.0-SIRON-AW	02697423	2	F	2,0	6,0	5,0	50,0	0,025	3	□
553025Z3.0-SIRON-AW	02700354	2	F	2,5	6,0	7,0	50,0	0,025	3	■
553030Z3.0-SIRON-AW	02700355	2	F	3,0	6,0	7,0	50,0	0,035	3	■
553035Z3.0-SIRON-AW	02700357	2	F	3,5	6,0	9,0	55,0	0,035	3	■
553040Z3.0-SIRON-AW	02700358	2	F	4,0	6,0	10,0	55,0	0,045	3	■
553045Z3.0-SIRON-AW	02700359	2	F	4,5	6,0	12,0	55,0	0,045	3	□
553050Z3.0-SIRON-AW	02700360	2	F	5,0	6,0	12,0	55,0	0,055	3	■
553055Z3.0-SIRON-AW	02700361	2	F	5,5	6,0	14,0	55,0	0,055	3	□
553060Z3.3-SIRON-A	02679367	2	D	6,0	6,0	14,0	55,0	0,075	3	■
553075Z3.3-SIRON-A	02733915	2	F	7,5	8,0	18,0	60,0	0,1	3	■
553080Z3.3-SIRON-A	02679370	2	D	8,0	8,0	18,0	60,0	0,1	3	■
553095Z3.3-SIRON-A	02733919	2	F	9,5	10,0	22,0	70,0	0,125	3	■
553100Z3.3-SIRON-A	02679373	2	D	10,0	10,0	22,0	70,0	0,125	3	■
553115Z3.3-SIRON-A	02733923	2	F	11,5	12,0	26,0	80,0	0,15	3	■
553120Z3.3-SIRON-A	02679379	2	D	12,0	12,0	26,0	80,0	0,15	3	■
553140Z3.3-SIRON-A	02733929	2	D	14,0	14,0	30,0	85,0	0,175	3	■
553160Z3.3-SIRON-A	02679383	2	D	16,0	16,0	34,0	90,0	0,2	3	■
553200Z3.3-SIRON-A	02679388	2	D	20,0	20,0	42,0	110,0	0,25	3	■
553250Z3.3-SIRON-A	02679392	2	D	25,0	25,0	52,0	125,0	0,3	3	■

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Weldon – Smusso





- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile se DC è ≥Ø6

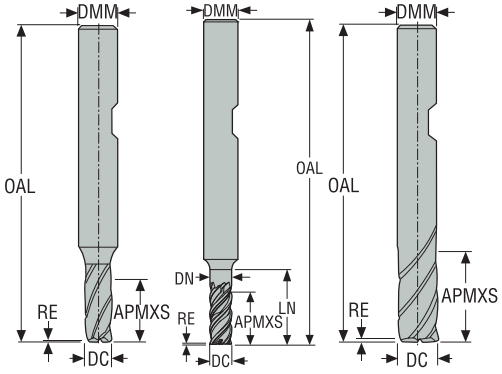


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm		
553L020Z3.0-SIRON-AW	02734001	3	F	2,0	6,0	7,0	50,0	0,025	3	□
553L030Z3.0-SIRON-AW	02734006	3	F	3,0	6,0	10,0	55,0	0,035	3	■
553L040Z3.0-SIRON-AW	02734007	3	F	4,0	6,0	14,0	60,0	0,045	3	■
553L050Z3.0-SIRON-AW	02734008	3	F	5,0	6,0	18,0	60,0	0,055	3	□
553L060Z3.3-SIRON-A	02733980	3	D	6,0	6,0	20,0	65,0	0,075	3	■
553L080Z3.3-SIRON-A	02733984	3	D	8,0	8,0	28,0	70,0	0,1	3	■
553L100Z3.3-SIRON-A	02733988	3	D	10,0	10,0	35,0	85,0	0,125	3	■
553L120Z3.3-SIRON-A	02733993	3	D	12,0	12,0	40,0	95,0	0,15	3	■
553L160Z3.3-SIRON-A	02733995	3	D	16,0	16,0	50,0	110,0	0,2	3	■
553L200Z3.3-SIRON-A	02733997	3	D	20,0	20,0	60,0	125,0	0,25	3	■
553L250Z3.3-SIRON-A	02733999	3	D	25,0	25,0	75,0	150,0	0,3	3	■

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Weldon – Raggio di punta







- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

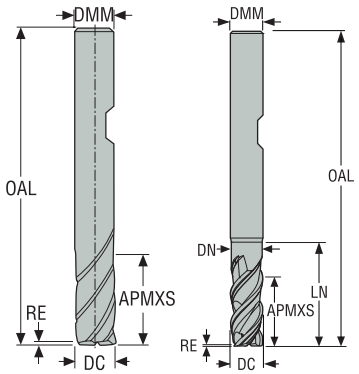
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS553080D1R050.3Z3-SIRA	10194469	1	D	8,0	8,0	11,0	50,0	–	–	0,5	3	☐
JS553100D1R050.3Z3-SIRA	10194470	1	D	10,0	10,0	13,0	57,0	–	–	0,5	3	☐
JS553100D1R100.3Z3-SIRA	10194471	1	D	10,0	10,0	13,0	57,0	–	–	1,0	3	☐
JS553120D1R050.3Z3-SIRA	10194472	1	D	12,0	12,0	15,0	65,0	–	–	0,5	3	☐
JS553120D1R100.3Z3-SIRA	10194474	1	D	12,0	12,0	15,0	65,0	–	–	1,0	3	☐
JS553020G2R050.3Z3-SIRA	02881690	2	G	2,0	6,0	5,0	57,0	8,0	1,9	0,5	3	☐
553030R015Z3.0-SIRON-AW	02733941	2	F	3,0	6,0	7,0	50,0	8,5	3,0	0,15	3	☐
JS553030G2R050.3Z3-SIRA	02881691	2	G	3,0	6,0	7,0	57,0	11,0	2,85	0,5	3	☐
553040R020Z3.0-SIRON-AW	02733944	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,2	3	☐
JS553040G2R050.3Z3-SIRA	02881692	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,5	3	☐
553050R020Z3.0-SIRON-AW	02703763	2	F	5,0	6,0	12,0	55,0	14,7	5,0	0,2	3	☐
JS553050G2R050.3Z3-SIRA	02881693	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,5	3	☐
553060R020Z3.0-SIRON-AW	02700364	2	D	6,0	6,0	14,0	55,0	–	–	0,2	3	☐
JS553060E2R050.3Z3-SIRA	02881694	2	E	6,0	6,0	14,0	57,0	19,0	5,7	0,5	3	☐
JS553060E2R100.3Z3-SIRA	02881695	2	E	6,0	6,0	14,0	57,0	19,0	5,7	1,0	3	■
553080R050Z3.0-SIRON-AW	02700366	2	D	8,0	8,0	18,0	60,0	–	–	0,5	3	■
553100R050Z3.0-SIRON-AW	02700369	2	D	10,0	10,0	22,0	70,0	–	–	0,5	3	☐
553100R100Z3.0-SIRON-AW	02700371	2	D	10,0	10,0	22,0	70,0	–	–	1,0	3	☐
553100R200Z3.3-SIRON-A	02810422	2	D	10,0	10,0	22,0	70,0	–	–	2,0	3	☐
553100R250Z3.3-SIRON-A	02810423	2	D	10,0	10,0	22,0	70,0	–	–	2,5	3	☐
553100R310Z3.3-SIRON-A	02810424	2	D	10,0	10,0	22,0	70,0	–	–	3,1	3	☐
553120R050Z3.0-SIRON-AW	02700373	2	D	12,0	12,0	26,0	80,0	–	–	0,5	3	☐
553120R100Z3.0-SIRON-AW	02700374	2	D	12,0	12,0	26,0	80,0	–	–	1,0	3	☐
553120R200Z3.3-SIRON-A	02810425	2	D	12,0	12,0	26,0	80,0	–	–	2,0	3	☐
553120R250Z3.3-SIRON-A	02810426	2	D	12,0	12,0	26,0	80,0	–	–	2,5	3	☐
553120R310Z3.3-SIRON-A	02810427	2	D	12,0	12,0	26,0	80,0	–	–	3,1	3	☐

■ Prodotto standard. ☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Weldon – Raggio di punta





- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile

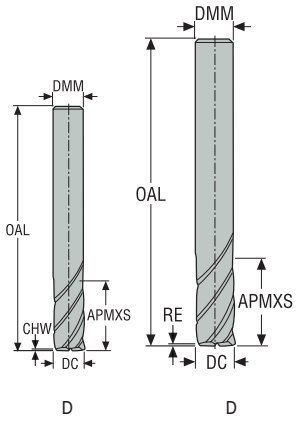


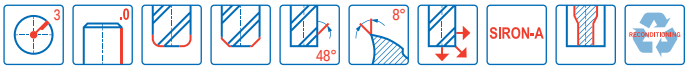
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
553160R050Z3.0-SIRON-AW	02700378	2	D	16,0	16,0	34,0	90,0	0,5	3	☐
553160R100Z3.0-SIRON-AW	02700381	2	D	16,0	16,0	34,0	90,0	1,0	3	☐
553160R200Z3.3-SIRON-A	02810428	2	D	16,0	16,0	34,0	90,0	2,0	3	☐
553160R250Z3.3-SIRON-A	02810429	2	D	16,0	16,0	34,0	90,0	2,5	3	☐
553160R310Z3.3-SIRON-A	02810430	2	D	16,0	16,0	34,0	90,0	3,1	3	☐
553160R400Z3.3-SIRON-A	02810431	2	D	16,0	16,0	34,0	90,0	4,0	3	☐
553200R050Z3.0-SIRON-AW	02700383	2	D	20,0	20,0	42,0	110,0	0,5	3	■
553200R100Z3.0-SIRON-AW	02700384	2	D	20,0	20,0	42,0	110,0	1,0	3	☐
JS553200E2R200.3Z3-SIRA	02881696	2	E	20,0	20,0	42,0	110,0	2,0	3	☐
553250R050Z3.0-SIRON-AW	02700386	2	D	25,0	25,0	52,0	125,0	0,5	3	☐
553250R100Z3.0-SIRON-AW	02700385	2	D	25,0	25,0	52,0	125,0	1,0	3	☐

■ Prodotto standard. ☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Cilindrico – Raggio di punta o smusso – Pollici







- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile se DC è ≥Ø.375

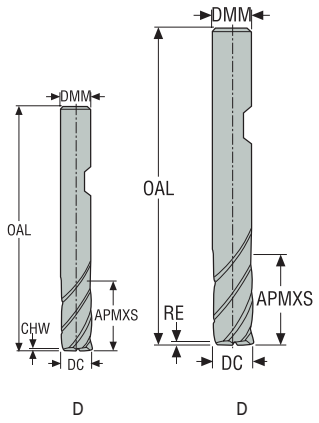
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Cilindrico
				inch	inch	inch	inch	inch	inch		
5530125Z3.0-SIRON-A	02712684	2	D	0.125	0.125	0.250	2.000	0.001	–	3	■
5530187Z3.0-SIRON-A	02712687	2	D	0.188	0.188	0.375	2.000	0.001	–	3	■
5530250Z3.0-SIRON-A	02712688	2	D	0.250	0.250	0.500	2.500	0.003	–	3	■
5530250R015Z3.0-SIRON-A	02712689	2	D	0.250	0.250	0.500	2.500	–	0.015	3	■
5530312Z3.0-SIRON-A	02712690	2	D	0.313	0.313	0.625	2.500	0.004	–	3	■
5530312R015Z3.0-SIRON-A	02712693	2	D	0.313	0.313	0.625	2.500	–	0.015	3	■
5530375Z3.0-SIRON-A	02712694	2	D	0.375	0.375	0.750	3.000	0.005	–	3	■
5530375R015Z3.0-SIRON-A	02712695	2	D	0.375	0.375	0.750	3.000	–	0.015	3	■
5530375R030Z3.0-SIRON-A	02712696	2	D	0.375	0.375	0.750	3.000	–	0.030	3	■
5530500Z3.0-SIRON-A	02712699	2	D	0.500	0.500	1.000	3.500	0.006	–	3	■
5530500R015Z3.0-SIRON-A	02712701	2	D	0.500	0.500	1.000	3.500	–	0.015	3	■
5530500R030Z3.0-SIRON-A	02712703	2	D	0.500	0.500	1.000	3.500	–	0.030	3	■

■ Prodotto standard.

JS553

Alte prestazioni – Universale – Spallamento – 3 Eliche – Weldon – Raggio di punta o smusso – Pollici





- Tolleranze:
- DMM=h5
- DC=e7



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Weldon
				inch	inch	inch	inch	inch	inch		
5530500Z3.3-SIRON-A	02712697	2	D	0.500	0.500	1.000	3.500	0.006	–	3	■
5530500R015Z3.3-SIRON-A	02712700	2	D	0.500	0.500	1.000	3.500	–	0.015	3	■
5530500R030Z3.3-SIRON-A	02712702	2	D	0.500	0.500	1.000	3.500	–	0.030	3	■

■ Prodotto standard.

Parametri di taglio – JS553 Contornatura

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	225 (200 — 250) *740 (660 — 820)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	220 (190 — 240) *720 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	190 (170 — 210) *620 (560 — 680)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	165 (150 — 190) *540 (500 — 620)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	180 (160 — 200) *590 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	170 (150 — 190) *560 (500 — 620)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	95 (82 — 100) *310 (270 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	115 (100 — 120) *375 (330 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	95 (82 — 100) *310 (270 — 320)*
M3	E	0.400 *0,400*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	60 (47 — 69) *195 (160 — 220)*
M4	E	0.400 *0,400*	1.0 *1,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	45 (36 — 53) *150 (120 — 170)*
M5	E	0.400 *0,400*	1.0 *1,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	37 (30 — 44) *120 (99 — 140)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	165 (160 — 190) *540 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	145 (140 — 170) *475 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (120 — 140) *410 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	120 (110 — 140) *395 (370 — 450)*
K5	E	0.400 *0,400*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.1 *1,1*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS553 Contornatura

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
N1	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	620 (520 — 720) *2025 (1800 — 2300)*
N2	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	400 (340 — 460) *1300 (1200 — 1500)*
N3	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	265 (230 — 300) *870 (760 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	310 (260 — 350) *1025 (860 — 1100)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	43 (26 — 60) *140 (86 — 190)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	110 (78 — 130) *360 (260 — 420)*
S12	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	85 (60 — 100) *280 (200 — 320)*
S13	E	0.400 *0,400*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	65 (48 — 84) *215 (160 — 270)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	75 (62 — 91) *245 (210 — 290)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (65 — 96) *260 (220 — 310)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (65 — 96) *260 (220 — 310)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (49 — 72) *195 (170 — 230)*
TS1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	290 (180 — 400) *950 (600 — 1300)*
TP1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	300 (180 — 410) *980 (600 — 1300)*
GR1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS553 Scanalatura

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
P1	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	195 (170 — 220)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*640 (560 — 720)*
P2	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	190 (170 — 210)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*620 (560 — 680)*
P3	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	165 (140 — 180)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*540 (460 — 590)*
P4	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	145 (130 — 160)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*475 (430 — 520)*
P5	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	135 (120 — 150)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*445 (400 — 490)*
P6	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	155 (140 — 170)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*510 (460 — 550)*
P7	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	145 (130 — 160)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*475 (430 — 520)*
P8	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	135 (120 — 150)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*445 (400 — 490)*
P11	M/A/D/E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	130 (120 — 140)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*425 (400 — 450)*
P12	M/A/D/E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.11	80 (69 — 87)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0044*	*260 (230 — 280)*
M1	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	95 (85 — 100)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*310 (280 — 320)*
M2	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.11	80 (69 — 87)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0044*	*260 (230 — 280)*
M3	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.080	0.095	48 (39 — 58)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0032*	*0,0038*	*155 (130 — 190)*
M4	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.075	0.085	36 (30 — 43)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0030*	*0,0034*	*120 (99 — 140)*
M5	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.075	0.085	30 (25 — 36)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0030*	*0,0034*	*100 (83 — 110)*
K1	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	145 (140 — 170)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*475 (460 — 550)*
K2	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	125 (120 — 150)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*410 (400 — 490)*
K3	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	110 (110 — 120)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*360 (370 — 390)*
K4	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	105 (96 — 120)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*345 (320 — 390)*
K5	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	135 (120 — 150)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*445 (400 — 490)*
K6	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	200 (180 — 230)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*660 (600 — 750)*
K7	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	175 (150 — 190)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*570 (500 — 620)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS553 Scanalatura

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
N1	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	580 (490 — 670) *1900 (1700 — 2100)*
N2	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	375 (320 — 430) *1225 (1100 — 1400)*
N3	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	250 (210 — 290) *820 (690 — 950)*
N11	E	0.60 *0,60*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	34 (21 — 47) *110 (69 — 150)*
S2	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 77) *215 (180 — 250)*
H8	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 77) *215 (180 — 250)*
H11	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	80 (66 — 98) *260 (220 — 320)*
H12	M/A/D	1.0 *1,0*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	65 (52 — 77) *215 (180 — 250)*
H21	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 77) *215 (180 — 250)*
TS1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	245 (150 — 340) *800 (500 — 1100)*
TP1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (160 — 350) *820 (530 — 1100)*
GR1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	490 (400 — 580) *1600 (1400 — 1900)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS553 Contornatura – Pollici

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/8	3/16	1/4	5/16	3/8	1/2	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	225 (200 — 250) *740 (660 — 820)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	220 (190 — 240) *720 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	190 (170 — 210) *620 (560 — 680)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	165 (150 — 190) *540 (500 — 620)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	160 (140 — 180) *520 (460 — 590)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	180 (160 — 200) *590 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	95 (82 — 100) *310 (270 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	115 (100 — 120) *375 (330 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	95 (82 — 100) *310 (270 — 320)*
M3	E	0.400 *0,400*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	60 (47 — 69) *195 (160 — 220)*
M4	E	0.400 *0,400*	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	45 (36 — 53) *150 (120 — 170)*
M5	E	0.400 *0,400*	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	37 (30 — 44) *120 (99 — 140)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	165 (160 — 190) *540 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	145 (140 — 170) *475 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	125 (120 — 140) *410 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	120 (110 — 140) *395 (370 — 450)*
K5	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.1 *1,1*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	195 (170 — 220) *640 (560 — 720)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS553 Contornatura – Pollici

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/8	3/16	1/4	5/16	3/8	1/2	
N1	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	620 (520 — 720) *2025 (1800 — 2300)*
N2	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	400 (340 — 460) *1300 (1200 — 1500)*
N3	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	265 (230 — 300) *870 (760 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	310 (260 — 350) *1025 (860 — 1100)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	43 (26 — 60) *140 (86 — 190)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	110 (78 — 130) *360 (260 — 420)*
S12	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	85 (60 — 100) *280 (200 — 320)*
S13	E	0.400 *0,400*	1.0 *1,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	65 (48 — 84) *215 (160 — 270)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.020 *0,00080*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	75 (62 — 91) *245 (210 — 290)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	80 (65 — 96) *260 (220 — 310)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	80 (65 — 96) *260 (220 — 310)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	60 (49 — 72) *195 (170 — 230)*
TS1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	300 (180 — 410) *980 (600 — 1300)*
GR1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	580 (470 — 690) *1900 (1600 — 2200)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS553 Scanalatura – Pollici

SMG		a_p/DC	f_z						v_c
			1/8	3/16	1/4	5/16	3/8	1/2	
P1	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	195 (170 — 220) *640 (560 — 720)*
P2	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	165 (140 — 180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	145 (130 — 160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	135 (120 — 150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	130 (120 — 140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	95 (85 — 100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	48 (39 — 58) *155 (130 — 190)*
M4	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	36 (30 — 43) *120 (99 — 140)*
M5	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	30 (25 — 36) *100 (83 — 110)*
K1	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	145 (140 — 170) *475 (460 — 550)*
K2	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	125 (120 — 150) *410 (400 — 490)*
K3	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	110 (110 — 120) *360 (370 — 390)*
K4	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	105 (96 — 120) *345 (320 — 390)*
K5	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	135 (120 — 150) *445 (400 — 490)*
K6	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	200 (180 — 230) *660 (600 — 750)*
K7	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	175 (150 — 190) *570 (500 — 620)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS553 Scanalatura – Pollici

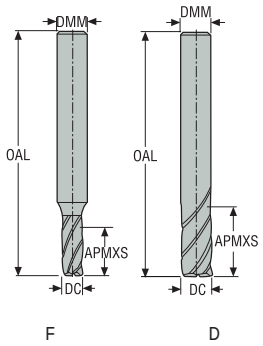
SMG		a_p/DC	f_z						v_c
			1/8	3/16	1/4	5/16	3/8	1/2	
N1	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	580 (490 — 670) *1900 (1700 — 2100)*
N2	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	375 (320 — 430) *1225 (1100 — 1400)*
N3	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	250 (210 — 290) *820 (690 — 950)*
N11	E	0.60 *0,60*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	34 (21 — 47) *110 (69 — 150)*
S2	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H8	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H21	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H31	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	49 (39 — 58) *160 (130 — 190)*
TS1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	245 (150 — 340) *800 (500 — 1100)*
TP1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	250 (160 — 350) *820 (530 — 1100)*
GR1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	490 (400 — 580) *1600 (1400 — 1900)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

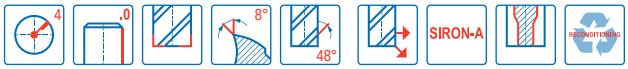
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo







- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile se DC è ≥Ø6

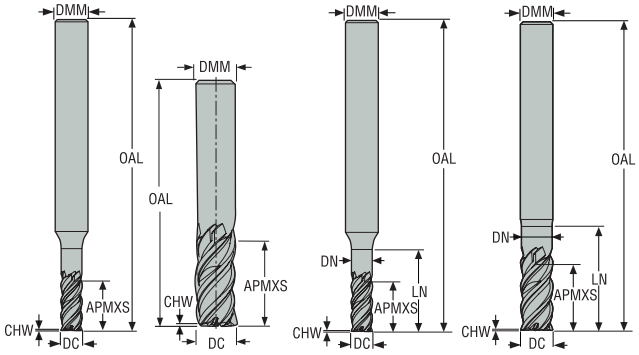
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
				mm	mm	mm	mm		
554030SZ4.0-SIRON-A	02733453	2	F	3,0	6,0	7,0	50,0	4	■
554040SZ4.0-SIRON-A	02733458	2	F	4,0	6,0	10,0	55,0	4	■
554050SZ4.0-SIRON-A	02733812	2	F	5,0	6,0	12,0	55,0	4	■
554060SZ4.0-SIRON-A	02733814	2	D	6,0	6,0	14,0	55,0	4	■
554080SZ4.0-SIRON-A	02733815	2	D	8,0	8,0	18,0	60,0	4	■
554100SZ4.0-SIRON-A	02733816	2	D	10,0	10,0	22,0	70,0	4	■

■ Prodotto standard.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Cilindrico – Smusso





- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile se DC è ≥Ø6

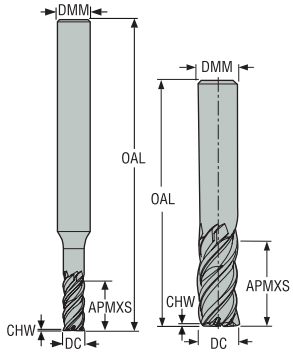


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS554030F1C.0Z4-SIRA	10194615	1	F	3,0	6,0	4,0	40,0	6,0	3,05	0,035	4	■
JS554040F1C.0Z4-SIRA	10041454	1	F	4,0	6,0	6,0	40,0	9,0	4,05	0,045	4	■
JS554050F1C.0Z4-SIRA	10194616	1	F	5,0	6,0	7,0	40,0	10,0	5,05	0,055	4	■
JS554060D1C.0Z4-SIRA	10041455	1	D	6,0	6,0	8,0	40,0	–	–	0,075	4	■
JS554080D1C.0Z4-SIRA	10041456	1	D	8,0	8,0	11,0	50,0	–	–	0,1	4	■
JS554100D1C.0Z4-SIRA	10041457	1	D	10,0	10,0	13,0	57,0	–	–	0,125	4	■
JS554120D1C.0Z4-SIRA	10041458	1	D	12,0	12,0	15,0	65,0	–	–	0,15	4	■
JS554160D1C.0Z4-SIRA	10041459	1	D	16,0	16,0	19,0	75,0	–	–	0,2	4	■
554030Z4.0-SIRON-A	02733455	2	F	3,0	6,0	7,0	50,0	8,7	3,0	0,035	4	■
JS554030G2C.0Z4-SIRA	03029956	2	G	3,0	6,0	8,0	57,0	10,0	2,85	0,035	4	■
554040Z4.0-SIRON-A	02733459	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,045	4	■
JS554040G2C.0Z4-SIRA	03029957	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,045	4	■
554050Z4.0-SIRON-A	02733813	2	F	5,0	6,0	12,0	55,0	13,7	5,0	0,055	4	■
JS554050G2C.0Z4-SIRA	03029958	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,055	4	■
554060Z4.0-SIRON-A	02679503	2	D	6,0	6,0	14,0	55,0	–	–	0,075	4	■
JS554060E2C.0Z4-SIRA	03029959	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,075	4	■
554080Z4.0-SIRON-A	02679512	2	D	8,0	8,0	18,0	60,0	–	–	0,1	4	■
JS554080E2C.0Z4-SIRA	03029961	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,1	4	■
554100Z4.0-SIRON-A	02679537	2	D	10,0	10,0	22,0	70,0	–	–	0,125	4	■
JS554100E2C.0Z4-SIRA	03029963	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,125	4	■
554120Z4.0-SIRON-A	02679548	2	D	12,0	12,0	26,0	80,0	–	–	0,15	4	■
JS554120E2C.0Z4-SIRA	03029966	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,15	4	■
554160Z4.0-SIRON-A	02679560	2	D	16,0	16,0	34,0	90,0	–	–	0,2	4	■
JS554160E2C.0Z4-SIRA	03029970	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,2	4	■
554200Z4.0-SIRON-A	02679566	2	D	20,0	20,0	42,0	100,0	–	–	0,25	4	■
JS554200E2C.0Z4-SIRA	03029972	2	E	20,0	20,0	42,0	109,0	54,0	19,0	0,25	4	■
554250Z4.0-SIRON-A	02679573	2	D	25,0	25,0	52,0	125,0	–	–	0,3	4	■

■ Prodotto standard.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Cilindrico – Smusso







- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile se DC è ≥Ø6

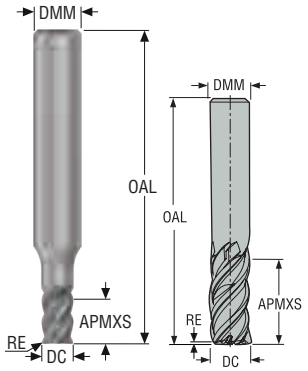
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
554L030Z4.0-SIRON-A	02733818	3	F	3,0	6,0	12,0	55,0	13,7	3,0	0,035	4	■
554L040Z4.0-SIRON-A	02733823	3	F	4,0	6,0	16,0	60,0	17,7	4,0	0,045	4	■
554L050Z4.0-SIRON-A	02733825	3	F	5,0	6,0	20,0	65,0	21,7	5,0	0,055	4	■
554L060Z4.0-SIRON-A	02733828	3	D	6,0	6,0	23,0	65,0	–	–	0,075	4	■
554L080Z4.0-SIRON-A	02733830	3	D	8,0	8,0	32,0	75,0	–	–	0,1	4	■
554L100Z4.0-SIRON-A	02733832	3	D	10,0	10,0	40,0	85,0	–	–	0,125	4	■
554L120Z4.0-SIRON-A	02733834	3	D	12,0	12,0	45,0	100,0	–	–	0,15	4	■
554L160Z4.0-SIRON-A	02733836	3	D	16,0	16,0	55,0	115,0	–	–	0,2	4	■
554L200Z4.0-SIRON-A	02733838	3	D	20,0	20,0	65,0	125,0	–	–	0,25	4	■
554L250Z4.0-SIRON-A	02733841	3	D	25,0	25,0	85,0	150,0	–	–	0,3	4	■

■ Prodotto standard.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Cilindrico – Raggio di punta





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

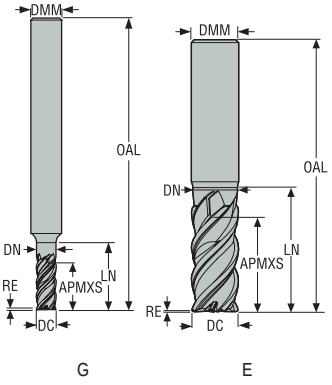


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JS554030F1R020.0Z4-SIRA	10194617	1	F	3,0	6,0	4,0	40,0	0,2	4	■
JS554040F1R020.0Z4-SIRA	10194618	1	F	4,0	6,0	6,0	40,0	0,2	4	■
JS554050F1R020.0Z4-SIRA	10194619	1	F	5,0	6,0	7,0	40,0	0,2	4	■
JS554060D1R020.0Z4-SIRA	10194620	1	D	6,0	6,0	8,0	40,0	0,2	4	■
JS554060D1R050.0Z4-SIRA	10194621	1	D	6,0	6,0	8,0	40,0	0,5	4	■
JS554080D1R050.0Z4-SIRA	10194622	1	D	8,0	8,0	11,0	50,0	0,5	4	■
JS554100D1R050.0Z4-SIRA	10194623	1	D	10,0	10,0	13,0	57,0	0,5	4	■
JS554100D1R100.0Z4-SIRA	10194624	1	D	10,0	10,0	13,0	57,0	1,0	4	■
JS554120D1R050.0Z4-SIRA	10194625	1	D	12,0	12,0	15,0	65,0	0,5	4	■
JS554120D1R100.0Z4-SIRA	10194626	1	D	12,0	12,0	15,0	65,0	1,0	4	■
JS554160D1R050.0Z4-SIRA	10194627	1	D	16,0	16,0	19,0	75,0	0,5	4	■
JS554160D1R100.0Z4-SIRA	10194628	1	D	16,0	16,0	19,0	75,0	1,0	4	■
554060R020Z4.0-SIRON-A	02679507	2	D	6,0	6,0	14,0	55,0	0,2	4	■
554080R050Z4.0-SIRON-A	02679514	2	D	8,0	8,0	18,0	60,0	0,5	4	■
554100R050Z4.0-SIRON-A	02679540	2	D	10,0	10,0	22,0	70,0	0,5	4	■
554100R100Z4.0-SIRON-A	02679544	2	D	10,0	10,0	22,0	70,0	1,0	4	■
554120R050Z4.0-SIRON-A	02679552	2	D	12,0	12,0	26,0	80,0	0,5	4	■
554120R100Z4.0-SIRON-A	02679557	2	D	12,0	12,0	26,0	80,0	1,0	4	■
554160R050Z4.0-SIRON-A	02679562	2	D	16,0	16,0	34,0	90,0	0,5	4	■
554160R100Z4.0-SIRON-A	02679564	2	D	16,0	16,0	34,0	90,0	1,0	4	■
554160R200Z4.0-SIRON-A	02810437	2	D	16,0	16,0	34,0	90,0	2,0	4	■
554160R310Z4.0-SIRON-A	02810439	2	D	16,0	16,0	34,0	90,0	3,1	4	■
554160R400Z4.0-SIRON-A	02810441	2	D	16,0	16,0	34,0	90,0	4,0	4	■
554200R050Z4.0-SIRON-A	02679568	2	D	20,0	20,0	42,0	100,0	0,5	4	■
554200R100Z4.0-SIRON-A	02679571	2	D	20,0	20,0	42,0	100,0	1,0	4	■
554200R250Z4.0-SIRON-A	02810443	2	D	20,0	20,0	42,0	100,0	2,5	4	■
554200R310Z4.0-SIRON-A	02810445	2	D	20,0	20,0	42,0	100,0	3,1	4	■
554200R400Z4.0-SIRON-A	02810447	2	D	20,0	20,0	42,0	100,0	4,0	4	■
554250R050Z4.0-SIRON-A	02679575	2	D	25,0	25,0	52,0	125,0	0,5	4	■
554250R100Z4.0-SIRON-A	02679577	2	D	25,0	25,0	52,0	125,0	1,0	4	■
554250R310Z4.0-SIRON-A	02810449	2	D	25,0	25,0	52,0	125,0	3,1	4	■
554250R400Z4.0-SIRON-A	02810452	2	D	25,0	25,0	52,0	125,0	4,0	4	■

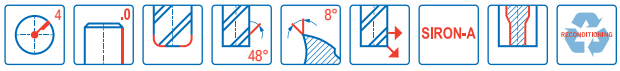
■ Prodotto standard.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Cilindrico – Raggio di punta







- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

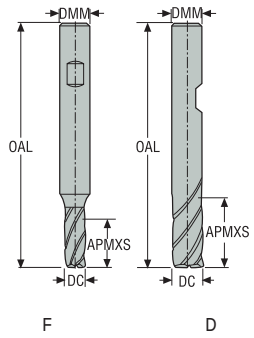
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS554030G2R015.0Z4-SIRA	02881697	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	■
JS554040G2R020.0Z4-SIRA	02881698	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,2	4	■
JS554050G2R020.0Z4-SIRA	02881699	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,2	4	■
JS554060E2R020.0Z4-SIRA	03029960	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,2	4	■
JS554060E2R050.0Z4-SIRA	02881700	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,5	4	■
JS554060E2R100.0Z4-SIRA	03029948	2	E	6,0	6,0	14,0	57,0	18,0	5,7	1,0	4	■
JS554080E2R050.0Z4-SIRA	03029962	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,5	4	■
JS554080E2R100.0Z4-SIRA	02881701	2	E	8,0	8,0	18,0	63,0	25,0	7,6	1,0	4	■
JS554100E2R050.0Z4-SIRA	03029964	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,5	4	■
JS554100E2R100.0Z4-SIRA	03029965	2	E	10,0	10,0	22,0	72,0	29,0	9,5	1,0	4	■
JS554100E2R200.0Z4-SIRA	02881702	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,0	4	■
JS554100E2R250.0Z4-SIRA	03029949	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,5	4	■
JS554120E2R050.0Z4-SIRA	03029968	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,5	4	■
JS554120E2R100.0Z4-SIRA	03029969	2	E	12,0	12,0	26,0	83,0	35,0	11,4	1,0	4	■
JS554120E2R200.0Z4-SIRA	02881703	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,0	4	■
JS554120E2R250.0Z4-SIRA	02881704	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,5	4	■
JS554120E2R300.0Z4-SIRA	03029950	2	E	12,0	12,0	26,0	83,0	35,0	11,4	3,0	4	■
JS554160E2R050.0Z4-SIRA	03029971	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,5	4	■
JS554160E2R600.0Z4-SIRA	03093685	2	E	16,0	16,0	34,0	92,0	42,0	15,2	6,0	4	■
JS554200E2R200.0Z4-SIRA	02881705	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	4	■
JS554200E2R600.0Z4-SIRA	03029951	2	E	20,0	20,0	42,0	109,0	54,0	19,0	6,0	4	■
JS554250E2R600.0Z4-SIRA	03093686	2	E	25,0	25,0	52,0	125,0	65,0	23,8	6,0	4	■

■ Prodotto standard.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Weldon – Spigolo vivo





- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile se DC è ≥Ø6

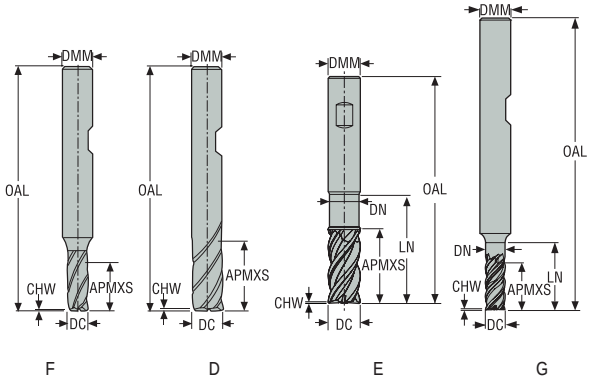


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
554030SZ4.0-SIRON-AW	02733844	2	F	3,0	6,0	7,0	50,0	4	☐
554040SZ4.0-SIRON-AW	02733846	2	F	4,0	6,0	10,0	55,0	4	☐
554050SZ4.0-SIRON-AW	02733847	2	F	5,0	6,0	12,0	55,0	4	☐
554060SZ4.0-SIRON-AW	02733848	2	D	6,0	6,0	14,0	55,0	4	☐
554080SZ4.0-SIRON-AW	02733849	2	D	8,0	8,0	18,0	60,0	4	☐
554100SZ4.0-SIRON-AW	02733850	2	D	10,0	10,0	22,0	70,0	4	☐

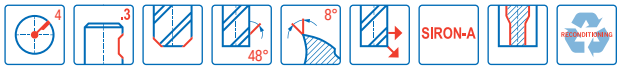
☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Weldon – Smusso







- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile se DC è ≥Ø6

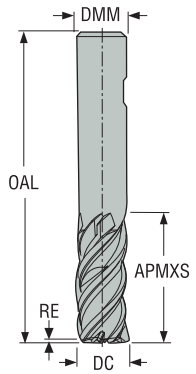
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS554040F1C.3Z4-SIRA	10041460	1	F	4,0	6,0	6,0	40,0	9,0	4,05	0,045	4	■
JS554060D1C.3Z4-SIRA	10041461	1	D	6,0	6,0	8,0	40,0	–	–	0,075	4	■
JS554080D1C.3Z4-SIRA	10041462	1	D	8,0	8,0	11,0	50,0	–	–	0,1	4	□
JS554100D1C.3Z4-SIRA	10041463	1	D	10,0	10,0	13,0	57,0	–	–	0,125	4	□
JS554120D1C.3Z4-SIRA	10041464	1	D	12,0	12,0	15,0	65,0	–	–	0,15	4	□
JS554160D1C.3Z4-SIRA	10041465	1	D	16,0	16,0	19,0	75,0	–	–	0,2	4	□
554030Z4.3-SIRON-A	02733450	2	F	3,0	6,0	7,0	50,0	8,7	3,0	0,035	4	■
JS554030G2C.3Z4-SIRA	03029973	2	G	3,0	6,0	8,0	57,0	10,0	2,85	0,035	4	□
554040Z4.3-SIRON-A	02733456	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,045	4	■
JS554040G2C.3Z4-SIRA	03029974	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,045	4	□
554050Z4.3-SIRON-A	02733461	2	F	5,0	6,0	12,0	55,0	13,7	5,0	0,055	4	■
JS554050G2C.3Z4-SIRA	03029975	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,055	4	□
554060Z4.3-SIRON-A	02679502	2	D	6,0	6,0	14,0	55,0	–	–	0,075	4	■
JS554060E2C.3Z4-SIRA	03029976	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,075	4	□
554080Z4.3-SIRON-A	02679511	2	D	8,0	8,0	18,0	60,0	–	–	0,1	4	■
JS554080E2C.3Z4-SIRA	03029978	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,1	4	□
JS554100E2C.3Z4-SIRA	03029980	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,125	4	□
554100Z4.3-SIRON-A	02679535	2	D	10,0	10,0	22,0	70,0	–	–	0,125	4	■
JS554120E2C.3Z4-SIRA	03029983	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,15	4	□
554120Z4.3-SIRON-A	02679547	2	D	12,0	12,0	26,0	80,0	–	–	0,15	4	■
JS554160E2C.3Z4-SIRA	03029986	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,2	4	□
554160Z4.3-SIRON-A	02679559	2	D	16,0	16,0	34,0	90,0	–	–	0,2	4	■
JS554200E2C.3Z4-SIRA	03029988	2	E	20,0	20,0	42,0	109,0	54,0	19,0	0,25	4	□
554200Z4.3-SIRON-A	02679565	2	D	20,0	20,0	42,0	100,0	–	–	0,25	4	■
554250Z4.3-SIRON-A	02679572	2	D	25,0	25,0	52,0	125,0	–	–	0,3	4	■
554L030Z4.3-SIRON-A	02733817	3	F	3,0	6,0	12,0	55,0	13,7	3,0	0,035	4	■
554L040Z4.3-SIRON-A	02733820	3	F	4,0	6,0	16,0	60,0	17,7	4,0	0,045	4	■
554L050Z4.3-SIRON-A	02733824	3	F	5,0	6,0	20,0	65,0	21,7	5,0	0,055	4	■
554L060Z4.3-SIRON-A	02733827	3	D	6,0	6,0	23,0	65,0	–	–	0,075	4	■
554L080Z4.3-SIRON-A	02733829	3	D	8,0	8,0	32,0	75,0	–	–	0,1	4	■
554L100Z4.3-SIRON-A	02733831	3	D	10,0	10,0	40,0	85,0	–	–	0,125	4	■
554L120Z4.3-SIRON-A	02733833	3	D	12,0	12,0	45,0	100,0	–	–	0,15	4	■
554L160Z4.3-SIRON-A	02733835	3	D	16,0	16,0	55,0	115,0	–	–	0,2	4	■
554L200Z4.3-SIRON-A	02733837	3	D	20,0	20,0	65,0	125,0	–	–	0,25	4	■
554L250Z4.3-SIRON-A	02733839	3	D	25,0	25,0	85,0	150,0	–	–	0,3	4	■

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Weldon – Raggio di punta





D

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

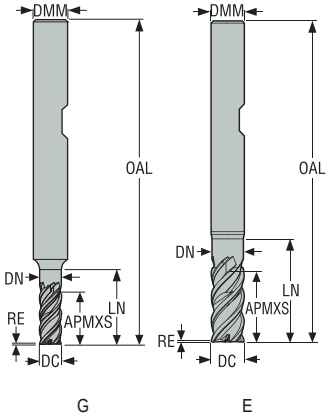


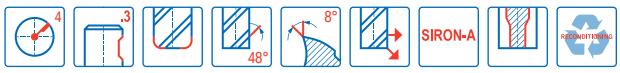
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS554080D1R050.3Z4-SIRA	10194629	1	D	8,0	8,0	11,0	50,0	0,5	4	□
JS554100D1R050.3Z4-SIRA	10194630	1	D	10,0	10,0	13,0	57,0	0,5	4	□
JS554100D1R100.3Z4-SIRA	10194631	1	D	10,0	10,0	13,0	57,0	1,0	4	□
JS554120D1R050.3Z4-SIRA	10194632	1	D	12,0	12,0	15,0	65,0	0,5	4	□
JS554120D1R100.3Z4-SIRA	10194633	1	D	12,0	12,0	15,0	65,0	1,0	4	□
JS554160D1R050.3Z4-SIRA	10194634	1	D	16,0	16,0	19,0	75,0	0,5	4	□
JS554160D1R100.3Z4-SIRA	10194635	1	D	16,0	16,0	19,0	75,0	1,0	4	□
554060R020Z4.3-SIRON-A	02679506	2	D	6,0	6,0	14,0	55,0	0,2	4	■
554080R050Z4.3-SIRON-A	02679513	2	D	8,0	8,0	18,0	60,0	0,5	4	■
554100R050Z4.3-SIRON-A	02679539	2	D	10,0	10,0	22,0	70,0	0,5	4	■
554100R100Z4.3-SIRON-A	02679542	2	D	10,0	10,0	22,0	70,0	1,0	4	■
554120R050Z4.3-SIRON-A	02679549	2	D	12,0	12,0	26,0	80,0	0,5	4	■
554120R100Z4.3-SIRON-A	02679554	2	D	12,0	12,0	26,0	80,0	1,0	4	■
554160R050Z4.3-SIRON-A	02679561	2	D	16,0	16,0	34,0	90,0	0,5	4	■
554160R100Z4.3-SIRON-A	02679563	2	D	16,0	16,0	34,0	90,0	1,0	4	■
554160R200Z4.3-SIRON-A	02810436	2	D	16,0	16,0	34,0	90,0	2,0	4	■
554160R310Z4.3-SIRON-A	02810438	2	D	16,0	16,0	34,0	90,0	3,1	4	■
554160R400Z4.3-SIRON-A	02810440	2	D	16,0	16,0	34,0	90,0	4,0	4	■
554200R050Z4.3-SIRON-A	02679567	2	D	20,0	20,0	42,0	100,0	0,5	4	■
554200R100Z4.3-SIRON-A	02679570	2	D	20,0	20,0	42,0	100,0	1,0	4	■
554200R250Z4.3-SIRON-A	02810442	2	D	20,0	20,0	42,0	100,0	2,5	4	■
554200R310Z4.3-SIRON-A	02810444	2	D	20,0	20,0	42,0	100,0	3,1	4	■
554200R400Z4.3-SIRON-A	02810446	2	D	20,0	20,0	42,0	100,0	4,0	4	■
554250R050Z4.3-SIRON-A	02679574	2	D	25,0	25,0	52,0	125,0	0,5	4	■
554250R100Z4.3-SIRON-A	02679576	2	D	25,0	25,0	52,0	125,0	1,0	4	■
554250R310Z4.3-SIRON-A	02810448	2	D	25,0	25,0	52,0	125,0	3,1	4	■
554250R400Z4.3-SIRON-A	02810451	2	D	25,0	25,0	52,0	125,0	4,0	4	■

■ Prodotto standard.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Weldon – Raggio di punta







- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

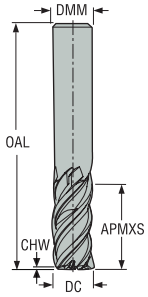
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS554030G2R015.3Z4-SIRA	02881706	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	☐
JS554040G2R020.3Z4-SIRA	02881946	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,2	4	☐
JS554050G2R020.3Z4-SIRA	02881708	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,2	4	☐
JS554060E2R020.3Z4-SIRA	03029977	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,2	4	☐
JS554060E2R050.3Z4-SIRA	02881709	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,5	4	☐
JS554060E2R100.3Z4-SIRA	03029952	2	E	6,0	6,0	14,0	57,0	18,0	5,7	1,0	4	☐
JS554080E2R050.3Z4-SIRA	03029979	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,5	4	☐
JS554080E2R100.3Z4-SIRA	02881710	2	E	8,0	8,0	18,0	63,0	25,0	7,6	1,0	4	☐
JS554100E2R050.3Z4-SIRA	03029981	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,5	4	☐
JS554100E2R100.3Z4-SIRA	03029982	2	E	10,0	10,0	22,0	72,0	29,0	9,5	1,0	4	☐
JS554100E2R200.3Z4-SIRA	02881711	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,0	4	☐
JS554100E2R250.3Z4-SIRA	03029953	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,5	4	☐
JS554120E2R050.3Z4-SIRA	03029984	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,5	4	■
JS554120E2R100.3Z4-SIRA	03029985	2	E	12,0	12,0	26,0	83,0	35,0	11,4	1,0	4	☐
JS554120E2R200.3Z4-SIRA	02881712	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,0	4	☐
JS554120E2R250.3Z4-SIRA	02881713	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,5	4	☐
JS554120E2R300.3Z4-SIRA	03029954	2	E	12,0	12,0	26,0	83,0	35,0	11,4	3,0	4	☐
JS554160E2R050.3Z4-SIRA	03029987	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,5	4	☐
JS554160E2R600.3Z4-SIRA	03093687	2	E	16,0	16,0	34,0	92,0	42,0	15,2	6,0	4	☐
JS554200E2R200.3Z4-SIRA	02881714	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	4	☐
JS554200E2R600.3Z4-SIRA	03029955	2	E	20,0	20,0	42,0	109,0	54,0	19,0	6,0	4	☐
JS554250E2R600.3Z4-SIRA	03093688	2	E	25,0	25,0	52,0	125,0	65,0	23,8	6,0	4	☐

■ Prodotto standard. ☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Cilindrico – Smusso – Pollici





D

- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile se DC è ≥Ø.375

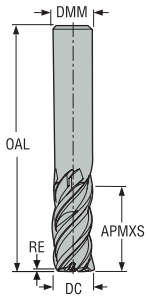


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
				inch	inch	inch	inch	inch		
5540250Z4.0-SIRON-A	02711329	2	D	0.250	0.250	0.500	2.500	0.003	4	■
5540312Z4.0-SIRON-A	02711340	2	D	0.313	0.313	0.625	2.500	0.004	4	■
5540375Z4.0-SIRON-A	02711344	2	D	0.375	0.375	0.750	3.000	0.005	4	■
5540500Z4.0-SIRON-A	02711611	2	D	0.500	0.500	1.000	3.500	0.006	4	■
5540625Z4.0-SIRON-A	02711626	2	D	0.625	0.625	1.250	3.750	0.008	4	■
5540750Z4.0-SIRON-A	02711643	2	D	0.750	0.750	1.500	4.000	0.010	4	■
5541000Z4.0-SIRON-A	02711660	2	D	1.000	1.000	2.000	5.000	0.012	4	■

■ Prodotto standard.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Cilindrico – Raggio di punta – Pollici



D





- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±.0008 *pollici*
- Riaffilatura possibile se DC è ≥Ø.375

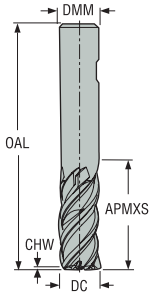
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				inch	inch	inch	inch	inch		
5540250R015Z4.0-SIRON-A	02711335	2	D	0.250	0.250	0.500	2.500	0.015	4	■
5540312R015Z4.0-SIRON-A	02711341	2	D	0.313	0.313	0.625	2.500	0.015	4	■
5540375R015Z4.0-SIRON-A	02711588	2	D	0.375	0.375	0.750	3.000	0.015	4	■
5540375R030Z4.0-SIRON-A	02711589	2	D	0.375	0.375	0.750	3.000	0.030	4	■
5540500R015Z4.0-SIRON-A	02711614	2	D	0.500	0.500	1.000	3.500	0.015	4	■
5540500R030Z4.0-SIRON-A	02711616	2	D	0.500	0.500	1.000	3.500	0.030	4	■
5540500R125Z4.0-SIRON-A	02842370	2	D	0.500	0.500	1.000	3.500	0.125	4	■
5540625R015Z4.0-SIRON-A	02711629	2	D	0.625	0.625	1.250	3.750	0.015	4	■
5540625R030Z4.0-SIRON-A	02711631	2	D	0.625	0.625	1.250	3.750	0.030	4	■
5540625R125Z4.0-SIRON-A	02842371	2	D	0.625	0.625	1.250	3.750	0.125	4	■
5540750R030Z4.0-SIRON-A	02711647	2	D	0.750	0.750	1.500	4.000	0.030	4	■
5540750R060Z4.0-SIRON-A	02711655	2	D	0.750	0.750	1.500	4.000	0.060	4	■

■ Prodotto standard.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Weldon – Smusso – Pollici





D

- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile

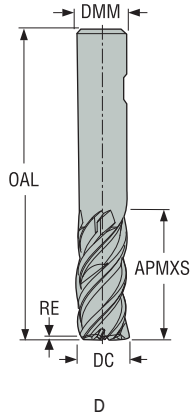


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				inch	inch	inch	inch	inch		
5540500Z4.3-SIRON-A	02711608	2	D	0.500	0.500	1.000	3.500	0.006	4	■
5540750Z4.3-SIRON-A	02711632	2	D	0.750	0.750	1.500	4.000	0.010	4	■

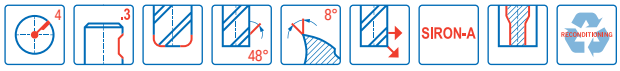
■ Prodotto standard.

JS554

Alte prestazioni – Universale – Spallamento – 4 Eliche – Weldon – Raggio di punta – Pollici



D





- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±.0008 *pollici*
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				inch	inch	inch	inch	inch		
5540500R015Z4.3-SIRON-A	02711613	2	D	0.500	0.500	1.000	3.500	0.015	4	■
5540500R030Z4.3-SIRON-A	02711615	2	D	0.500	0.500	1.000	3.500	0.030	4	■
5540500R125Z4.3-SIRON-A	02856456	2	D	0.500	0.500	1.000	3.500	0.125	4	□
5540625R125Z4.3-SIRON-A	02856457	2	D	0.625	0.625	1.250	3.750	0.125	4	□
5541000R060Z4.3-SIRON-A	02711663	2	D	1.000	1.000	2.000	5.000	0.060	4	■

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

Parametri di taglio – JS554 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	215 (190 — 240) *710 (630 — 780)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	210 (190 — 240) *690 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	185 (160 — 200) *610 (530 — 650)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (160 — 200) *570 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	140 (130 — 150) *460 (430 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	55 (45 — 66) *180 (150 — 210)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	43 (35 — 51) *140 (120 — 160)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	36 (29 — 42) *120 (96 — 130)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	175 (160 — 190) *570 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	155 (140 — 170) *510 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	130 (120 — 140) *425 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (110 — 140) *410 (370 — 450)*
K5	E	0.400 *0,400*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS554 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
N1	E	0.500 *0,500*	0.90 *0,90*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E	0.500 *0,500*	0.90 *0,90*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	390 (330 — 450) *1275 (1100 — 1400)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	320 (270 — 370) *1050 (890 — 1200)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	100 (72 — 120) *330 (240 — 390)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	75 (56 — 99) *245 (190 — 320)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	60 (44 — 78) *195 (150 — 250)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	75 (59 — 88) *245 (200 — 280)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	80 (63 — 93) *260 (210 — 300)*
H11	M/A/D	0.200 *0,200*	0.90 *0,90*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	95 (75 — 110) *310 (250 — 360)*
H12	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	90 (73 — 100) *295 (240 — 320)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	155 (110 — 190) *510 (370 — 620)*
TS1	A	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	285 (180 — 400) *940 (600 — 1300)*
TP1	A	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	295 (180 — 410) *970 (600 — 1300)*
GR1	A	0.500 *0,500*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS554 Scanalatura

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	195 (170 — 220)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*640 (560 — 720)*
P2	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	190 (170 — 210)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*620 (560 — 680)*
P3	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	165 (140 — 180)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*540 (460 — 590)*
P4	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	145 (130 — 160)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*475 (430 — 520)*
P5	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	135 (120 — 150)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*445 (400 — 490)*
P6	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	155 (140 — 170)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*510 (460 — 550)*
P7	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	145 (130 — 160)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*475 (430 — 520)*
P8	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	135 (120 — 150)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*445 (400 — 490)*
P11	M/A/D/E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	130 (120 — 140)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*425 (400 — 450)*
P12	M/A/D/E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	80 (69 — 87)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*260 (230 — 280)*
M1	E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	95 (85 — 100)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*310 (280 — 320)*
M2	E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	80 (69 — 87)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*260 (230 — 280)*
M3	E	0.60	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.050	0.065	0.080	48 (39 — 57)
		0,60	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*155 (130 — 180)*
M4	E	0.60	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.050	0.065	0.080	36 (29 — 43)
		0,60	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*120 (96 — 140)*
M5	E	0.60	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.050	0.065	0.080	30 (25 — 36)
		0,60	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*100 (83 — 110)*
K1	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	155 (140 — 170)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*510 (460 — 550)*
K2	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	135 (120 — 150)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*445 (400 — 490)*
K3	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	115 (110 — 120)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*375 (370 — 390)*
K4	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	110 (96 — 120)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*360 (320 — 390)*
K5	E	0.70	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	135 (120 — 150)
		0,70	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*445 (400 — 490)*
K6	E	0.70	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	200 (180 — 220)
		0,70	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*660 (600 — 720)*
K7	E	0.70	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	175 (150 — 190)
		0,70	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*570 (500 — 620)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS554 Scanalatura

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
N1	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	570 (480 — 670) *1875 (1600 — 2100)*
N2	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	370 (310 — 430) *1225 (1100 — 1400)*
N3	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	245 (210 — 280) *800 (690 — 910)*
N11	E	0.60 *0,60*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	30 (25 — 34) *100 (83 — 110)*
S2	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	50 (38 — 66) *165 (130 — 210)*
H5	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H8	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H11	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	80 (66 — 97) *260 (220 — 310)*
H12	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	75 (60 — 89) *245 (200 — 290)*
H21	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	125 (90 — 160) *410 (300 — 520)*
TS1	A	0.70 *0,70*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	240 (150 — 330) *790 (500 — 1000)*
TP1	A	0.70 *0,70*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (150 — 340) *820 (500 — 1100)*
GR1	A	0.80 *0,80*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	485 (390 — 580) *1600 (1300 — 1900)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS554 Contornatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	215 (190 — 240) *710 (630 — 780)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 240) *690 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	185 (160 — 200) *610 (530 — 650)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	175 (160 — 200) *570 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	165 (150 — 180) *540 (500 — 590)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	140 (130 — 150) *460 (430 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	55 (45 — 66) *180 (150 — 210)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	43 (35 — 51) *140 (120 — 160)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	36 (29 — 42) *120 (96 — 130)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	175 (160 — 190) *570 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	155 (140 — 170) *510 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	130 (120 — 140) *425 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	125 (110 — 140) *410 (370 — 450)*
K5	E	0.400 *0,400*	1.0 *1,0*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.0 *1,0*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.0 *1,0*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS554 Contornatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	390 (330 — 450) *1275 (1100 — 1400)*
N3	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	260 (220 — 300) *850 (730 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	320 (270 — 370) *1050 (890 — 1200)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.17 *0,0065*	38 (32 — 44) *125 (110 — 140)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.17 *0,0065*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	100 (72 — 120) *330 (240 — 390)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	75 (56 — 99) *245 (190 — 320)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	60 (44 — 78) *195 (150 — 250)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.15 *0,0060*	75 (59 — 88) *245 (200 — 280)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	80 (63 — 93) *260 (210 — 300)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	155 (110 — 190) *510 (370 — 620)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.080 *0,0032*	0.095 *0,0038*	60 (48 — 71) *195 (160 — 230)*
TS1	A	0.500 *0,500*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	285 (180 — 400) *940 (600 — 1300)*
TP1	A	0.500 *0,500*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	295 (180 — 410) *970 (600 — 1300)*
GR1	A	0.500 *0,500*	1.1 *1,1*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS554 Scanalatura – Pollici

SMG		a_p/DC	f_z							v_c
			1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	195 (170 — 220) *640 (560 — 720)*
P2	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	165 (140 — 180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	130 (120 — 140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	95 (85 — 100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	48 (39 — 57) *155 (130 — 180)*
M4	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	36 (29 — 43) *120 (96 — 140)*
M5	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	30 (25 — 36) *100 (83 — 110)*
K1	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	155 (140 — 170) *510 (460 — 550)*
K2	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	135 (120 — 150) *445 (400 — 490)*
K3	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	115 (110 — 120) *375 (370 — 390)*
K4	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
K5	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	135 (120 — 150) *445 (400 — 490)*
K6	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	200 (180 — 220) *660 (600 — 720)*
K7	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	175 (150 — 190) *570 (500 — 620)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS554 Scanalatura – Pollici

SMG		a_p/DC	f_z							v_c
			1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	570 (480 — 670) *1875 (1600 — 2100)*
N2	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	370 (310 — 430) *1225 (1100 — 1400)*
N3	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	245 (210 — 280) *800 (690 — 910)*
N11	E	0.60 *0,60*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	30 (25 — 34) *100 (83 — 110)*
S2	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	50 (38 — 66) *165 (130 — 210)*
H5	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H8	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H21	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	125 (90 — 160) *410 (300 — 520)*
H31	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	48 (39 — 57) *155 (130 — 180)*
TS1	A	0.70 *0,70*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	240 (150 — 330) *790 (500 — 1000)*
TP1	A	0.70 *0,70*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	250 (150 — 340) *820 (500 — 1100)*
GR1	A	0.80 *0,80*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	485 (390 — 580) *1600 (1300 — 1900)*

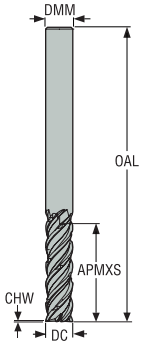
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

JS554-3C

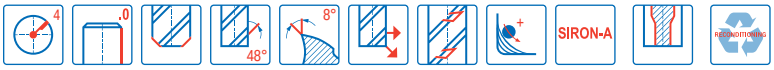
Sgrossatura avanzata – Universale – Spallamento – 4 Eliche – Cilindrico – Smusso





D

- Tolleranze:
- DMM= h5
- DC= e7
- Rompitruciolo
- Riaffilatura possibile

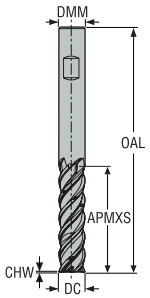


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm		
JS554060D3C.0Z4C-SIRA	02810475	3	D	■	6,0	6,0	23,0	65,0	0,075	4	■
JS554080D3C.0Z4C-SIRA	02810477	3	D	■	8,0	8,0	32,0	75,0	0,1	4	■
JS554100D3C.0Z4C-SIRA	02810479	3	D	■	10,0	10,0	40,0	85,0	0,125	4	■
JS554120D3C.0Z4C-SIRA	02810481	3	D	■	12,0	12,0	45,0	100,0	0,15	4	■
JS554160D3C.0Z4C-SIRA	02810483	3	D	■	16,0	16,0	55,0	115,0	0,2	4	■
JS554200D3C.0Z4C-SIRA	02810485	3	D	■	20,0	20,0	65,0	125,0	0,25	4	■
JS554250D3C.0Z4C-SIRA	02810486	3	D	■	25,0	25,0	85,0	150,0	0,3	4	■

■ Prodotto standard.

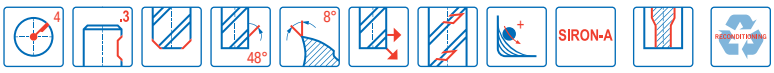
JS554-3C

Sgrossatura avanzata – Universale – Spallamento – 4 Eliche – Weldon – Smusso



D





- Tolleranze:
- DMM= h5
- DC= e7
- Rompitruciolo
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS554060D3C.3Z4C-SIRA	02810474	3	D	■	6,0	6,0	23,0	65,0	0,075	4	■
JS554080D3C.3Z4C-SIRA	02810476	3	D	■	8,0	8,0	32,0	75,0	0,1	4	■
JS554100D3C.3Z4C-SIRA	02810478	3	D	■	10,0	10,0	40,0	85,0	0,125	4	■
JS554120D3C.3Z4C-SIRA	02810480	3	D	■	12,0	12,0	45,0	100,0	0,15	4	■
JS554160D3C.3Z4C-SIRA	02810482	3	D	■	16,0	16,0	55,0	115,0	0,2	4	■
JS554200D3C.3Z4C-SIRA	02810484	3	D	■	20,0	20,0	65,0	125,0	0,25	4	■
JS554250D3C.3Z4C-SIRA	02810487	3	D	■	25,0	25,0	85,0	150,0	0,3	4	■

■ Prodotto standard.

Parametri di taglio – JS554-3C Sgrossatura avanzata

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P1	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	350 (320 — 380) *1150 (1100 — 1200)*
P2	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	340 (310 — 370) *1125 (1100 — 1200)*
P3	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	295 (270 — 320) *970 (890 — 1000)*
P4	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	260 (240 — 280) *850 (790 — 910)*
P5	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (230 — 270) *820 (760 — 880)*
P6	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	280 (260 — 300) *920 (860 — 980)*
P7	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	265 (240 — 290) *870 (790 — 950)*
P8	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	250 (230 — 270) *820 (760 — 880)*
P11	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	245 (230 — 270) *800 (760 — 880)*
P12	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	150 (140 — 160) *490 (460 — 520)*
M1	E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	180 (160 — 210) *590 (530 — 680)*
M2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	150 (130 — 170) *490 (430 — 550)*
M3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	100 (90 — 100) *330 (300 — 320)*
M4	E	0.100 *0,100*	3.6 *3,6*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	75 (70 — 85) *245 (230 — 270)*
M5	E	0.100 *0,100*	3.6 *3,6*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	65 (59 — 71) *215 (200 — 230)*
K1	E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	340 (310 — 370) *1125 (1100 — 1200)*
K2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	185 (160 — 210) *610 (530 — 680)*
K3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	255 (240 — 280) *840 (790 — 910)*
K4	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	245 (220 — 260) *800 (730 — 850)*
K5	E	0.100 *0,100*	3.6 *3,6*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (140 — 160) *490 (460 — 520)*
K6	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	215 (200 — 230) *710 (660 — 750)*
K7	E	0.100 *0,100*	3.6 *3,6*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	190 (180 — 200) *620 (600 — 650)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS554-3C Sgrossatura avanzata

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	750 (650 — 840) *2450 (2200 — 2700)*
N2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	480 (420 — 540) *1575 (1400 — 1700)*
N3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	320 (280 — 360) *1050 (920 — 1100)*
N11	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	375 (330 — 420) *1225 (1100 — 1300)*
S1	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	50 (40 — 60) *165 (140 — 190)*
S2	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	40 (33 — 48) *130 (110 — 150)*
S3	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	25 (20 — 29) *80 (66 — 95)*
S11	E	0.100 *0,100*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	195 (130 — 220) *640 (430 — 720)*
S12	E	0.100 *0,100*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	150 (100 — 160) *490 (330 — 520)*
S13	E	0.100 *0,100*	3.6 *3,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	120 (80 — 130) *395 (270 — 420)*
H5	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	200 (190 — 220) *660 (630 — 720)*
H8	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	210 (190 — 220) *690 (630 — 720)*
H11	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	255 (240 — 280) *840 (790 — 910)*
H12	M/A/D	0.100 *0,100*	3.6 *3,6*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	205 (190 — 220) *670 (630 — 720)*
H21	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	210 (190 — 220) *690 (630 — 720)*

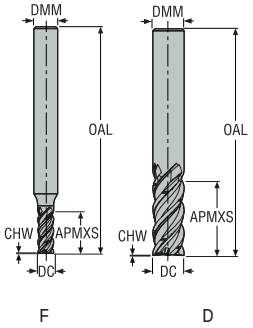
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS564

Sgrossatura avanzata – Universale – Spallamento – 4 Eliche – Cilindrico – Smusso





- Tolleranze:
- DMM= h5
- DC= e7
- Rompitruciolo
- Riaffilatura possibile se DC è ≥Ø8

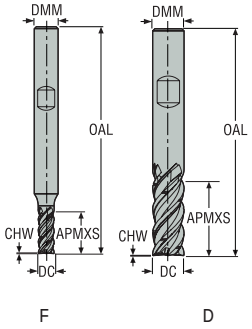


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm		
JS564030F2C.0Z4C-NXT	03067338	2	F	■	3,0	6,0	7,0	57,0	0,04	4	■
JS564040F2C.0Z4C-NXT	03067339	2	F	■	4,0	6,0	10,0	57,0	0,05	4	■
JS564050F2C.0Z4C-NXT	03067340	2	F	■	5,0	6,0	12,5	57,0	0,06	4	■
JS564060D2C.0Z4C-NXT	03067341	2	D	■	6,0	6,0	15,0	57,0	0,075	4	■
JS564080D2C.0Z4C-NXT	03067342	2	D	■	8,0	8,0	20,0	63,0	0,1	4	■
JS564100D2C.0Z4C-NXT	03067343	2	D	■	10,0	10,0	25,0	72,0	0,125	4	■
JS564120D2C.0Z4C-NXT	03067344	2	D	■	12,0	12,0	30,0	83,0	0,15	4	■
JS564160D2C.0Z4C-NXT	03067345	2	D	■	16,0	16,0	40,0	99,0	0,2	4	■
JS564200D2C.0Z4C-NXT	03067346	2	D	■	20,0	20,0	50,0	114,0	0,25	4	■
JS564060D3C.0Z4C-NXT	03067347	3	D	■	6,0	6,0	23,0	64,0	0,075	4	■
JS564080D3C.0Z4C-NXT	03067348	3	D	■	8,0	8,0	32,0	74,0	0,1	4	■
JS564100D3C.0Z4C-NXT	03067349	3	D	■	10,0	10,0	40,0	88,0	0,125	4	■
JS564120D3C.0Z4C-NXT	03067350	3	D	■	12,0	12,0	45,0	99,0	0,15	4	■
JS564160D3C.0Z4C-NXT	03067351	3	D	■	16,0	16,0	55,0	114,0	0,2	4	■
JS564200D3C.0Z4C-NXT	03067352	3	D	■	20,0	20,0	65,0	126,0	0,25	4	■

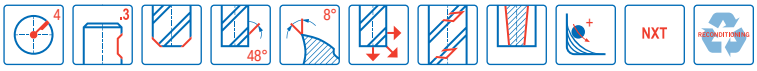
■ Prodotto standard.

JS564

Sgrossatura avanzata – Universale – Spallamento – 4 Eliche – Weldon – Smusso







- Tolleranze:
- DMM= h5
- DC= e7
- Rompitruciolo
- Riaffilatura possibile se DC è ≥Ø8

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS564030F2C.3Z4C-NXT	03067353	2	F	■	3,0	6,0	7,0	57,0	0,04	4	■
JS564040F2C.3Z4C-NXT	03067354	2	F	■	4,0	6,0	10,0	57,0	0,05	4	■
JS564050F2C.3Z4C-NXT	03067355	2	F	■	5,0	6,0	12,5	57,0	0,06	4	■
JS564060D2C.3Z4C-NXT	03067356	2	D	■	6,0	6,0	15,0	57,0	0,075	4	■
JS564080D2C.3Z4C-NXT	03067357	2	D	■	8,0	8,0	20,0	63,0	0,1	4	■
JS564100D2C.3Z4C-NXT	03067358	2	D	■	10,0	10,0	25,0	72,0	0,125	4	■
JS564120D2C.3Z4C-NXT	03067359	2	D	■	12,0	12,0	30,0	83,0	0,15	4	■
JS564160D2C.3Z4C-NXT	03067360	2	D	■	16,0	16,0	40,0	99,0	0,2	4	■
JS564200D2C.3Z4C-NXT	03067361	2	D	■	20,0	20,0	50,0	114,0	0,25	4	■
JS564060D3C.3Z4C-NXT	03067362	3	D	■	6,0	6,0	23,0	64,0	0,075	4	■
JS564080D3C.3Z4C-NXT	03067363	3	D	■	8,0	8,0	32,0	74,0	0,1	4	■
JS564100D3C.3Z4C-NXT	03067364	3	D	■	10,0	10,0	40,0	88,0	0,125	4	■
JS564120D3C.3Z4C-NXT	03067365	3	D	■	12,0	12,0	45,0	99,0	0,15	4	■
JS564160D3C.3Z4C-NXT	03067366	3	D	■	16,0	16,0	55,0	114,0	0,2	4	■
JS564200D3C.3Z4C-NXT	03067367	3	D	■	20,0	20,0	65,0	126,0	0,25	4	■

■ Prodotto standard.

Parametri di taglio – JS564 Contornatura sgrossatura avanzata

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
P1	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	305 (270 — 340) *1000 (890 — 1100)*
P2	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	295 (260 — 330) *970 (860 — 1000)*
P3	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (230 — 290) *850 (760 — 950)*
P4	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
P5	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	215 (190 — 240) *710 (630 — 780)*
P6	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	240 (210 — 270) *790 (690 — 880)*
P7	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
P8	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	215 (190 — 240) *710 (630 — 780)*
P11	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	200 (180 — 220) *660 (600 — 720)*
P12	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (120 — 140) *425 (400 — 450)*
M1	E	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	195 (170 — 210) *640 (560 — 680)*
M2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 170) *520 (460 — 550)*
M3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M5	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	110 (92 — 120) *360 (310 — 390)*
K1	E	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	260 (230 — 290) *850 (760 — 950)*
K2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
K3	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	195 (170 — 210) *640 (560 — 680)*
K4	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	185 (170 — 200) *610 (560 — 650)*
K5	E	0.150 *0,150*	2.4 *2,4*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	115 (99 — 120) *375 (330 — 390)*
K6	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	165 (150 — 180) *540 (500 — 590)*
K7	E	0.150 *0,150*	2.4 *2,4*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS564 Contornatura sgrossatura avanzata

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	700 (600 — 790) *2300 (2000 — 2500)*
N2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	450 (390 — 510) *1475 (1300 — 1600)*
N3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
N11	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	350 (300 — 390) *1150 (990 — 1200)*
S1	E	0.0300 *0,0300*	2.4 *2,4*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	60 (37 — 86) *195 (130 — 280)*
S2	E	0.0300 *0,0300*	2.4 *2,4*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	50 (30 — 69) *165 (99 — 220)*
S3	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	43 (26 — 60) *140 (86 — 190)*
S11	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
S12	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
H8	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H21	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H31	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.018 *0,00070*	0.024 *0,00095*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	125 (110 — 140) *410 (370 — 450)*

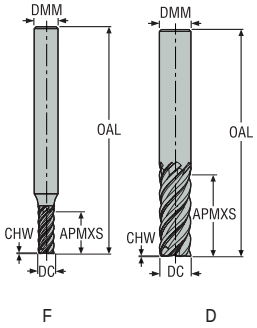
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

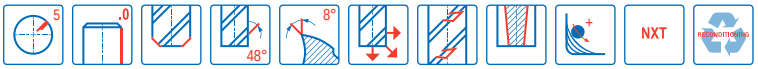
JS565

Sgrossatura avanzata – Universale – Spallamento – 5 Eliche – Cilindrico – Smusso





- Tolleranze:
- DMM= h5
- DC= e7
- PCEDC5= no rompitruciolo
- PCEDC5C= con rompitruciolo
- Riaffilatura possibile se DC è ≥Ø8

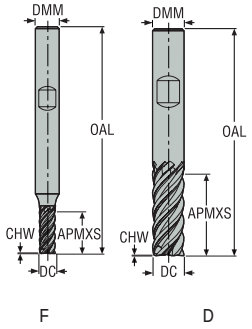


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm		
JS565040F2C.0Z5-NXT	03067369	2	F	–	4,0	6,0	10,0	57,0	0,05	5	■
JS565040F2C.0Z5C-NXT	03067378	2	F	■	4,0	6,0	10,0	57,0	0,05	5	■
JS565050F2C.0Z5-NXT	03067370	2	F	–	5,0	6,0	12,5	57,0	0,06	5	■
JS565050F2C.0Z5C-NXT	03067379	2	F	■	5,0	6,0	12,5	57,0	0,06	5	■
JS565060D2C.0Z5-NXT	03067371	2	D	–	6,0	6,0	15,0	57,0	0,075	5	■
JS565060D2C.0Z5C-NXT	03067380	2	D	■	6,0	6,0	15,0	57,0	0,075	5	■
JS565080D2C.0Z5-NXT	03067372	2	D	–	8,0	8,0	20,0	63,0	0,1	5	■
JS565080D2C.0Z5C-NXT	03067381	2	D	■	8,0	8,0	20,0	63,0	0,1	5	■
JS565100D2C.0Z5-NXT	03067373	2	D	–	10,0	10,0	25,0	72,0	0,125	5	■
JS565100D2C.0Z5C-NXT	03067382	2	D	■	10,0	10,0	25,0	72,0	0,125	5	■
JS565120D2C.0Z5-NXT	03067374	2	D	–	12,0	12,0	30,0	83,0	0,15	5	■
JS565120D2C.0Z5C-NXT	03067383	2	D	■	12,0	12,0	30,0	83,0	0,15	5	■
JS565160D2C.0Z5-NXT	03067375	2	D	–	16,0	16,0	40,0	99,0	0,2	5	■
JS565160D2C.0Z5C-NXT	03067384	2	D	■	16,0	16,0	40,0	99,0	0,2	5	■
JS565200D2C.0Z5-NXT	03067376	2	D	–	20,0	20,0	50,0	114,0	0,25	5	■
JS565200D2C.0Z5C-NXT	03067385	2	D	■	20,0	20,0	50,0	114,0	0,25	5	■
JS565060D3C.0Z5C-NXT	03067386	3	D	■	6,0	6,0	23,0	64,0	0,075	5	■
JS565080D3C.0Z5C-NXT	03067387	3	D	■	8,0	8,0	32,0	74,0	0,1	5	■
JS565100D3C.0Z5C-NXT	03067388	3	D	■	10,0	10,0	40,0	88,0	0,125	5	■
JS565120D3C.0Z5C-NXT	03067389	3	D	■	12,0	12,0	45,0	99,0	0,15	5	■
JS565160D3C.0Z5C-NXT	03067390	3	D	■	16,0	16,0	55,0	114,0	0,2	5	■
JS565200D3C.0Z5C-NXT	03067391	3	D	■	20,0	20,0	65,0	126,0	0,25	5	■

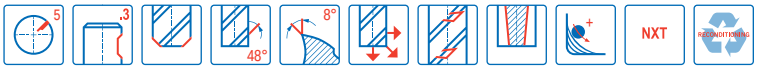
■ Prodotto standard.

JS565

Sgrossatura avanzata – Universale – Spallamento – 5 Eliche – Weldon – Smusso







- Tolleranze:
- DMM= h5
- DC= e7
- PCEDC5= no rompitruciolo
- PCEDC5C= con rompitruciolo
- Riaffilatura possibile se DC è ≥Ø8

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS565040F2C.3Z5-NXT	03067393	2	F	–	4,0	6,0	10,0	57,0	0,05	5	■
JS565040F2C.3Z5C-NXT	03067402	2	F	■	4,0	6,0	10,0	57,0	0,05	5	■
JS565050F2C.3Z5-NXT	03067394	2	F	–	5,0	6,0	12,5	57,0	0,06	5	■
JS565050F2C.3Z5C-NXT	03067403	2	F	■	5,0	6,0	12,5	57,0	0,06	5	■
JS565060D2C.3Z5-NXT	03067395	2	D	–	6,0	6,0	15,0	57,0	0,075	5	■
JS565060D2C.3Z5C-NXT	03067404	2	D	■	6,0	6,0	15,0	57,0	0,075	5	■
JS565080D2C.3Z5-NXT	03067396	2	D	–	8,0	8,0	20,0	63,0	0,1	5	■
JS565080D2C.3Z5C-NXT	03067405	2	D	■	8,0	8,0	20,0	63,0	0,1	5	■
JS565100D2C.3Z5-NXT	03067397	2	D	–	10,0	10,0	25,0	72,0	0,125	5	■
JS565100D2C.3Z5C-NXT	03067406	2	D	■	10,0	10,0	25,0	72,0	0,125	5	■
JS565120D2C.3Z5-NXT	03067398	2	D	–	12,0	12,0	30,0	83,0	0,15	5	■
JS565120D2C.3Z5C-NXT	03067407	2	D	■	12,0	12,0	30,0	83,0	0,15	5	■
JS565160D2C.3Z5-NXT	03067399	2	D	–	16,0	16,0	40,0	99,0	0,2	5	■
JS565160D2C.3Z5C-NXT	03067408	2	D	■	16,0	16,0	40,0	99,0	0,2	5	■
JS565200D2C.3Z5-NXT	03067400	2	D	–	20,0	20,0	50,0	114,0	0,25	5	■
JS565200D2C.3Z5C-NXT	03067409	2	D	■	20,0	20,0	50,0	114,0	0,25	5	■
JS565060D3C.3Z5C-NXT	03067410	3	D	■	6,0	6,0	23,0	64,0	0,075	5	■
JS565080D3C.3Z5C-NXT	03067411	3	D	■	8,0	8,0	32,0	74,0	0,1	5	■
JS565100D3C.3Z5C-NXT	03067412	3	D	■	10,0	10,0	40,0	88,0	0,125	5	■
JS565120D3C.3Z5C-NXT	03067413	3	D	■	12,0	12,0	45,0	99,0	0,15	5	■
JS565160D3C.3Z5C-NXT	03067414	3	D	■	16,0	16,0	55,0	114,0	0,2	5	■
JS565200D3C.3Z5C-NXT	03067415	3	D	■	20,0	20,0	65,0	126,0	0,25	5	■

■ Prodotto standard.

Parametri di taglio – JS565 Contornatura sgrossatura avanzata

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
P1	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	325 (270 — 340) *1075 (890 — 1100)*
P2	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	315 (260 — 330) *1025 (860 — 1000)*
P3	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	280 (230 — 290) *920 (760 — 950)*
P4	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
P5	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	230 (190 — 240) *750 (630 — 780)*
P6	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	260 (210 — 270) *850 (690 — 880)*
P7	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
P8	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	230 (190 — 240) *750 (630 — 780)*
P11	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	225 (190 — 230) *740 (630 — 750)*
P12	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	140 (120 — 140) *460 (400 — 450)*
M1	E	0.100 *0,100*	2.4 *2,4*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	205 (180 — 210) *670 (600 — 680)*
M2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	170 (140 — 170) *560 (460 — 550)*
M3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M5	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	110 (92 — 120) *360 (310 — 390)*
K1	E	0.100 *0,100*	2.4 *2,4*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	275 (230 — 290) *900 (760 — 950)*
K2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
K3	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	205 (170 — 210) *670 (560 — 680)*
K4	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	200 (170 — 200) *660 (560 — 650)*
K5	E	0.100 *0,100*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	120 (98 — 120) *395 (330 — 390)*
K6	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	175 (150 — 180) *570 (500 — 590)*
K7	E	0.100 *0,100*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	155 (130 — 160) *510 (430 — 520)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS565 Contornatura sgrossatura avanzata

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	740 (600 — 790) *2425 (2000 — 2500)*
N2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	475 (390 — 510) *1550 (1300 — 1600)*
N3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
N11	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	370 (300 — 390) *1225 (990 — 1200)*
S1	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	60 (38 — 86) *195 (130 — 280)*
S2	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	50 (30 — 70) *165 (99 — 220)*
S3	E	0.0300 *0,0300*	2.4 *2,4*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	43 (27 — 60) *140 (89 — 190)*
S11	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
S12	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
H8	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H21	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	155 (140 — 180) *510 (460 — 590)*
H31	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	120 (110 — 140) *395 (370 — 450)*

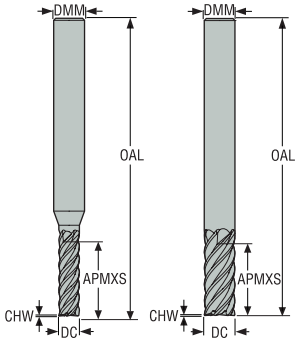
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

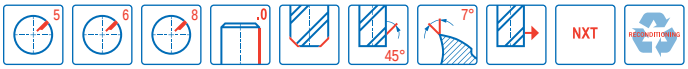
JS520

Alte prestazioni – Universale – Spallamento – 5-8 Eliche – Cilindrico – Smusso





- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile se DC è ≥Ø6

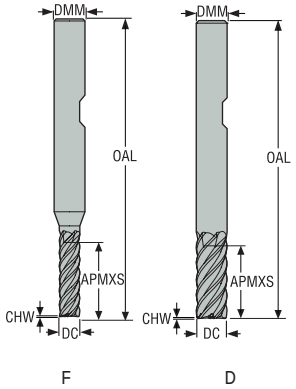


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JS520040F2C.0Z5-NXT	02927474	2	F	4,0	6,0	10,0	57,0	0,04	5	■
JS520050F2C.0Z5-NXT	02927476	2	F	5,0	6,0	12,0	57,0	0,05	5	■
JS520060D2C.0Z5-NXT	02927478	2	D	6,0	6,0	15,0	57,0	0,06	5	■
JS520060D2C.0Z6-NXT	02927479	2	D	6,0	6,0	15,0	57,0	0,06	6	■
JS520080D2C.0Z5-NXT	02927482	2	D	8,0	8,0	20,0	63,0	0,08	5	■
JS520080D2C.0Z6-NXT	02927483	2	D	8,0	8,0	20,0	63,0	0,08	6	■
JS520100D2C.0Z6-NXT	02927486	2	D	10,0	10,0	25,0	72,0	0,1	6	■
JS520120D2C.0Z6-NXT	02927488	2	D	12,0	12,0	25,0	83,0	0,12	6	■
JS520140D2C.0Z6-NXT	02927490	2	D	14,0	14,0	30,0	83,0	0,14	6	■
JS520160D2C.0Z6-NXT	02927491	2	D	16,0	16,0	30,0	92,0	0,16	6	■
JS520160D2C.0Z8-NXT	02927492	2	D	16,0	16,0	30,0	92,0	0,16	8	■
JS520200D2C.0Z8-NXT	02927495	2	D	20,0	20,0	35,0	104,0	0,2	8	■
JS520250D2C.0Z8-NXT	02927497	2	D	25,0	25,0	50,0	125,0	0,25	8	■
JS520040F3C.0Z5-NXT	02927475	3	F	4,0	6,0	15,0	57,0	0,04	5	■
JS520050F3C.0Z5-NXT	02927477	3	F	5,0	6,0	19,0	57,0	0,05	5	■
JS520060D3C.0Z5-NXT	02927480	3	D	6,0	6,0	20,0	63,0	0,06	5	■
JS520060D3C.0Z6-NXT	02927481	3	D	6,0	6,0	20,0	63,0	0,06	6	■
JS520080D3C.0Z5-NXT	02927484	3	D	8,0	8,0	30,0	80,0	0,08	5	■
JS520080D3C.0Z6-NXT	02927485	3	D	8,0	8,0	30,0	80,0	0,08	6	■
JS520100D3C.0Z6-NXT	02927487	3	D	10,0	10,0	40,0	89,0	0,1	6	■
JS520120D3C.0Z6-NXT	02927489	3	D	12,0	12,0	45,0	100,0	0,12	6	■
JS520160D3C.0Z6-NXT	02927493	3	D	16,0	16,0	65,0	125,0	0,16	6	■
JS520160D3C.0Z8-NXT	02927494	3	D	16,0	16,0	65,0	125,0	0,16	8	■
JS520200D3C.0Z8-NXT	02927496	3	D	20,0	20,0	65,0	125,0	0,2	8	■
JS520250D3C.0Z8-NXT	02927498	3	D	25,0	25,0	75,0	150,0	0,25	8	■

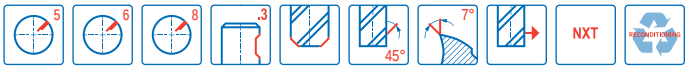
■ Prodotto standard.

JS520

Alte prestazioni – Universale – Spallamento – 5-8 Eliche – Weldon – Smusso







- Tolleranze:
- DMM=h5
- DC=e7
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS520040F2C.3Z5-NXT	02927499	2	F	4,0	6,0	10,0	57,0	0,04	5	☐
JS520050F2C.3Z5-NXT	02927501	2	F	5,0	6,0	12,0	57,0	0,05	5	☐
JS520060D2C.3Z5-NXT	02927503	2	D	6,0	6,0	15,0	57,0	0,06	5	☐
JS520060D2C.3Z6-NXT	02927504	2	D	6,0	6,0	15,0	57,0	0,06	6	☐
JS520080D2C.3Z5-NXT	02927507	2	D	8,0	8,0	20,0	63,0	0,08	5	☐
JS520080D2C.3Z6-NXT	02927508	2	D	8,0	8,0	20,0	63,0	0,08	6	☐
JS520100D2C.3Z6-NXT	02927511	2	D	10,0	10,0	25,0	72,0	0,1	6	☐
JS520120D2C.3Z6-NXT	02927513	2	D	12,0	12,0	25,0	83,0	0,12	6	☐
JS520140D2C.3Z6-NXT	02927515	2	D	14,0	14,0	30,0	83,0	0,14	6	☐
JS520160D2C.3Z6-NXT	02927516	2	D	16,0	16,0	30,0	92,0	0,16	6	☐
JS520160D2C.3Z8-NXT	02927517	2	D	16,0	16,0	30,0	92,0	0,16	8	■
JS520200D2C.3Z8-NXT	02927520	2	D	20,0	20,0	35,0	104,0	0,2	8	■
JS520250D2C.3Z8-NXT	02927522	2	D	25,0	25,0	50,0	125,0	0,25	8	☐
JS520040F3C.3Z5-NXT	02927500	3	F	4,0	6,0	15,0	57,0	0,04	5	☐
JS520050F3C.3Z5-NXT	02927502	3	F	5,0	6,0	19,0	57,0	0,05	5	☐
JS520060D3C.3Z5-NXT	02927505	3	D	6,0	6,0	20,0	63,0	0,06	5	☐
JS520060D3C.3Z6-NXT	02927506	3	D	6,0	6,0	20,0	63,0	0,06	6	☐
JS520080D3C.3Z5-NXT	02927509	3	D	8,0	8,0	30,0	80,0	0,08	5	☐
JS520080D3C.3Z6-NXT	02927510	3	D	8,0	8,0	30,0	80,0	0,08	6	☐
JS520100D3C.3Z6-NXT	02927512	3	D	10,0	10,0	40,0	89,0	0,1	6	☐
JS520120D3C.3Z6-NXT	02927514	3	D	12,0	12,0	45,0	100,0	0,12	6	☐
JS520160D3C.3Z6-NXT	02927518	3	D	16,0	16,0	65,0	125,0	0,16	6	☐
JS520160D3C.3Z8-NXT	02927519	3	D	16,0	16,0	65,0	125,0	0,16	8	☐
JS520200D3C.3Z8-NXT	02927521	3	D	20,0	20,0	65,0	125,0	0,2	8	☐
JS520250D3C.3Z8-NXT	02927523	3	D	25,0	25,0	75,0	150,0	0,25	8	☐

■ Prodotto standard. ☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

Parametri di taglio – JS520 Contornatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	180 (120 — 250) *590 (400 — 820)*
P2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (110 — 240) *570 (370 — 780)*
P3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (95 — 210) *510 (320 — 680)*
P4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	135 (84 — 180) *445 (280 — 590)*
P5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	130 (81 — 180) *425 (270 — 590)*
P6	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	145 (90 — 200) *475 (300 — 650)*
P7	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	140 (85 — 190) *460 (280 — 620)*
P8	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	130 (80 — 170) *425 (270 — 550)*
P11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.17 *0,0065*	0.20 *0,0080*	0.22 *0,0085*	195 (160 — 230) *640 (530 — 750)*
P12	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (100 — 140) *410 (330 — 450)*
M1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (130 — 180) *490 (430 — 590)*
M2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (100 — 150) *410 (330 — 490)*
M3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	100 (75 — 120) *330 (250 — 390)*
M4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (58 — 96) *245 (200 — 310)*
M5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	65 (49 — 80) *215 (170 — 260)*
K1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (110 — 240) *570 (370 — 780)*
K2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	155 (97 — 210) *510 (320 — 680)*
K3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	135 (82 — 180) *445 (270 — 590)*
K4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (79 — 170) *410 (260 — 550)*
K5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	75 (48 — 100) *245 (160 — 320)*
K6	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	110 (69 — 150) *360 (230 — 490)*
K7	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	100 (62 — 130) *330 (210 — 420)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS520 Contornatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*
N2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	320 (290 — 350) *1050 (960 — 1100)*
N3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	215 (200 — 230) *710 (660 — 750)*
N11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	75 (63 — 86) *245 (210 — 280)*
S2	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (50 — 70) *195 (170 — 220)*
S3	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	40 (30 — 49) *130 (99 — 160)*
S11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	105 (92 — 110) *345 (310 — 360)*
S12	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	80 (71 — 90) *260 (240 — 290)*
S13	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	65 (56 — 71) *215 (190 — 230)*
H5	M/A	0.0600 *0,0600*	2.0 *2,0*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (64 — 180) *410 (210 — 590)*
H8	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	130 (66 — 190) *425 (220 — 620)*
H11	M/A	0.0600 *0,0600*	2.0 *2,0*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	160 (81 — 240) *520 (270 — 780)*
H12	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	150 (76 — 220) *490 (250 — 720)*
H21	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	130 (66 — 190) *425 (220 — 620)*
H31	M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	100 (51 — 150) *330 (170 — 490)*
TS1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*
TP1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	395 (350 — 440) *1300 (1200 — 1400)*
GR1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*

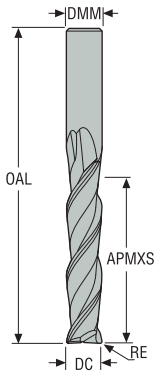
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS522

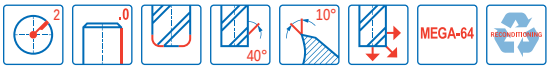
Alte prestazioni – Universale – Spallamento – 2 Eliche – Pareti alte – Cilindrico – Raggio di punta





D

- Tolleranze:
- Run-out= Ø6-Ø8 <0,01, Ø10-Ø12 <0,015, Ø16-Ø32 <0,02
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= 0,1+0,1 mm, RE= 0,5 ±0,03 mm
  RE= 3,1 ±0,05 mm, RE= 4 ±0,05 mm
  RE= 6 ±0,05 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
522060R010Z2.0-MEGA-64	02747756	4	D	6,0	6,0	30,0	80,0	0,1	2	■
522080R010Z2.0-MEGA-64	02747763	4	D	8,0	8,0	40,0	85,0	0,1	2	■
522100R010Z2.0-MEGA-64	02747765	4	D	10,0	10,0	50,0	100,0	0,1	2	■
522120R010Z2.0-MEGA-64	02747766	4	D	12,0	12,0	60,0	115,0	0,1	2	■
522160R050Z2.0-MEGA-64	02747767	4	D	16,0	16,0	80,0	150,0	0,5	2	■
522160R310Z2.0-MEGA-64	02747768	4	D	16,0	16,0	80,0	150,0	3,1	2	■
JS522160D4R600.0Z2-M64	03093681	4	D	16,0	16,0	80,0	150,0	6,0	2	■
522200R050Z2.0-MEGA-64	02747769	4	D	20,0	20,0	100,0	175,0	0,5	2	■
522200R310Z2.0-MEGA-64	02747770	4	D	20,0	20,0	100,0	175,0	3,1	2	■
JS522200D4R600.0Z2-M64	03093682	4	D	20,0	20,0	100,0	175,0	6,0	2	■
522250R050Z2.0-MEGA-64	02747771	4	D	25,0	25,0	125,0	205,0	0,5	2	■
522250R310Z2.0-MEGA-64	02747772	4	D	25,0	25,0	125,0	205,0	3,1	2	■
522250R400Z2.0-MEGA-64	02747773	4	D	25,0	25,0	125,0	205,0	4,0	2	■
JS522250D4R600.0Z2-M64	03093683	4	D	25,0	25,0	125,0	205,0	6,0	2	■
522320R050Z2.0-MEGA-64	02747774	4	D	32,0	32,0	160,0	245,0	0,5	2	■
522320R400Z2.0-MEGA-64	02747775	4	D	32,0	32,0	160,0	245,0	4,0	2	■
JS522320D4R600.0Z2-M64	03093684	4	D	32,0	32,0	160,0	245,0	6,0	2	■

■ Prodotto standard.

*JS522 long flute finisher, with its special geometry designed to machine high shoulders with exellent surface finish and perpendicularity.

Parametri di taglio – JS522 Contornatura semifinitura

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	16	20	25	32	
P1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	160 (140 — 170) *520 (460 — 550)*
P2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	155 (140 — 170) *510 (460 — 550)*
P3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	120 (110 — 140) *395 (370 — 450)*
P7	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	115 (95 — 130) *375 (320 — 420)*
P8	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	105 (89 — 120) *345 (300 — 390)*
P11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	0.22 *0,0085*	105 (87 — 120) *345 (290 — 390)*
P12	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	65 (55 — 75) *215 (190 — 240)*
M1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	110 (86 — 130) *360 (290 — 420)*
M2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	90 (71 — 110) *295 (240 — 360)*
M3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	80 (61 — 100) *260 (210 — 320)*
M4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	60 (47 — 76) *195 (160 — 240)*
M5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	50 (39 — 63) *165 (130 — 200)*
K1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	120 (100 — 130) *395 (330 — 420)*
K2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	105 (87 — 120) *345 (290 — 390)*
K3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	90 (74 — 100) *295 (250 — 320)*
K4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	85 (71 — 98) *280 (240 — 320)*
K5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	100 (81 — 120) *330 (270 — 390)*
K6	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	150 (120 — 170) *490 (400 — 550)*
K7	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	130 (110 — 150) *425 (370 — 490)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS522 Contornatura semifinitura

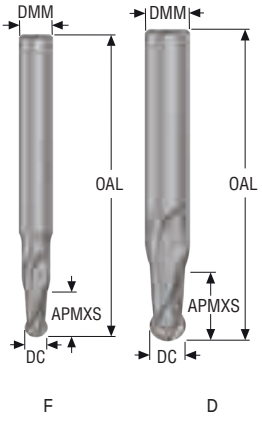
SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	16	20	25	32	
N1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	400 (310 — 500) *1300 (1100 — 1600)*
N2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	300 (210 — 400) *980 (690 — 1300)*
N3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	200 (140 — 260) *660 (460 — 850)*
N11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	300 (260 — 350) *980 (860 — 1100)*
S1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	48 (39 — 57) *155 (130 — 180)*
S2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	39 (31 — 46) *130 (110 — 150)*
S3	E/M/A	0.0300 *0,0300*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	42 (32 — 51) *140 (110 — 160)*
S11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	125 (100 — 140) *410 (330 — 450)*
S12	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	95 (77 — 110) *310 (260 — 360)*
S13	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (61 — 90) *245 (210 — 290)*
TS1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	500 (410 — 600) *1650 (1400 — 1900)*
TP1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	400 (310 — 500) *1300 (1100 — 1600)*
GR1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	500 (410 — 600) *1650 (1400 — 1900)*

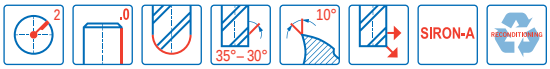
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JSB512

Uso generico – Universale – A testa sferica – 2 Eliche – Cilindrico







- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø10

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
					mm	mm	mm	mm		
JSB512020F2B.0Z2	SIRA	10053561	2	F	2,0	3,0	3,0	40,0	2	■
JSB512030D2B.0Z2	SIRA	10053562	2	D	3,0	3,0	5,0	40,0	2	■
JSB512040D2B.0Z2	SIRA	10053563	2	D	4,0	4,0	6,0	50,0	2	■
JSB512050F2B.0Z2	SIRA	10053564	2	F	5,0	6,0	8,0	57,0	2	■
JSB512060D2B.0Z2	SIRA	10053565	2	D	6,0	6,0	9,0	57,0	2	■
JSB512080D2B.0Z2	SIRA	10053566	2	D	8,0	8,0	12,0	63,0	2	■
JSB512100D2B.0Z2	SIRA	10053567	2	D	10,0	10,0	15,0	72,0	2	■
JSB512120D2B.0Z2	SIRA	10053568	2	D	12,0	12,0	18,0	83,0	2	■

■ Prodotto standard.

Parametri di taglio – JSB512 Copiatura sgrossatura

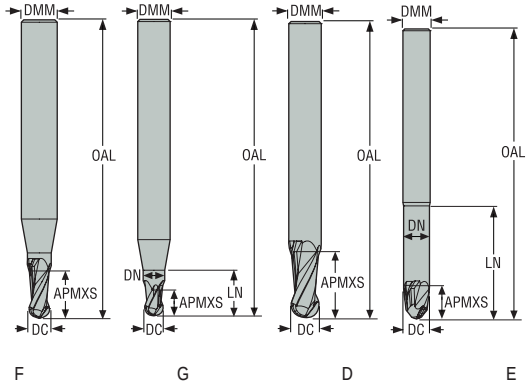
SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P2	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P3	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P4	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P5	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P6	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P7	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P8	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P11	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
P12	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M1	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M2	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M3	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M4	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M5	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
K1	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K2	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K3	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K4	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K5	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K6	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K7	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
N1	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	500 (380 — 620) *1650 (1300 — 2000)*
N11	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	375 (260 — 500) *1225 (860 — 1600)*
S11	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (66 — 130) *295 (220 — 420)*
S12	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
S13	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

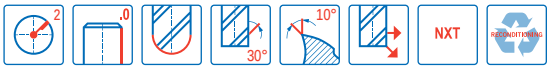
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS532

Alte prestazioni – Universale – A testa sferica – 2 Eliche – Cilindrico







- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6

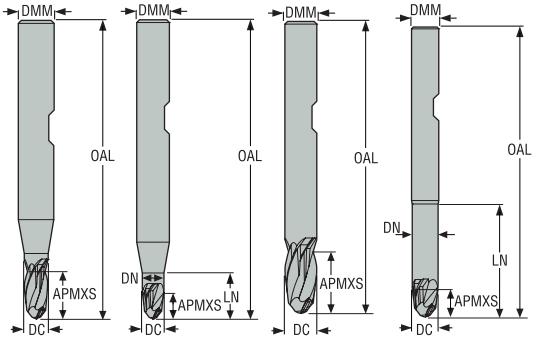
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS532010F1B.0Z2-NXT	02928193	1	F	1,0	3,0	2,0	38,0	3,1	1,0	0,5	2	■
JS532015F1B.0Z2-NXT	02928194	1	F	1,5	3,0	3,0	38,0	4,6	1,5	0,75	2	■
JS532020F1B.0Z2-NXT	02928195	1	F	2,0	3,0	4,0	38,0	6,1	2,0	1,0	2	■
JS532025F1B.0Z2-NXT	02928197	1	F	2,5	3,0	5,0	38,0	7,1	2,5	1,25	2	■
JS532030D1B.0Z2-NXT	02928199	1	D	3,0	3,0	6,0	38,0	–	–	1,5	2	■
JS532035F1B.0Z2-NXT	02928202	1	F	3,5	6,0	7,0	57,0	9,6	3,5	1,75	2	■
JS532040F1B.0Z2-NXT	02928203	1	F	4,0	6,0	8,0	57,0	10,75	4,0	2,0	2	■
JS532045F1B.0Z2-NXT	02928206	1	F	4,5	6,0	9,0	57,0	11,75	4,5	2,25	2	■
JS532050F1B.0Z2-NXT	02928207	1	F	5,0	6,0	10,0	57,0	12,75	5,0	2,5	2	■
JS532060D1B.0Z2-NXT	02928210	1	D	6,0	6,0	12,0	57,0	–	–	3,0	2	■
JS532080D1B.0Z2-NXT	02928213	1	D	8,0	8,0	16,0	63,0	–	–	4,0	2	■
JS532100D1B.0Z2-NXT	02928216	1	D	10,0	10,0	20,0	72,0	–	–	5,0	2	■
JS532120D1B.0Z2-NXT	02928219	1	D	12,0	12,0	24,0	83,0	–	–	6,0	2	■
JS532160D1B.0Z2-NXT	02928222	1	D	16,0	16,0	32,0	92,0	–	–	8,0	2	■
JS532200D1B.0Z2-NXT	02928225	1	D	20,0	20,0	40,0	104,0	–	–	10,0	2	■
JS532020G2B.0Z2-NXT	02928196	2	G	2,0	3,0	2,0	38,0	8,0	1,9	1,0	2	■
JS532030E2B.0Z2-NXT	02928200	2	E	3,0	3,0	3,0	38,0	10,0	2,85	1,5	2	■
JS532040G2B.0Z2-NXT	02928204	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	2	■
JS532050G2B.0Z2-NXT	02928208	2	G	5,0	6,0	5,0	57,0	20,0	4,8	2,5	2	■
JS532060E2B.0Z2-NXT	02928211	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	2	■
JS532080E2B.0Z2-NXT	02928214	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	2	■
JS532100E2B.0Z2-NXT	02928217	2	E	10,0	10,0	10,0	82,0	40,0	9,5	5,0	2	■
JS532120E2B.0Z2-NXT	02928220	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	2	■
JS532160E2B.0Z2-NXT	02928223	2	E	16,0	16,0	16,0	125,0	72,0	15,2	8,0	2	■
JS532030E3B.0Z2-NXT	02928201	3	E	3,0	3,0	3,0	52,0	20,0	2,85	1,5	2	■
JS532040G3B.0Z2-NXT	02928205	3	G	4,0	6,0	4,0	63,0	24,0	3,8	2,0	2	■
JS532050G3B.0Z2-NXT	02928209	3	G	5,0	6,0	5,0	75,0	35,0	4,8	2,5	2	■
JS532060E3B.0Z2-NXT	02928212	3	E	6,0	6,0	6,0	80,0	42,0	5,7	3,0	2	■
JS532080E3B.0Z2-NXT	02928215	3	E	8,0	8,0	8,0	100,0	60,0	7,6	4,0	2	■
JS532100E3B.0Z2-NXT	02928218	3	E	10,0	10,0	10,0	125,0	80,0	9,5	5,0	2	■
JS532120E3B.0Z2-NXT	02928221	3	E	12,0	12,0	12,0	125,0	75,0	11,4	6,0	2	■
JS532160E3B.0Z2-NXT	02928224	3	E	16,0	16,0	16,0	150,0	100,0	15,2	8,0	2	■

■ Prodotto standard.

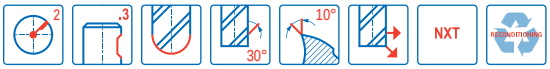
JS532

Alte prestazioni – Universale – A testa sferica – 2 Eliche – Weldon





- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS532035F1B.3Z2-NXT	02928254	1	F	3,5	6,0	7,0	57,0	9,6	3,5	1,75	2	☐
JS532040F1B.3Z2-NXT	02928255	1	F	4,0	6,0	8,0	57,0	10,75	4,0	2,0	2	☐
JS532045F1B.3Z2-NXT	02928258	1	F	4,5	6,0	9,0	57,0	11,75	4,5	2,25	2	☐
JS532050F1B.3Z2-NXT	02928259	1	F	5,0	6,0	10,0	57,0	12,75	5,0	2,5	2	☐
JS532060D1B.3Z2-NXT	02928263	1	D	6,0	6,0	12,0	57,0	–	–	3,0	2	☐
JS532080D1B.3Z2-NXT	02928266	1	D	8,0	8,0	16,0	63,0	–	–	4,0	2	☐
JS532100D1B.3Z2-NXT	02928269	1	D	10,0	10,0	20,0	72,0	–	–	5,0	2	☐
JS532120D1B.3Z2-NXT	02928272	1	D	12,0	12,0	24,0	83,0	–	–	6,0	2	☐
JS532160D1B.3Z2-NXT	02928275	1	D	16,0	16,0	32,0	92,0	–	–	8,0	2	☐
JS532200D1B.3Z2-NXT	02928278	1	D	20,0	20,0	40,0	104,0	–	–	10,0	2	☐
JS532040G2B.3Z2-NXT	02928256	2	G	4,0	6,0	4,0	57,0	18,0	3,8	2,0	2	☐
JS532050G2B.3Z2-NXT	02928260	2	G	5,0	6,0	5,0	57,0	18,0	4,8	2,5	2	☐
JS532060E2B.3Z2-NXT	02928264	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	2	☐
JS532080E2B.3Z2-NXT	02928267	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	2	☐
JS532100E2B.3Z2-NXT	02928270	2	E	10,0	10,0	10,0	82,0	40,0	9,5	5,0	2	☐
JS532120E2B.3Z2-NXT	02928273	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	2	☐
JS532160E2B.3Z2-NXT	02928276	2	E	16,0	16,0	16,0	125,0	70,0	15,2	8,0	2	☐
JS532040G3B.3Z2-NXT	02928257	3	G	4,0	6,0	4,0	63,0	24,0	3,8	2,0	2	☐
JS532050G3B.3Z2-NXT	02928261	3	G	5,0	6,0	5,0	75,0	35,0	4,8	2,5	2	☐
JS532060E3B.3Z2-NXT	02928265	3	E	6,0	6,0	6,0	80,0	42,0	5,7	3,0	2	☐
JS532080E3B.3Z2-NXT	02928268	3	E	8,0	8,0	8,0	100,0	60,0	7,6	4,0	2	☐
JS532100E3B.3Z2-NXT	02928271	3	E	10,0	10,0	10,0	125,0	80,0	9,5	5,0	2	☐
JS532120E3B.3Z2-NXT	02928274	3	E	12,0	12,0	12,0	125,0	75,0	11,4	6,0	2	☐
JS532160E3B.3Z2-NXT	02928277	3	E	16,0	16,0	16,0	150,0	100,0	15,2	8,0	2	☐

☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

Parametri di taglio – JS532 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	205 (140 — 180) *670 (460 — 590)*
P2	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	200 (130 — 180) *660 (430 — 590)*
P3	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	170 (110 — 150) *560 (370 — 490)*
P4	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.10 *0,0040*	150 (97 — 130) *490 (320 — 420)*
P5	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	145 (93 — 130) *475 (310 — 420)*
P6	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	160 (110 — 140) *520 (370 — 450)*
P7	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (98 — 140) *490 (330 — 450)*
P8	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	145 (93 — 130) *475 (310 — 420)*
P11	M/A/D/E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	170 (110 — 150) *560 (370 — 490)*
P12	M/A/D/E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	100 (64 — 92) *330 (210 — 300)*
M1	E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	195 (170 — 220) *640 (560 — 720)*
M2	E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	115 (93 — 130) *375 (310 — 420)*
M3	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	95 (73 — 110) *310 (240 — 360)*
M4	E	0.100 *0,100*	0.10 *0,10*	0.0048 *0,00019*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	70 (55 — 85) *230 (190 — 270)*
M5	E	0.100 *0,100*	0.10 *0,10*	0.0048 *0,00019*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	60 (46 — 71) *195 (160 — 230)*
K1	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	195 (180 — 210) *640 (600 — 680)*
K2	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	170 (160 — 180) *560 (530 — 590)*
K3	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	145 (130 — 150) *475 (430 — 490)*
K4	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	140 (130 — 150) *460 (430 — 490)*
K5	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	165 (150 — 180) *540 (500 — 590)*
K6	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	245 (220 — 270) *800 (730 — 880)*
K7	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	210 (190 — 230) *690 (630 — 750)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS532 Copiatura sgrossatura

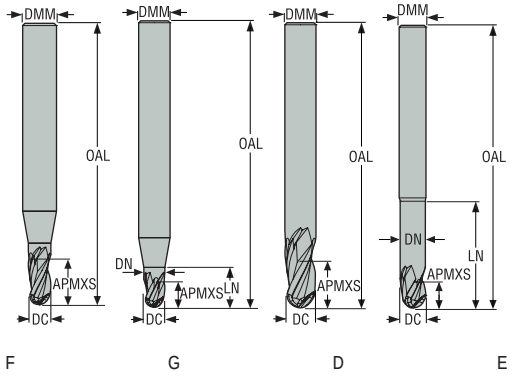
SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	610 (520 — 710) *2000 (1800 — 2300)*
N2	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	395 (330 — 450) *1300 (1100 — 1400)*
N3	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	260 (220 — 300) *850 (730 — 980)*
N11	E	0.200 *0,200*	0.30 *0,30*	0.0050 *0,00020*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	415 (370 — 460) *1350 (1300 — 1500)*
S1	E	0.150 *0,150*	0.10 *0,10*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	60 (52 — 72) *195 (180 — 230)*
S2	E	0.150 *0,150*	0.10 *0,10*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	50 (42 — 58) *165 (140 — 190)*
S3	E	0.100 *0,100*	0.10 *0,10*	0.0036 *0,00014*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.018 *0,00070*	0.020 *0,00080*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	32 (22 — 42) *105 (73 — 130)*
S11	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	105 (94 — 110) *345 (310 — 360)*
S12	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	80 (72 — 92) *260 (240 — 300)*
S13	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.080 *0,0032*	0.090 *0,0036*	65 (57 — 72) *215 (190 — 230)*
TS1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*
TP1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*
GR1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

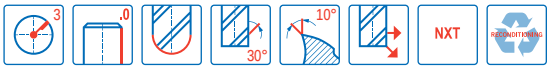
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS533

Alte prestazioni – Universale – A testa sferica – 3 Eliche – Cilindrico







- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6

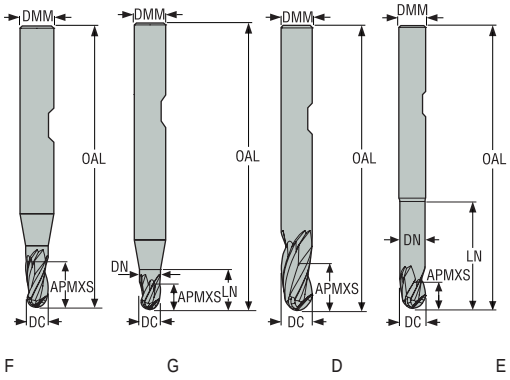
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS533010F1B.0Z3-NXT	02928284	1	F	1,0	3,0	2,0	38,0	3,0	1,05	0,5	3	■
JS533015F1B.0Z3-NXT	02928286	1	F	1,5	3,0	3,0	38,0	4,6	1,55	0,75	3	■
JS533020F1B.0Z3-NXT	02928287	1	F	2,0	3,0	4,0	38,0	5,6	2,05	1,0	3	■
JS533030D1B.0Z3-NXT	02928289	1	D	3,0	3,0	6,0	38,0	–	–	1,5	3	■
JS533040F1B.0Z3-NXT	02928291	1	F	4,0	6,0	8,0	57,0	10,75	4,05	2,0	3	■
JS533050F1B.0Z3-NXT	02928293	1	F	5,0	6,0	10,0	57,0	13,75	5,05	2,5	3	■
JS533060D1B.0Z3-NXT	02928295	1	D	6,0	6,0	12,0	57,0	–	–	3,0	3	■
JS533080D1B.0Z3-NXT	02928297	1	D	8,0	8,0	16,0	63,0	–	–	4,0	3	■
JS533100D1B.0Z3-NXT	02928299	1	D	10,0	10,0	20,0	72,0	–	–	5,0	3	■
JS533120D1B.0Z3-NXT	02928301	1	D	12,0	12,0	24,0	83,0	–	–	6,0	3	■
JS533160D1B.0Z3-NXT	02928303	1	D	16,0	16,0	32,0	110,0	–	–	8,0	3	■
JS533200D1B.0Z3-NXT	02928305	1	D	20,0	20,0	40,0	125,0	–	–	10,0	3	■
JS533020G2B.0Z3-NXT	02928288	2	G	2,0	3,0	2,0	38,0	7,0	1,9	1,0	3	■
JS533030E2B.0Z3-NXT	02928290	2	E	3,0	3,0	3,0	38,0	9,0	2,85	1,5	3	■
JS533040G2B.0Z3-NXT	02928292	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	3	■
JS533050G2B.0Z3-NXT	02928294	2	G	5,0	6,0	5,0	57,0	15,0	4,8	2,5	3	■
JS533060E2B.0Z3-NXT	02928296	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	3	■
JS533080E2B.0Z3-NXT	02928298	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	3	■
JS533100E2B.0Z3-NXT	02928300	2	E	10,0	10,0	10,0	89,0	40,0	9,5	5,0	3	■
JS533120E2B.0Z3-NXT	02928302	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	3	■
JS533160E2B.0Z3-NXT	02928304	2	E	16,0	16,0	16,0	125,0	70,0	15,2	8,0	3	■

■ Prodotto standard.

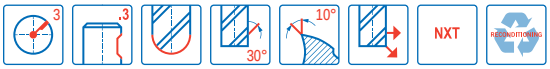
JS533

Alte prestazioni – Universale – A testa sferica – 3 Eliche – Weldon





- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS533040F1B.3Z3-NXT	02928323	1	F	4,0	6,0	8,0	57,0	10,75	4,05	2,0	3	☐
JS533050F1B.3Z3-NXT	02928325	1	F	5,0	6,0	10,0	57,0	13,75	5,05	2,5	3	☐
JS533060D1B.3Z3-NXT	02928326	1	D	6,0	6,0	12,0	57,0	–	–	3,0	3	☐
JS533080D1B.3Z3-NXT	02928328	1	D	8,0	8,0	16,0	63,0	–	–	4,0	3	☐
JS533100D1B.3Z3-NXT	02928330	1	D	10,0	10,0	20,0	72,0	–	–	5,0	3	☐
JS533120D1B.3Z3-NXT	02928332	1	D	12,0	12,0	24,0	83,0	–	–	6,0	3	☐
JS533160D1B.3Z3-NXT	02928334	1	D	16,0	16,0	32,0	109,0	–	–	8,0	3	☐
JS533200D1B.3Z3-NXT	02928336	1	D	20,0	20,0	40,0	125,0	–	–	10,0	3	☐
JS533040G2B.3Z3-NXT	02928324	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	3	☐
JS533050G2B.3Z3-NXT	02928341	2	G	5,0	6,0	5,0	57,0	15,0	4,8	2,5	3	☐
JS533060E2B.3Z3-NXT	02928327	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	3	☐
JS533080E2B.3Z3-NXT	02928329	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	3	☐
JS533100E2B.3Z3-NXT	02928331	2	E	10,0	10,0	10,0	89,0	40,0	9,5	5,0	3	☐
JS533120E2B.3Z3-NXT	02928333	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	3	☐
JS533160E2B.3Z3-NXT	02928335	2	E	16,0	16,0	16,0	122,0	70,0	15,2	8,0	3	☐

☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

Parametri di taglio – JS533 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	200 (180 — 220) *660 (600 — 720)*
P2	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0034 *0,00013*	0.0065 *0,00026*	0.010 *0,00040*	0.013 *0,00050*	0.017 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	195 (170 — 220) *640 (560 — 720)*
P3	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0060 *0,00024*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	165 (150 — 180) *540 (500 — 590)*
P4	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	140 (130 — 160) *460 (430 — 520)*
P6	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	150 (130 — 160) *490 (430 — 520)*
P8	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0060 *0,00024*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	140 (120 — 150) *460 (400 — 490)*
P11	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	140 (130 — 160) *460 (430 — 520)*
P12	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	85 (73 — 97) *280 (240 — 310)*
M1	E	0.0300 *0,0300*	0.80 *0,80*	0.0034 *0,00013*	0.0065 *0,00026*	0.010 *0,00040*	0.013 *0,00050*	0.017 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	125 (99 — 140) *410 (330 — 450)*
M2	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (80 — 120) *330 (270 — 390)*
M3	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	70 (50 — 90) *230 (170 — 290)*
M4	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	55 (38 — 67) *180 (130 — 210)*
M5	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	44 (32 — 56) *145 (110 — 180)*
K1	E	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	145 (130 — 160) *475 (430 — 520)*
K2	E	0.0300 *0,0300*	0.80 *0,80*	0.0036 *0,00014*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	125 (110 — 140) *410 (370 — 450)*
K3	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	105 (91 — 110) *345 (300 — 360)*
K4	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	120 (100 — 140) *395 (330 — 450)*
K5	E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	70 (61 — 84) *230 (210 — 270)*
K6	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	105 (89 — 120) *345 (300 — 390)*
K7	E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	155 (130 — 180) *510 (430 — 590)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS533 Copiatura sgrossatura

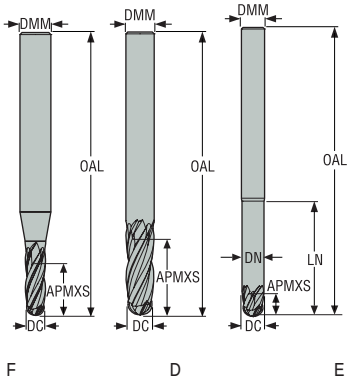
SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	800 (700 — 900) *2625 (2300 — 2900)*
N2	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	510 (450 — 570) *1675 (1500 — 1800)*
N3	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	345 (300 — 380) *1125 (990 — 1200)*
N11	E	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (90 — 110) *330 (300 — 360)*
S2	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	80 (73 — 88) *260 (240 — 280)*
S11	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	130 (120 — 140) *425 (400 — 450)*
S12	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (91 — 110) *330 (300 — 360)*
S13	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	80 (70 — 85) *260 (230 — 270)*
TS1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*
TP1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*
GR1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

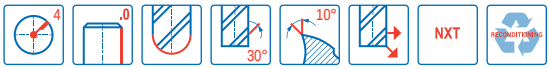
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS534

Alte prestazioni – Universale – A testa sferica – 4 Eliche – Cilindrico







- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6

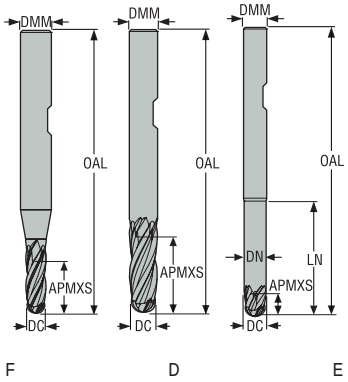
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS534020F1B.0Z4-NXT	02928366	1	F	2,0	3,0	6,0	38,0	6,7	2,05	1,0	4	■
JS534030D1B.0Z4-NXT	02928367	1	D	3,0	3,0	9,0	38,0	–	–	1,5	4	■
JS534040F1B.0Z4-NXT	02928368	1	F	4,0	6,0	12,0	57,0	14,0	4,05	2,0	4	■
JS534050F1B.0Z4-NXT	02928370	1	F	5,0	6,0	15,0	57,0	17,0	5,05	2,5	4	■
JS534060D1B.0Z4-NXT	02928372	1	D	6,0	6,0	18,0	57,0	–	–	3,0	4	■
JS534080D1B.0Z4-NXT	02928375	1	D	8,0	8,0	24,0	69,0	–	–	4,0	4	■
JS534100D1B.0Z4-NXT	02928378	1	D	10,0	10,0	30,0	82,0	–	–	5,0	4	■
JS534120D1B.0Z4-NXT	02928381	1	D	12,0	12,0	36,0	100,0	–	–	6,0	4	■
JS534160D1B.0Z4-NXT	02928384	1	D	16,0	16,0	48,0	110,0	–	–	8,0	4	■
JS534200D1B.0Z4-NXT	02928387	1	D	20,0	20,0	60,0	125,0	–	–	10,0	4	■
JS534040F2B.0Z4-NXT	02928369	2	F	4,0	6,0	20,0	63,0	22,0	4,05	2,0	4	■
JS534050F2B.0Z4-NXT	02928371	2	F	5,0	6,0	25,0	75,0	27,0	5,05	2,5	4	■
JS534060D2B.0Z4-NXT	02928373	2	D	6,0	6,0	30,0	75,0	–	–	3,0	4	■
JS534080D2B.0Z4-NXT	02928376	2	D	8,0	8,0	40,0	80,0	–	–	4,0	4	■
JS534100D2B.0Z4-NXT	02928379	2	D	10,0	10,0	50,0	100,0	–	–	5,0	4	■
JS534120D2B.0Z4-NXT	02928382	2	D	12,0	12,0	60,0	125,0	–	–	6,0	4	■
JS534160D2B.0Z4-NXT	02928385	2	D	16,0	16,0	80,0	130,0	–	–	8,0	4	■
JS534060E3B.0Z4-NXT	02928374	3	E	6,0	6,0	6,0	75,0	30,0	5,7	3,0	4	■
JS534080E3B.0Z4-NXT	02928377	3	E	8,0	8,0	8,0	80,0	40,0	7,6	4,0	4	■
JS534100E3B.0Z4-NXT	02928380	3	E	10,0	10,0	10,0	100,0	50,0	9,7	5,0	4	■
JS534120E3B.0Z4-NXT	02928383	3	E	12,0	12,0	12,0	125,0	60,0	11,4	6,0	4	■
JS534160E3B.0Z4-NXT	02928386	3	E	16,0	16,0	16,0	130,0	80,0	15,2	8,0	4	■
JS534200E3B.0Z4-NXT	02928388	3	E	20,0	20,0	20,0	150,0	100,0	19,0	10,0	4	■

■ Prodotto standard.

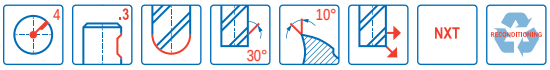
JS534

Alte prestazioni – Universale – A testa sferica – 4 Eliche – Weldon





- Tolleranze:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS534040F1B.3Z4-NXT	02928390	1	F	4,0	6,0	12,0	57,0	14,0	4,05	2,0	4	☐
JS534050F1B.3Z4-NXT	02928392	1	F	5,0	6,0	15,0	57,0	17,0	5,05	2,5	4	☐
JS534060D1B.3Z4-NXT	02928394	1	D	6,0	6,0	18,0	57,0	–	–	3,0	4	☐
JS534080D1B.3Z4-NXT	02928397	1	D	8,0	8,0	24,0	69,0	–	–	4,0	4	☐
JS534100D1B.3Z4-NXT	02928400	1	D	10,0	10,0	30,0	82,0	–	–	5,0	4	☐
JS534120D1B.3Z4-NXT	02928403	1	D	12,0	12,0	36,0	100,0	–	–	6,0	4	☐
JS534160D1B.3Z4-NXT	02928406	1	D	16,0	16,0	48,0	110,0	–	–	8,0	4	☐
JS534200D1B.3Z4-NXT	02928409	1	D	20,0	20,0	60,0	125,0	–	–	10,0	4	☐
JS534040F2B.3Z4-NXT	02928391	2	F	4,0	6,0	20,0	63,0	22,0	4,05	2,0	4	☐
JS534050F2B.3Z4-NXT	02928393	2	F	5,0	6,0	25,0	75,0	27,0	5,05	2,5	4	☐
JS534060D2B.3Z4-NXT	02928395	2	D	6,0	6,0	30,0	75,0	–	–	3,0	4	☐
JS534080D2B.3Z4-NXT	02928398	2	D	8,0	8,0	40,0	80,0	–	–	4,0	4	☐
JS534100D2B.3Z4-NXT	02928401	2	D	10,0	10,0	50,0	100,0	–	–	5,0	4	☐
JS534120D2B.3Z4-NXT	02928404	2	D	12,0	12,0	60,0	125,0	–	–	6,0	4	☐
JS534160D2B.3Z4-NXT	02928407	2	D	16,0	16,0	80,0	130,0	–	–	8,0	4	☐
JS534060E3B.3Z4-NXT	02928396	3	E	6,0	6,0	6,0	75,0	30,0	5,7	3,0	4	☐
JS534080E3B.3Z4-NXT	02928399	3	E	8,0	8,0	8,0	80,0	40,0	7,6	4,0	4	☐
JS534100E3B.3Z4-NXT	02928402	3	E	10,0	10,0	10,0	100,0	50,0	9,7	5,0	4	☐
JS534120E3B.3Z4-NXT	02928405	3	E	12,0	12,0	12,0	125,0	60,0	11,4	6,0	4	☐
JS534160E3B.3Z4-NXT	02928408	3	E	16,0	16,0	16,0	130,0	80,0	15,2	8,0	4	☐
JS534200E3B.3Z4-NXT	02928410	3	E	20,0	20,0	20,0	150,0	100,0	19,0	10,0	4	☐

☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

Parametri di taglio – JS534 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	345 (310 — 370) *1125 (1100 — 1200)*
P2	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	335 (300 — 360) *1100 (990 — 1100)*
P3	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.012 *0,00048*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	290 (260 — 310) *950 (860 — 1000)*
P4	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	255 (230 — 280) *840 (760 — 910)*
P5	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	245 (220 — 260) *800 (730 — 850)*
P6	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	230 (210 — 250) *750 (690 — 820)*
P7	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	220 (200 — 240) *720 (660 — 780)*
P8	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.012 *0,00048*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	205 (190 — 220) *670 (630 — 720)*
P11	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	210 (190 — 230) *690 (630 — 750)*
P12	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	125 (120 — 130) *410 (400 — 420)*
M1	E	0.0300 *0,0300*	4.0 *4,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
M2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (130 — 160) *475 (430 — 520)*
M3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (140 — 180) *510 (460 — 590)*
M4	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	120 (100 — 130) *395 (330 — 420)*
M5	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	100 (83 — 110) *330 (280 — 360)*
K1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	245 (220 — 260) *800 (730 — 850)*
K2	E	0.0300 *0,0300*	4.0 *4,0*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	215 (200 — 230) *710 (660 — 750)*
K3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	180 (160 — 190) *590 (530 — 620)*
K4	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	170 (160 — 180) *560 (530 — 590)*
K5	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	200 (180 — 220) *660 (600 — 720)*
K6	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	295 (260 — 330) *970 (860 — 1000)*
K7	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	260 (230 — 280) *850 (760 — 910)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS534 Copiatura sgrossatura

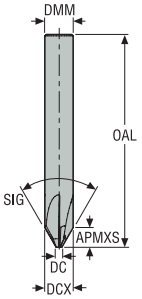
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	1025 (910 — 1100) *3375 (3000 — 3600)*
N2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	910 (780 — 1000) *2975 (2600 — 3200)*
N3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	600 (520 — 690) *1975 (1800 — 2200)*
N11	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	500 (440 — 560) *1650 (1500 — 1800)*
S1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	110 (88 — 110) *360 (290 — 360)*
S2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	90 (71 — 90) *295 (240 — 290)*
S3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (63 — 87) *280 (210 — 280)*
S11	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	185 (150 — 180) *610 (500 — 590)*
S12	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	140 (120 — 140) *460 (400 — 450)*
S13	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	110 (91 — 110) *360 (300 — 360)*
TS1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*
TP1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*
GR1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS506

Uso generico – Universale – Smusso – 3-4 Eliche – Cilindrico



N





- Tolleranze:
- DMM=h5
- SIG= ±0,5°
- Riaffilatura possibile se DMM è ≥Ø6

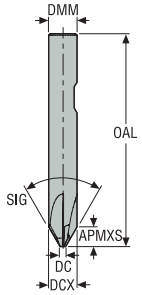
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm			
JS506030N2CZ3.0-SIRA	02881622	2	N	0,6	3,0	3,0	2,0	50,0	60,0	3	■
JS506040N2CZ3.0-SIRA	02881623	2	N	0,8	4,0	4,0	2,7	50,0	60,0	3	■
JS506060N2CZ4.0-SIRA	02881624	2	N	1,2	6,0	6,0	4,1	57,0	60,0	4	■
JS506080N2CZ4.0-SIRA	02881626	2	N	1,6	8,0	8,0	5,5	63,0	60,0	4	■
JS506100N2CZ4.0-SIRA	02881628	2	N	2,0	10,0	10,0	6,9	72,0	60,0	4	■
JS506120N2CZ4.0-SIRA	02881630	2	N	2,4	12,0	12,0	8,3	83,0	60,0	4	■

■ Prodotto standard.

JS506

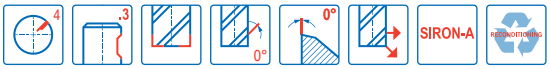
Uso generico – Universale – Smusso – 3-4 Eliche – Weldon





N

- Tolleranze:
- DMM=h5
- SIG= ±0,5°
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Weldon
				mm	mm	mm	mm	mm			
JS506060N2CZ4.3-SIRA	02881625	2	N	1,2	6,0	6,0	4,1	57,0	60,0	4	■
JS506080N2CZ4.3-SIRA	02881627	2	N	1,6	8,0	8,0	5,5	63,0	60,0	4	■
JS506100N2CZ4.3-SIRA	02881629	2	N	2,0	10,0	10,0	6,9	72,0	60,0	4	■
JS506120N2CZ4.3-SIRA	02881631	2	N	2,4	12,0	12,0	8,3	83,0	60,0	4	■

■ Prodotto standard.

Parametri di taglio – JS506 Smussatura

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	200 (180 — 220) *660 (600 — 720)*
P2	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	195 (180 — 220) *640 (600 — 720)*
P3	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	170 (150 — 190) *560 (500 — 620)*
P4	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	150 (130 — 160) *490 (430 — 520)*
P5	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	140 (130 — 160) *460 (430 — 520)*
P6	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	160 (140 — 180) *520 (460 — 590)*
P7	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P8	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	140 (130 — 160) *460 (430 — 520)*
P11	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.013 *0,00050*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	85 (75 — 97) *280 (250 — 310)*
M1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	120 (95 — 140) *395 (320 — 450)*
M2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	95 (76 — 110) *310 (250 — 360)*
M3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (43 — 80) *195 (150 — 260)*
M4	E/M/A	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	46 (33 — 60) *150 (110 — 190)*
M5	E/M/A	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	39 (27 — 50) *130 (89 — 160)*
K1	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	200 (180 — 220) *660 (600 — 720)*
K2	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	170 (150 — 190) *560 (500 — 620)*
K3	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	145 (130 — 160) *475 (430 — 520)*
K4	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	140 (130 — 150) *460 (430 — 490)*
K5	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.018 *0,00070*	0.024 *0,00095*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	85 (72 — 93) *280 (240 — 300)*
K6	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	125 (110 — 130) *410 (370 — 420)*
K7	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.018 *0,00070*	0.024 *0,00095*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	105 (92 — 120) *345 (310 — 390)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS506 Smussatura

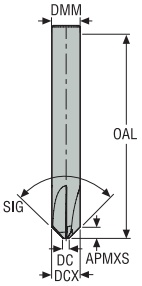
SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500 — 1700)*
N2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	305 (280 — 330) *1000 (920 — 1000)*
N3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	205 (190 — 220) *670 (630 — 720)*
N11	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	270 (250 — 290) *890 (830 — 950)*
S1	E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	41 (14 — 68) *135 (46 — 220)*
S2	E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	33 (12 — 55) *110 (40 — 180)*
S3	E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	28 (9.5 — 47) *90 (32 — 150)*
S11	E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	95 (68 — 110) *310 (230 — 360)*
S12	E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	70 (53 — 90) *230 (180 — 290)*
S13	E	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	55 (41 — 69) *180 (140 — 220)*
H5	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	65 (45 — 83) *215 (150 — 270)*
H8	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.011 *0,00044*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	60 (44 — 81) *195 (150 — 260)*
H11	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	80 (57 — 100) *260 (190 — 320)*
H12	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.011 *0,00044*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	70 (51 — 94) *230 (170 — 300)*
H21	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.011 *0,00044*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	60 (44 — 81) *195 (150 — 260)*
TS1	A/D	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500 — 1700)*
TP1	A/D	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500 — 1700)*
GR1	A/D	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500 — 1700)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS509

Uso generico – Universale – Smusso – 3-4 Eliche – Cilindrico



N



- Tolleranze:
- DMM=h5
- SIG= ±0,5°
- Riaffilatura possibile se DMM è ≥Ø6

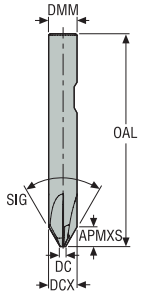
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm			
JS509030N2CZ3.0-SIRA	02881634	2	N	0,6	3,0	3,0	1,2	50,0	90,0	3	■
JS509040N2CZ3.0-SIRA	02881635	2	N	0,8	4,0	4,0	1,6	50,0	90,0	3	■
JS509060N2CZ4.0-SIRA	02881636	2	N	1,2	6,0	6,0	2,4	57,0	90,0	4	■
JS509080N2CZ4.0-SIRA	02881638	2	N	1,6	8,0	8,0	3,2	63,0	90,0	4	■
JS509100N2CZ4.0-SIRA	02881640	2	N	2,0	10,0	10,0	4,0	72,0	90,0	4	■
JS509120N2CZ4.0-SIRA	02881642	2	N	2,4	12,0	12,0	4,8	83,0	90,0	4	■

■ Prodotto standard.

JS509

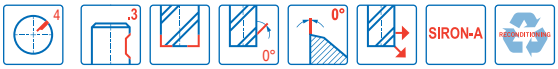
Uso generico – Universale – Smusso – 3-4 Eliche – Weldon





N

- Tolleranze:
- DMM=h5
- SIG= ±0,5°
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Weldon
				mm	mm	mm	mm	mm			
JS509060N2CZ4.3-SIRA	02881637	2	N	1,2	6,0	6,0	2,4	57,0	90,0	4	■
JS509080N2CZ4.3-SIRA	02881639	2	N	1,6	8,0	8,0	3,2	63,0	90,0	4	■
JS509100N2CZ4.3-SIRA	02881641	2	N	2,0	10,0	10,0	4,0	72,0	90,0	4	■
JS509120N2CZ4.3-SIRA	02881643	2	N	2,4	12,0	12,0	4,8	83,0	90,0	4	■

■ Prodotto standard.

Parametri di taglio – JS509 Smussatura

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	380 (340 — 430) *1250 (1200 — 1400)*
P2	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	370 (330 — 420) *1225 (1100 — 1300)*
P3	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.032 *0,0013*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	320 (280 — 360) *1050 (920 — 1100)*
P4	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.032 *0,0013*	0.042 *0,0017*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	280 (250 — 310) *920 (830 — 1000)*
P5	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	270 (240 — 300) *890 (790 — 980)*
P6	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	305 (270 — 340) *1000 (890 — 1100)*
P7	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	285 (250 — 320) *940 (830 — 1000)*
P8	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.032 *0,0013*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	270 (240 — 300) *890 (790 — 980)*
P11	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	280 (250 — 310) *920 (830 — 1000)*
P12	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	165 (150 — 180) *540 (500 — 590)*
M1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	220 (180 — 260) *720 (600 — 850)*
M2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	180 (150 — 210) *590 (500 — 680)*
M3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	115 (81 — 150) *375 (270 — 490)*
M4	E/M/A	0.100 *0,100*	0.55 *0,55*	0.026 *0,0010*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	90 (61 — 110) *295 (210 — 360)*
M5	E/M/A	0.100 *0,100*	0.55 *0,55*	0.026 *0,0010*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	75 (51 — 95) *245 (170 — 310)*
K1	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	375 (330 — 420) *1225 (1100 — 1300)*
K2	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	325 (290 — 360) *1075 (960 — 1100)*
K3	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	275 (240 — 310) *900 (790 — 1000)*
K4	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	265 (230 — 290) *870 (760 — 950)*
K5	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	155 (140 — 170) *510 (460 — 550)*
K6	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	230 (210 — 260) *750 (690 — 850)*
K7	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	200 (180 — 220) *660 (600 — 720)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS509 Smussatura

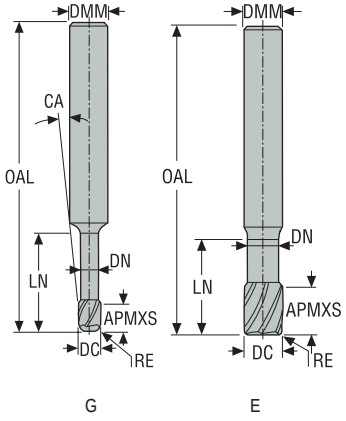
SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*
N2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	580 (530 — 630) *1900 (1800 — 2000)*
N3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	385 (350 — 420) *1275 (1200 — 1300)*
N11	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	510 (470 — 560) *1675 (1600 — 1800)*
S1	E	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	70 (24 — 110) *230 (79 — 360)*
S2	E	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	55 (19 — 94) *180 (63 — 300)*
S3	E	0.100 *0,100*	0.55 *0,55*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	49 (17 — 80) *160 (56 — 260)*
S11	E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	175 (130 — 220) *570 (430 — 720)*
S12	E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	135 (99 — 170) *445 (330 — 550)*
S13	E	0.100 *0,100*	0.55 *0,55*	0.026 *0,0010*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	105 (77 — 130) *345 (260 — 420)*
H5	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	115 (80 — 140) *375 (270 — 450)*
H8	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (78 — 140) *360 (260 — 450)*
H11	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	145 (110 — 190) *475 (370 — 620)*
H12	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	130 (91 — 170) *425 (300 — 550)*
H21	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (78 — 140) *360 (260 — 450)*
TS1	A/D	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*
TP1	A/D	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*
GR1	A/D	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

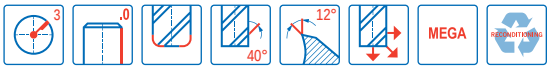
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH910

Alta velocità – Universale – Spallamento – 3 Eliche – Cilindrico – Raggio di punta







- Tolleranze:
- DMM= h5
- DC= -0,02/-0,03 mm
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6

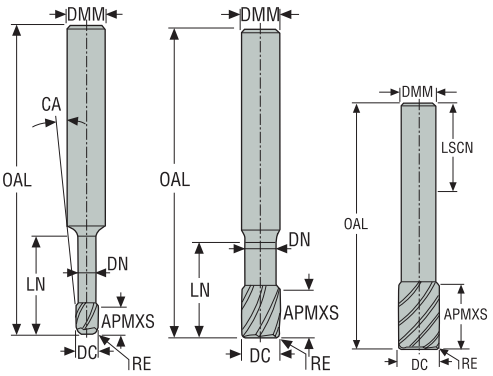
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
910020R020-MEGA	00020058	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,2	3,5	3	■
910025R020-MEGA	00020065	2	G	2,5	3,0	4,0	40,0	6,0	2,4	0,2	2,0	3	■
910030R010-MEGA	00020073	2	E	3,0	3,0	4,0	40,0	7,0	2,8	0,1	–	3	■
910030R020-MEGA	00020142	2	E	3,0	3,0	4,0	40,0	7,0	2,8	0,2	–	3	■
910035R020-MEGA	00020144	2	G	3,5	6,0	5,0	50,0	9,0	3,2	0,2	6,0	3	■
910040R020-MEGA	00020151	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,2	5,0	3	■
910040R030-MEGA	00020152	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,3	5,0	3	■
910040R050-MEGA	00020155	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,5	5,0	3	■
910050R020-MEGA	00020159	2	G	5,0	6,0	6,0	50,0	11,0	4,6	0,2	2,5	3	■
910060R020-MEGA	00020160	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,2	–	3	■
910060R030-MEGA	00020161	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,3	–	3	■
910060R050-MEGA	00020162	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,5	–	3	■
910080R020-MEGA	00020163	2	E	8,0	8,0	9,0	60,0	18,0	7,4	0,2	–	3	■
910080R050-MEGA	00020164	2	E	8,0	8,0	9,0	60,0	18,0	7,4	0,5	–	3	■
910100R020-MEGA	00020165	2	E	10,0	10,0	12,0	70,0	25,0	9,4	0,2	–	3	■
910100R050-MEGA	00020166	2	E	10,0	10,0	12,0	70,0	25,0	9,4	0,5	–	3	■
910100R100-MEGA	00020167	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	3	■
910120R050-MEGA	00020168	2	E	12,0	12,0	15,0	80,0	30,0	11,4	0,5	–	3	■
910120R100-MEGA	00020169	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,0	–	3	■

■ Prodotto standard.

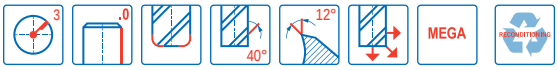
JH910

Alta velocità – Universale – Spallamento – 3 Eliche – Cilindrico – Raggio di punta





- Tolleranze:
- DMM= h5
- DC= -0,02/-0,03 mm
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA	LSCN	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		mm		
910L020-MEGA	00022002	3	G	2,0	3,0	3,0	60,0	10,0	1,9	0,2	2,5	28,0	3	■
910L030-MEGA	00022003	3	E	3,0	3,0	4,0	60,0	14,0	2,8	0,2	–	28,0	3	■
910L040-MEGA	00022004	3	G	4,0	6,0	5,0	65,0	18,0	3,7	0,2	3,0	36,0	3	■
910L050-MEGA	00022005	3	G	5,0	6,0	6,0	65,0	22,0	4,6	0,2	1,5	36,0	3	■
910L060-MEGA	00022006	3	E	6,0	6,0	7,0	80,0	26,0	5,6	0,3	–	36,0	3	■
910L080-MEGA	00022007	3	E	8,0	8,0	9,0	85,0	36,0	7,4	0,5	–	36,0	3	■
910L100-MEGA	00022009	3	E	10,0	10,0	12,0	100,0	45,0	9,4	0,5	–	40,0	3	■
910L120-MEGA	00022011	3	E	12,0	12,0	15,0	125,0	54,0	11,4	0,5	–	45,0	3	■
910L160-MEGA	00022013	3	E	16,0	16,0	18,0	125,0	65,0	15,4	1,0	–	48,0	3	■
910RS070-MEGA	00021772	4	P	7,0	6,0	8,0	100,0	–	–	0,3	–	36,0	3	■
910RS090-MEGA	00021781	4	P	9,0	8,0	11,0	100,0	–	–	0,5	–	36,0	3	■
910RS110-MEGA	00021782	4	P	11,0	10,0	13,0	125,0	–	–	0,5	–	40,0	3	■
910RS130-MEGA	00021784	4	P	13,0	12,0	16,0	150,0	–	–	0,6	–	45,0	3	■
910RS170-MEGA	00021800	4	P	17,0	16,0	20,0	150,0	–	–	0,6	–	48,0	3	■

■ Prodotto standard.

Parametri di taglio – JH910 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z														v_c
				2	3	4	5	6	7	8	9	10	11	12	13	16	17	
P1	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	455 (410 — 500) *1500 (1400 — 1600)*
P2	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	445 (400 — 490) *1450 (1400 — 1600)*
P3	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	385 (350 — 420) *1275 (1200 — 1300)*
P4	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	335 (300 — 370) *1100 (990 — 1200)*
P5	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	320 (290 — 350) *1050 (960 — 1100)*
P6	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	360 (330 — 400) *1175 (1100 — 1300)*
P7	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	340 (310 — 370) *1125 (1100 — 1200)*
P8	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	320 (290 — 350) *1050 (960 — 1100)*
P11	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	330 (300 — 360) *1075 (990 — 1100)*
P12	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	195 (180 — 210) *640 (600 — 680)*
M1	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	200 (180 — 220) *660 (600 — 720)*
M2	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	160 (150 — 170) *520 (500 — 550)*
M3	M/E/A	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	110 (91 — 120) *360 (300 — 390)*
M4	M/E/A	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	80 (68 — 94) *260 (230 — 300)*
M5	M/E/A	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	70 (57 — 78) *230 (190 — 250)*
K1	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	315 (270 — 350) *1025 (890 — 1100)*
K2	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	270 (240 — 310) *890 (790 — 1000)*
K3	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	230 (200 — 260) *750 (660 — 850)*
K4	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K5	A/E	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	280 (240 — 320) *920 (790 — 1000)*
K6	A/E	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	415 (350 — 480) *1350 (1200 — 1500)*
K7	A/E	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	355 (300 — 410) *1175 (990 — 1300)*
S1	E/M/A	0.0300 *0,0300*	0.70 *0,70*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	115 (93 — 130) *375 (310 — 420)*
S2	E/M/A	0.0300 *0,0300*	0.70 *0,70*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	95 (75 — 110) *310 (250 — 360)*
S3	E/M/A	0.0200 *0,0200*	0.50 *0,50*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.13 *0,0050*	0.14 *0,0055*	50 (40 — 59) *165 (140 — 190)*
S11	E/M/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	175 (160 — 190) *570 (530 — 620)*
S12	E/M/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	135 (120 — 150) *445 (400 — 490)*
S13	E/M/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	105 (90 — 110) *345 (300 — 360)*
TP1	A	0.150 *0,150*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.15 *0,0060*	205 (180 — 240) *670 (600 — 780)*
GR1	A	0.500 *0,500*	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	0.18 *0,0070*	610 (510 — 710) *2000 (1700 — 2300)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JH910 Scanalatura

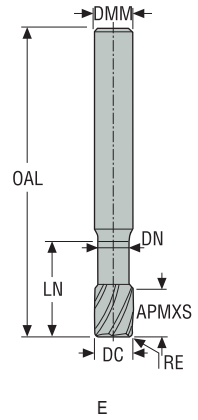
SMG		a_p/DC	f_z														v_c
			2	3	4	5	6	7	8	9	10	11	12	13	16	17	
P1	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	255 (230 — 280)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*840 (760 — 910)*
P2	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	250 (230 — 270)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*820 (760 — 880)*
P3	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	215 (200 — 230)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*710 (660 — 750)*
P4	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	190 (170 — 200)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*620 (560 — 650)*
P5	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	180 (170 — 190)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*590 (560 — 620)*
P6	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	200 (180 — 220)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*660 (600 — 720)*
P7	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	190 (170 — 210)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*620 (560 — 680)*
P8	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	180 (170 — 190)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*590 (560 — 620)*
P11	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	195 (180 — 210)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*640 (600 — 680)*
P12	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	115 (110 — 120)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*375 (370 — 390)*
M1	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	120 (110 — 130)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*395 (370 — 420)*
M2	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	95 (86 — 100)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*310 (290 — 320)*
M3	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	60 (51 — 70)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*195 (170 — 220)*
M4	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	45 (38 — 52)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*150 (130 — 170)*
M5	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	38 (32 — 43)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*125 (110 — 140)*
K1	A/E	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	175 (160 — 200)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*570 (530 — 650)*
K2	A/E	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	150 (140 — 170)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*490 (460 — 550)*
K3	A/E	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	130 (120 — 140)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*425 (400 — 450)*
K4	A/E	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	125 (110 — 140)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*410 (370 — 450)*
K5	A/E	0.16	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	150 (130 — 170)
		0,16	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*490 (430 — 550)*
K6	A/E	0.16	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	220 (190 — 250)
		0,16	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*720 (630 — 820)*
K7	A/E	0.16	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	190 (170 — 220)
		0,16	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*620 (560 — 720)*
S1	E/M/A	0.15	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	60 (50 — 74)
		0,15	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*195 (170 — 240)*
S2	E/M/A	0.15	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	50 (41 — 60)
		0,15	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*165 (140 — 190)*
S3	E/M/A	0.080	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	25 (21 — 30)
		0,080	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*80 (69 — 98)*
S11	E/M/A	0.24	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	100 (85 — 110)
		0,24	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*330 (280 — 360)*
S12	E/M/A	0.24	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	75 (65 — 84)
		0,24	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*245 (220 — 270)*
S13	E/M/A	0.24	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	60 (51 — 65)
		0,24	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*195 (170 — 210)*
TP1	A	0.24	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.095	0.10	150 (130 — 170)
		0,24	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0038*	*0,0040*	*490 (430 — 550)*
GR1	A	0.36	0.014	0.022	0.028	0.036	0.042	0.050	0.055	0.065	0.070	0.075	0.085	0.090	0.11	0.12	600 (510 — 700)
		0,36	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0020*	*0,0022*	*0,0026*	*0,0028*	*0,0030*	*0,0034*	*0,0036*	*0,0044*	*0,0048*	*1975 (1700 — 2200)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

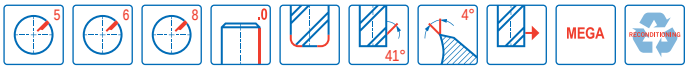
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

JH930

Alta velocità – Universale – Spallamento – 5-8 Eliche – Cilindrico – Raggio di punta



E





- Tolleranze:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
930060R020-MEGA	00022026	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,2	5	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	■

■ Prodotto standard.

Parametri di taglio – JH930 Contornatura

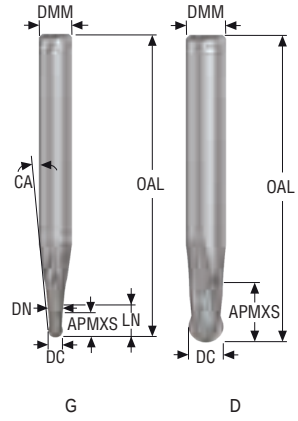
SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300 — 1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	430 (360 — 480) *1400 (1200 — 1500)*
P3	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	375 (320 — 420) *1225 (1100 — 1300)*
P4	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	330 (280 — 370) *1075 (920 — 1200)*
P5	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	315 (270 — 350) *1025 (890 — 1100)*
P6	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	355 (300 — 390) *1175 (990 — 1200)*
P7	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	335 (280 — 370) *1100 (920 — 1200)*
P8	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (270 — 350) *1025 (890 — 1100)*
P11	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	325 (280 — 360) *1075 (920 — 1100)*
P12	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
K1	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	255 (210 — 300) *840 (690 — 980)*
K2	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	225 (180 — 260) *740 (600 — 850)*
K3	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	190 (160 — 220) *620 (530 — 720)*
K4	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	180 (150 — 210) *590 (500 — 680)*
K5	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	205 (160 — 250) *670 (530 — 820)*
K6	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	300 (230 — 370) *980 (760 — 1200)*
K7	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (200 — 320) *850 (660 — 1000)*
S1	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	80 (62 — 100) *260 (210 — 320)*
S2	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (50 — 82) *215 (170 — 260)*
S3	E/M/A	0.0200 *0,0200*	0.70 *0,70*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	41 (31 — 50) *135 (110 — 160)*
S11	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
S12	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	120 (110 — 140) *395 (370 — 450)*
S13	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	95 (81 — 110) *310 (270 — 360)*
H3	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H5	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	250 (210 — 300) *820 (690 — 980)*
H7	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H8	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H11	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	320 (260 — 380) *1050 (860 — 1200)*
H12	M/A	0.0400 *0,0400*	0.70 *0,70*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	270 (220 — 320) *890 (730 — 1000)*
H21	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H31	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (130 — 180) *510 (430 — 590)*

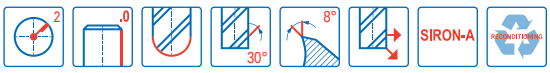
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JHB970

Alta velocità – Universale – A testa sferica – 2 Eliche – Cilindrico







- Tolleranze:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm			
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	2,5	2	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	–	2	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	–	2	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	–	2	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	–	2	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	8,0	2	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	7,5	2	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	5,5	2	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	4,5	2	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	3,0	2	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,0	2	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	2,5	2	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	–	2	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	–	2	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	–	2	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	–	2	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	8,0	2	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	5,5	2	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	3,0	2	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	2,5	2	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	–	2	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	–	2	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	–	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a αη (lαη, rif.)*

Parametri di taglio – JHB970 Copiatura sgrossatura

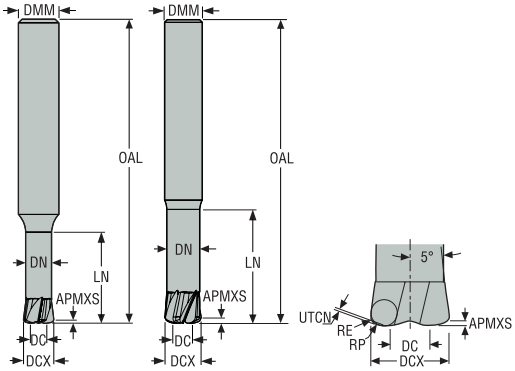
SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
P1	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	210 (190 — 230) *690 (630 — 750)*
P2	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	205 (180 — 230) *670 (600 — 750)*
P3	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
P4	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	155 (140 — 170) *510 (460 — 550)*
P5	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P6	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	170 (150 — 190) *560 (500 — 620)*
P7	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	160 (140 — 180) *520 (460 — 590)*
P8	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P11	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	75 (67 — 86) *245 (220 — 280)*
P12	M	0.200 *0,200*	1.0 *1,0*	0.0070 *0,00028*	0.0085 *0,00034*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	48 (42 — 53) *155 (140 — 170)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	90 (80 — 100) *295 (270 — 320)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	75 (65 — 85) *245 (220 — 270)*
M3	E	0.150 *0,150*	1.0 *1,0*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	65 (55 — 75) *215 (190 — 240)*
M4	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	49 (42 — 56) *160 (140 — 180)*
M5	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	41 (35 — 47) *135 (120 — 150)*
S1	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	50 (40 — 59) *165 (140 — 190)*
S2	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	40 (33 — 48) *130 (110 — 150)*
S3	E	0.100 *0,100*	0.60 *0,60*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0070 *0,00028*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.028 *0,0011*	30 (20 — 39) *100 (66 — 120)*
S11	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79 — 100) *295 (260 — 320)*
S12	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.200 *0,200*	1.0 *1,0*	0.0085 *0,00034*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JHF980

Elevato avanzamento – Universale – 2-5 Eliche – Cilindrico – Raggio di punta







- Tolleranze:
- DMM= h5
- DC= -0,02/-0,05 mm
- RE= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø6

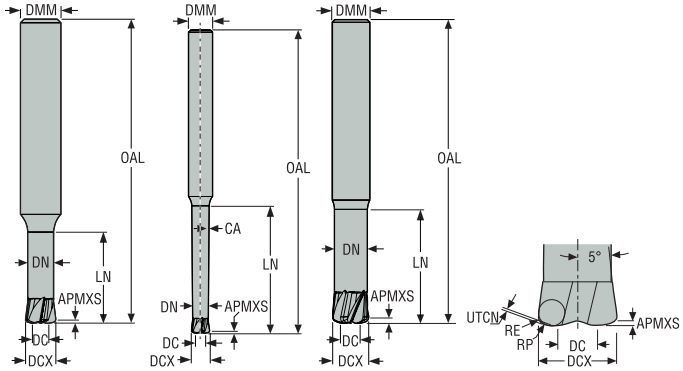
Codice di ordinazione	Codice prodotto	Indice di lung-hezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	RP	UTCN	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm			
980K080Z3-MEGA	02587115	1	E	8,0	4,0	8,0	0,4	70,0	12,0	3,0	0,6	0,935	0,198	–	3	■
JHF980080E1H.0Z5-MEGA	03003384	1	E	8,0	4,0	8,0	0,4	70,0	12,0	7,0	0,6	0,935	0,198	–	5	■
980K100Z3-MEGA	02587117	1	E	10,0	5,0	10,0	0,45	80,0	15,0	3,8	0,8	1,176	0,232	–	3	■
JHF980100E1H.0Z5-MEGA	03003385	1	E	10,0	5,0	10,0	0,45	80,0	15,0	8,8	0,8	1,176	0,232	–	5	■
980K120Z3-MEGA	02587118	1	E	12,0	6,0	12,0	0,5	80,0	18,0	4,6	1,0	1,417	0,265	–	3	■
JHF980120E1H.0Z5-MEGA	03003386	1	E	12,0	6,0	12,0	0,5	80,0	18,0	10,6	1,0	1,417	0,265	–	5	■
980010-MEGA	02587111	2	G	1,0	0,5	6,0	0,07	40,0	3,0	0,7	0,07	0,127	0,028	19,5	2	■
980015-MEGA	02511199	2	G	1,5	0,75	6,0	0,1	40,0	4,5	1,2	0,1	0,183	0,043	14,0	2	■
980020-MEGA	02511221	2	G	2,0	1,0	6,0	0,15	40,0	6,0	1,7	0,15	0,269	0,055	11,0	2	■
980030-MEGA	02511224	2	G	3,0	1,5	6,0	0,2	50,0	9,0	2,6	0,2	0,366	0,085	7,0	2	■
JHF980030G2H.0Z4-MEGA	03003387	2	G	3,0	1,5	6,0	0,2	50,0	9,0	2,6	0,2	0,366	0,085	7,12	4	■
980040-MEGA	02511229	2	G	4,0	2,0	6,0	0,25	60,0	12,0	3,5	0,3	0,503	0,107	4,0	2	■
JHF980040G2H.0Z4-MEGA	03003388	2	G	4,0	2,0	6,0	0,25	60,0	12,0	3,5	0,3	0,503	0,107	4,0	4	■
980050-MEGA	02511233	2	G	5,0	2,5	6,0	0,3	60,0	15,0	4,4	0,4	0,641	0,128	2,0	2	■
JHF980050G2H.0Z4-MEGA	03003389	2	G	5,0	2,5	6,0	0,3	60,0	15,0	4,4	0,4	0,641	0,128	1,77	4	■
980060-MEGA	02511314	2	G	6,0	3,0	8,0	0,35	60,0	18,0	5,2	0,5	0,778	0,15	3,0	2	■
JHF980060G2H.0Z4-MEGA	03003390	2	G	6,0	3,0	8,0	0,35	60,0	18,0	5,2	0,5	0,778	0,15	2,86	4	■
980080-MEGA	02511322	2	E	8,0	4,0	8,0	0,4	70,0	24,0	7,0	0,6	0,935	0,198	–	2	■
JHF980080E2H.0Z5-MEGA	03003391	2	E	8,0	4,0	8,0	0,4	70,0	24,0	7,0	0,6	0,935	0,198	–	5	■
980100-MEGA	02511341	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	2	■
980100Z3-MEGA	02511342	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	3	■
JHF980100E2H.0Z5-MEGA	03003392	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	5	■
980120-MEGA	02511346	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	2	■
980120Z3-MEGA	02511347	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	3	■
JHF980120E2H.0Z5-MEGA	03003393	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	5	■

■ Prodotto standard.
*UTCN=spessore non asportato

JHF980

Elevato avanzamento – Universale – 2-5 Eliche – Cilindrico – Raggio di punta





- Tolleranze:
- DMM= h5
- DC= -0,02/-0,05 mm
- RE= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	RP	UTCN	CA°	NA	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm		mm		
980ML010-MEGA	02587113	3	G	1,0	0,5	6,0	0,07	40,0	5,0	0,7	0,07	0,127	0,028	15,5	0,0	2	■
980ML015-MEGA	02511219	3	G	1,5	0,75	6,0	0,1	40,0	7,5	1,2	0,1	0,183	0,043	10,5	0,0	2	■
980ML020-MEGA	02511222	3	G	2,0	1,0	6,0	0,15	40,0	10,0	1,7	0,15	0,269	0,055	8,0	0,0	2	■
JHF980020G3H.0Z4-MEGA	03003394	3	G	2,0	1,0	6,0	0,15	40,0	10,0	1,7	0,15	0,269	0,055	8,46	0,0	4	■
980ML030-MEGA	02511225	3	G	3,0	1,5	6,0	0,2	50,0	15,0	2,6	0,2	0,366	0,085	5,0	0,0	2	■
JHF980030G3H.0Z4-MEGA	03003395	3	G	3,0	1,5	6,0	0,2	50,0	15,0	2,6	0,2	0,366	0,085	4,79	0,0	4	■
980ML040-MEGA	02511231	3	G	4,0	2,0	6,0	0,25	70,0	20,0	3,5	0,3	0,503	0,107	2,5	0,0	2	■
JHF980040G3H.0Z4-MEGA	03003396	3	G	4,0	2,0	6,0	0,25	70,0	20,0	3,5	0,3	0,503	0,107	2,59	0,0	4	■
980ML050-MEGA	02511234	3	G	5,0	2,5	6,0	0,3	80,0	25,0	4,4	0,4	0,641	0,128	1,5	0,0	2	■
JHF980050G3H.0Z4-MEGA	03003397	3	G	5,0	2,5	6,0	0,3	80,0	25,0	4,4	0,4	0,641	0,128	1,12	0,0	4	■
980ML060-MEGA	02511315	3	G	6,0	3,0	8,0	0,35	80,0	30,0	5,2	0,5	0,778	0,15	2,0	0,0	2	■
JHF980060G3H.0Z4-MEGA	03003398	3	G	6,0	3,0	8,0	0,35	80,0	30,0	5,2	0,5	0,778	0,15	1,8	0,0	4	■
980ML080-MEGA	02511338	3	E	8,0	4,0	8,0	0,4	80,0	40,0	7,0	0,6	0,935	0,198	–	0,0	2	■
JHF980080E3H.0Z5-MEGA	03003399	3	E	8,0	4,0	8,0	0,4	80,0	40,0	7,0	0,6	0,935	0,198	–	0,0	5	■
980ML100-MEGA	02511344	3	E	10,0	5,0	10,0	0,45	90,0	50,0	8,8	0,8	1,176	0,232	–	0,0	2	■
JHF980100E3H.0Z5-MEGA	03003400	3	E	10,0	5,0	10,0	0,45	90,0	50,0	8,8	0,8	1,176	0,232	–	0,0	5	■
980ML120-MEGA	02511348	3	E	12,0	6,0	12,0	0,5	110,0	60,0	10,6	1,0	1,417	0,265	–	0,0	2	■
JHF980120E3H.0Z5-MEGA	03003401	3	E	12,0	6,0	12,0	0,5	110,0	60,0	10,6	1,0	1,417	0,265	–	0,0	5	■
980TL010-MEGA	02587114	4	J	1,0	0,5	6,0	0,07	40,0	7,0	0,7	0,07	0,127	0,028	13,0	0,5	2	■
980TL015-MEGA	02511220	4	J	1,5	0,75	6,0	0,1	40,0	10,5	1,2	0,1	0,183	0,043	8,5	0,5	2	■
980TL020-MEGA	02511223	4	J	2,0	1,0	6,0	0,15	50,0	14,0	1,7	0,15	0,269	0,055	6,5	0,5	2	■
980TL030-MEGA	02511226	4	J	3,0	1,5	6,0	0,2	60,0	21,0	2,6	0,2	0,366	0,085	3,5	0,5	2	■
JHF980030J4H.0Z4-MEGA	03003402	4	J	3,0	1,5	6,0	0,2	60,0	21,0	2,6	0,2	0,366	0,085	3,63	0,5	4	■
980TL040-MEGA	02511232	4	J	4,0	2,0	6,0	0,25	80,0	28,0	3,5	0,3	0,503	0,107	2,0	0,5	2	■
JHF980040J4H.0Z4-MEGA	03003403	4	J	4,0	2,0	6,0	0,25	80,0	28,0	3,5	0,3	0,503	0,107	1,93	0,5	4	■
980TL050-MEGA	02511240	4	J	5,0	2,5	6,0	0,3	90,0	35,0	4,4	0,4	0,641	0,128	1,0	0,5	2	■
JHF980050J4H.0Z4-MEGA	03003404	4	J	5,0	2,5	6,0	0,3	90,0	35,0	4,4	0,4	0,641	0,128	0,82	0,5	4	■
980TL060-MEGA	02511321	4	J	6,0	3,0	8,0	0,35	100,0	42,0	5,2	0,5	0,778	0,15	1,5	0,5	2	■
JHF980060J4H.0Z4-MEGA	03003405	4	J	6,0	3,0	8,0	0,35	100,0	42,0	5,2	0,5	0,778	0,15	1,33	0,5	4	■
980TL080-MEGA	02511340	4	E	8,0	4,0	8,0	0,4	100,0	56,0	7,0	0,6	0,935	0,198	–	0,5	2	■
JHF980080E4H.0Z5-MEGA	03003406	4	E	8,0	4,0	8,0	0,4	100,0	56,0	7,0	0,6	0,935	0,198	–	0,0	5	■
980TL100-MEGA	02511345	4	E	10,0	5,0	10,0	0,45	110,0	70,0	8,8	0,8	1,176	0,232	–	0,5	2	■
JHF980100E4H.0Z5-MEGA	03003407	4	E	10,0	5,0	10,0	0,45	110,0	70,0	8,8	0,8	1,176	0,232	–	0,0	5	■
980TL120-MEGA	02511349	4	E	12,0	6,0	12,0	0,5	130,0	84,0	10,6	1,0	1,417	0,265	–	0,5	2	■
JHF980120E4H.0Z5-MEGA	03003408	4	E	12,0	6,0	12,0	0,5	130,0	84,0	10,6	1,0	1,417	0,265	–	0,0	5	■

■ Prodotto standard. *UTCN=spessore non asportato

Parametri di taglio – JHF980 Contornatura

SMG		a_e/DCX	a_p/DCX	f_z										v_c
				1	1.5	2	3	4	5	6	8	10	12	
P1	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	385 (350 — 430) *1275 (1200 — 1400)*
P2	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	375 (340 — 410) *1225 (1200 — 1300)*
P3	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	325 (290 — 360) *1075 (960 — 1100)*
P4	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	285 (260 — 310) *940 (860 — 1000)*
P5	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	275 (250 — 300) *900 (830 — 980)*
P6	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	215 (190 — 240) *710 (630 — 780)*
P7	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	205 (180 — 230) *670 (600 — 750)*
P8	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	190 (170 — 210) *620 (560 — 680)*
P11	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	195 (170 — 220) *640 (560 — 720)*
P12	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	120 (110 — 130) *395 (370 — 420)*
M1	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	190 (170 — 210) *620 (560 — 680)*
M2	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
M4	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	85 (73 — 100) *280 (240 — 320)*
M5	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	70 (61 — 83) *230 (210 — 270)*
K1	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	195 (170 — 220) *640 (560 — 720)*
K3	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	165 (150 — 180) *540 (500 — 590)*
K4	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	155 (140 — 170) *510 (460 — 550)*
K5	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	165 (140 — 190) *540 (460 — 620)*
K6	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	245 (200 — 290) *800 (660 — 950)*
K7	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	210 (170 — 250) *690 (560 — 820)*
S1	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	60 (50 — 74) *195 (170 — 240)*
S2	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	50 (41 — 60) *165 (140 — 190)*
S3	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	37 (25 — 49) *120 (83 — 160)*
S11	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	175 (160 — 190) *570 (530 — 620)*
S12	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	135 (120 — 150) *445 (400 — 490)*
S13	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	105 (90 — 110) *345 (300 — 360)*
H5	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H8	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H21	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H31	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	90 (74 — 100) *295 (250 — 320)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JHF980 Scanalatura

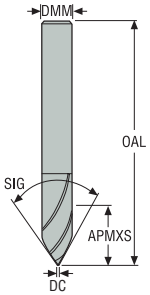
SMG		a_p/DCX	f_z										v_c
			1	1.5	2	3	4	5	6	8	10	12	
P1	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	340 (310 — 370) *1125 (1100 — 1200)*
P2	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	330 (300 — 360) *1075 (990 — 1100)*
P3	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	285 (260 — 310) *940 (860 — 1000)*
P4	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	250 (230 — 270) *820 (760 — 880)*
P5	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	240 (220 — 260) *790 (730 — 850)*
P6	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	175 (160 — 200) *570 (530 — 650)*
P8	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	165 (150 — 180) *540 (500 — 590)*
P11	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	105 (90 — 110) *345 (300 — 360)*
M1	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	165 (150 — 180) *540 (500 — 590)*
M2	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	130 (120 — 140) *425 (400 — 450)*
M3	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (85 — 110) *330 (280 — 360)*
M4	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	75 (64 — 87) *245 (210 — 280)*
M5	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	65 (53 — 72) *215 (180 — 230)*
K1	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	185 (160 — 210) *610 (530 — 680)*
K2	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	130 (120 — 140) *425 (400 — 450)*
K5	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	135 (110 — 150) *445 (370 — 490)*
K6	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	195 (160 — 230) *640 (530 — 750)*
K7	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	170 (140 — 200) *560 (460 — 650)*
S1	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	50 (42 — 62) *165 (140 — 200)*
S2	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	42 (34 — 50) *140 (120 — 160)*
S3	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	31 (21 — 41) *100 (69 — 130)*
S11	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	155 (140 — 170) *510 (460 — 550)*
S12	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	120 (110 — 130) *395 (370 — 420)*
S13	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	95 (82 — 100) *310 (270 — 320)*
H5	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H8	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H21	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H31	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	75 (65 — 88) *245 (220 — 280)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

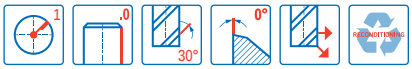
J29

Uso generico – Universale – Incisione – 1 Elica – Cilindrico



D





- Tolleranze:
- DMM=h5
- Riaffilatura possibile se DMM è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	SIG°	PCEDC	Cilindrico
				mm	mm	mm	mm			
29030	00029373	2	D	0,2	3,0	2,6	40,0	60,0	1	■
29040	00029381	2	D	0,2	4,0	3,5	50,0	60,0	1	■
29060	00029396	2	D	0,2	6,0	5,2	50,0	60,0	1	■

■ Prodotto standard.

Parametri di taglio – J29 Scanalatura

SMG		a_p/DC	f_z			v_c
			3	4	6	
P1	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	42 (32 — 63) *140 (110 — 200)*
P2	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.30 *0,012*	41 (32 — 61) *135 (110 — 200)*
P3	E	0.50 *0,50*	0.24 *0,0095*	0.25 *0,010*	0.28 *0,011*	36 (28 — 54) *120 (92 — 170)*
P4	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	31 (24 — 47) *100 (79 — 150)*
P5	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
P6	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	34 (26 — 51) *110 (86 — 160)*
P7	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	32 (25 — 48) *105 (83 — 150)*
P8	E	0.50 *0,50*	0.24 *0,0095*	0.25 *0,010*	0.28 *0,011*	30 (23 — 45) *100 (76 — 140)*
P11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	31 (24 — 46) *100 (79 — 150)*
P12	E	0.50 *0,50*	0.15 *0,0060*	0.16 *0,0065*	0.18 *0,0070*	19 (15 — 29) *60 (50 — 95)*
M1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
M2	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
M3	E	0.50 *0,50*	0.18 *0,0070*	0.19 *0,0075*	0.22 *0,0085*	24 (18 — 35) *80 (60 — 110)*
M4	E	0.50 *0,50*	0.16 *0,0065*	0.17 *0,0065*	0.18 *0,0070*	18 (14 — 27) *60 (46 — 88)*
M5	E	0.50 *0,50*	0.16 *0,0065*	0.17 *0,0065*	0.18 *0,0070*	15 (12 — 22) *49 (40 — 72)*
K1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
K2	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	26 (21 — 40) *85 (69 — 130)*
K3	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	22 (17 — 33) *70 (56 — 100)*
K4	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	21 (17 — 32) *70 (56 — 100)*
K5	E	0.50 *0,50*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	13 (9.8 — 19) *43 (33 — 62)*
K6	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	19 (15 — 28) *60 (50 — 91)*
K7	E	0.50 *0,50*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	16 (13 — 25) *50 (43 — 82)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – J29 Scanalatura

SMG		a_p/DC	f_z			v_c
			3	4	6	
N1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
N2	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	19 (15 — 29) *60 (50 — 95)*
N3	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	13 (9.8 — 19) *43 (33 — 62)*
N11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	17 (14 — 26) *55 (46 — 85)*
S1	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	43 (33 — 64) *140 (110 — 200)*
S2	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	34 (27 — 51) *110 (89 — 160)*
S3	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
S11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	39 (30 — 59) *130 (99 — 190)*
S12	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
S13	E	0.50 *0,50*	0.19 *0,0075*	0.20 *0,0080*	0.24 *0,0095*	24 (18 — 35) *80 (60 — 110)*
H5	M/A/D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
H8	M/A/D	0.50 *0,50*	0.17 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	32 (24 — 47) *105 (79 — 150)*
H11	M/A/D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	39 (30 — 58) *130 (99 — 190)*
H12	M/A/D	0.50 *0,50*	0.12 *0,0048*	0.12 *0,0048*	0.14 *0,0055*	12 (9.1 — 18) *39 (30 — 59)*
H21	M/A/D	0.50 *0,50*	0.17 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	32 (24 — 47) *105 (79 — 150)*
H31	M/A/D	0.50 *0,50*	0.15 *0,0060*	0.16 *0,0065*	0.17 *0,0065*	24 (19 — 36) *80 (63 — 110)*
TS1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
TP1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
GR1	D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*

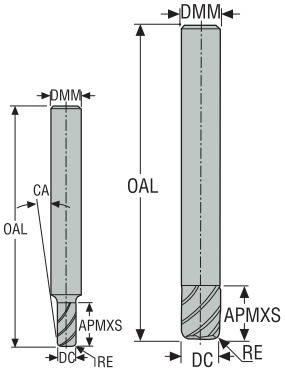
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

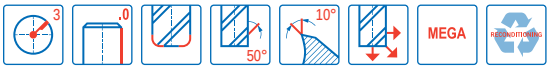
J36

Uso generico – Universale – Spallamento – 3 Eliche – Cilindrico – Raggio di punta





- Tolleranze:
- DMM= h5
- DC= Ø2-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø20= -0,02/-0,044 mm
- RE= Ø2-Ø12= +0,05 mm
- RE= Ø14-Ø20= +0,1 mm
- Riaffilatura possibile se DC è ≥Ø6



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	CA	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm		
36020-MEGA	00025621	2	F	2,0	3,0	9,0	40,0	0,1	2,5	3	■
36030-MEGA	00025626	2	D	3,0	3,0	12,0	40,0	0,1	–	3	■
36040-MEGA	00025628	2	D	4,0	4,0	14,0	50,0	0,1	–	3	■
36050-MEGA	00025651	2	D	5,0	5,0	20,0	50,0	0,1	–	3	■
36060-MEGA	00025663	2	D	6,0	6,0	20,0	65,0	0,1	–	3	■
36080-MEGA	00025674	2	D	8,0	8,0	20,0	65,0	0,2	–	3	■
36100-MEGA	00025680	2	D	10,0	10,0	25,0	75,0	0,2	–	3	■
36120-MEGA	00025681	2	D	12,0	12,0	25,0	75,0	0,2	–	3	■
36160-MEGA	00025689	2	D	16,0	16,0	30,0	90,0	0,5	–	3	■
36200-MEGA	00025692	2	D	20,0	20,0	40,0	100,0	0,5	–	3	■

■ Prodotto standard.

Parametri di taglio – J36 Contornatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
P1	E	0.200 *0,200*	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
P2	E	0.200 *0,200*	1.0 *1,0*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	190 (170 — 210) *620 (560 — 680)*
P3	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
P4	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (130 — 160) *490 (430 — 520)*
P5	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	140 (130 — 160) *460 (430 — 520)*
P6	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	160 (140 — 180) *520 (460 — 590)*
P7	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	150 (130 — 170) *490 (430 — 550)*
P8	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	140 (130 — 160) *460 (430 — 520)*
P11	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	145 (130 — 160) *475 (430 — 520)*
P12	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	90 (79 — 100) *295 (260 — 320)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	115 (92 — 140) *375 (310 — 450)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	95 (76 — 110) *310 (250 — 360)*
M3	E	0.100 *0,100*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	75 (56 — 95) *245 (190 — 310)*
M4	E	0.100 *0,100*	1.0 *1,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (43 — 73) *195 (150 — 230)*
M5	E	0.100 *0,100*	1.0 *1,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	48 (36 — 60) *155 (120 — 190)*
K1	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	140 (130 — 160) *460 (430 — 520)*
K2	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	125 (110 — 140) *410 (370 — 450)*
K3	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	105 (91 — 120) *345 (300 — 390)*
K4	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	100 (87 — 110) *330 (290 — 360)*
K5	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	60 (53 — 69) *195 (180 — 220)*
K6	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	90 (76 — 100) *295 (250 — 320)*
K7	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	80 (67 — 89) *260 (220 — 290)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – J36 Contornatura

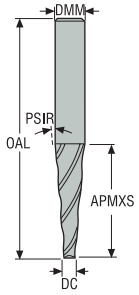
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	650 (540 — 750) *2125 (1800 — 2400)*
N2	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	415 (350 — 480) *1350 (1200 — 1500)*
N3	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	275 (240 — 320) *900 (790 — 1000)*
N11	E	0.300 *0,300*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	305 (260 — 350) *1000 (860 — 1100)*
S1	E	0.120 *0,120*	0.90 *0,90*	0.0055 *0,00022*	0.0080 *0,00032*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	70 (60 — 83) *230 (200 — 270)*
S2	E	0.120 *0,120*	0.90 *0,90*	0.0055 *0,00022*	0.0080 *0,00032*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	60 (48 — 67) *195 (160 — 210)*
S3	E	0.120 *0,120*	0.90 *0,90*	0.0036 *0,00014*	0.0055 *0,00022*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	39 (30 — 48) *130 (99 — 150)*
S11	E	0.300 *0,300*	1.0 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	100 (89 — 110) *330 (300 — 360)*
S12	E	0.300 *0,300*	1.0 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	80 (68 — 87) *260 (230 — 280)*
S13	E	0.300 *0,300*	1.0 *0,90*	0.0085 *0,00036*	0.013 *0,00050*	0.017 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (54 — 69) *195 (180 — 220)*
TS1	A	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (460 — 550) *1650 (1600 — 1800)*
TP1	A	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (460 — 550) *1650 (1600 — 1800)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

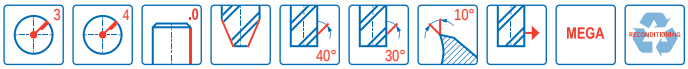
HK

Uso generico – Universale – Conica – 3-4 Eliche – Cilindrico – Spigolo vivo conico



N





- Tolleranze:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Riaffilatura possibile

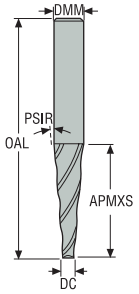
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cilindrico
				mm	mm	mm	mm			
HK020-040-MEGA	00028666	2	N	4,0	6,0	20,0	65,0	2,0	3	■
HK020-050-MEGA	00028669	2	N	5,0	8,0	30,0	75,0	2,0	3	■
HK020-100-MEGA	00028694	2	N	10,0	12,0	28,0	80,0	2,0	4	■

■ Prodotto standard.
Per i parametri di taglio, vedere My Pages – Suggest su www.secotools.com

HKM-HK

Uso generico – Universale – Conica – 2-4 Eliche – Cilindrico – Spigolo vivo conico





N

- Tolleranze:
- DMM= h5
- DC= HKM= +0,07/+0,03 mm
- DC= HK= +0,1/0 mm
- PSIR= ±0,1°
- Riaffilatura possibile se DC è ≥Ø6

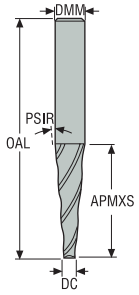


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cilindrico
				mm	mm	mm	mm			
HKM030-015-MEGA	00028738	2	N	1,5	3,0	6,0	40,0	3,0	2	■
HK030-025-MEGA	00028741	2	N	2,5	6,0	20,0	65,0	3,0	3	■
HK030-033-MEGA	00028744	2	N	3,0	8,0	30,0	75,0	3,0	3	■
HK030-065-MEGA	00028759	2	N	6,0	12,0	55,0	110,0	3,0	3	■
HK030-083-MEGA	00028771	2	N	8,0	12,0	30,0	80,0	3,0	4	■

■ Prodotto standard.
Per i parametri di taglio, vedere My Pages – Suggest su www.secotools.com

HKM-HK

Uso generico – Universale – Conica – 2-4 Eliche – Cilindrico – Spigolo vivo conico



N





- Tolleranze:
- DMM= h5
- DC= HKM= +0,07/+0,03 mm
- DC= HK= +0,1/0 mm
- PSIR= ±0,1°
- Riaffilatura possibile se DC è ≥Ø6

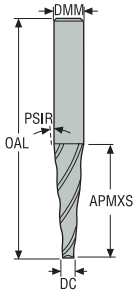
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cilindrico
				mm	mm	mm	mm			
HKM050-010-MEGA	00028947	2	N	1,0	3,0	4,0	40,0	5,0	2	■
HKM050-015-MEGA	00028952	2	N	1,5	3,0	6,0	40,0	5,0	2	■
HKM050-020-MEGA	00028954	2	N	2,0	4,0	10,0	50,0	5,0	2	■
HKM050-025-MEGA	00028958	2	N	2,5	5,0	10,0	50,0	5,0	2	■
HK050-025-MEGA	00028960	2	N	2,5	6,0	20,0	65,0	5,0	3	■
HK050-032-MEGA	00028972	2	N	3,0	8,0	28,0	70,0	5,0	3	■
HK050-0420-MEGA	00028998	2	N	4,0	8,0	22,0	65,0	5,0	3	■
HK050-050-MEGA	00029012	2	N	5,0	12,0	40,0	100,0	5,0	3	■
HK050-063-MEGA	00029014	2	N	6,0	12,0	32,0	90,0	5,0	3	■
HK050-065-MEGA	00029017	2	N	6,0	16,0	55,0	110,0	5,0	3	■
HK050-103-MEGA	00029020	2	N	10,0	16,0	32,0	90,0	5,0	4	■
HK050-105-MEGA	00029025	2	N	10,0	20,0	55,0	115,0	5,0	4	■

■ Prodotto standard.
Per i parametri di taglio, vedere My Pages – Suggest su www.secotools.com

HK

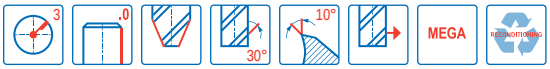
Uso generico – Universale – Conica – 3 Eliche – Cilindrico – Spigolo vivo conico





N

- Tolleranze:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Riaffilatura possibile



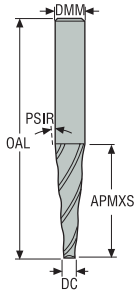
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cilindrico
				mm	mm	mm	mm			
HK070-025-MEGA	00029030	2	N	2,5	8,0	22,0	65,0	7,0	3	■
HK070-050-MEGA	00029034	2	N	5,0	12,0	28,0	80,0	7,0	3	■

■ Prodotto standard.

Per i parametri di taglio, vedere My Pages – Suggest su www.secotools.com

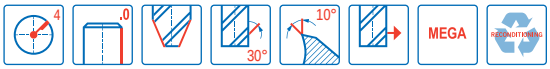
HK

Uso generico – Universale – Conica – 4 Eliche – Cilindrico – Spigolo vivo conico



N





- Tolleranze:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Riaffilatura possibile

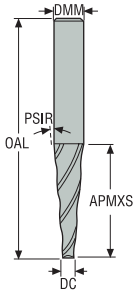
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cilindrico
				mm	mm	mm	mm			
HK080-083-MEGA	00029041	2	N	8,0	18,0	35,0	90,0	8,0	4	■

■ Prodotto standard.
Per i parametri di taglio, vedere My Pages – Suggest su www.secotools.com

HK

Uso generico – Universale – Conica – 3-4 Eliche – Cilindrico – Spigolo vivo conico





N

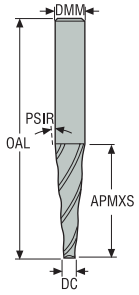
- Tolleranze:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cilindrico
				mm	mm	mm	mm			
HK100-025-MEGA	00029052	2	N	2,5	10,0	20,0	75,0	10,0	3	■
HK100-030-MEGA	00029066	2	N	3,0	14,0	30,0	90,0	10,0	3	■
HK100-050-MEGA	00029069	2	N	5,0	16,0	30,0	90,0	10,0	3	■
HK100-080-MEGA	00029083	2	N	8,0	20,0	32,0	90,0	10,0	4	■

■ Prodotto standard.
Per i parametri di taglio, vedere My Pages – Suggest su www.secotools.com

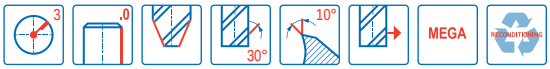
HK

Uso generico – Universale – Conica – 3 Eliche – Cilindrico – Spigolo vivo conico



N





- Tolleranze:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Riaffilatura possibile

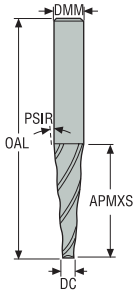
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cilindrico
				mm	mm	mm	mm			
HK110-020-MEGA	00029110	2	N	2,0	10,0	20,0	75,0	11,0	3	■
HK110-050-MEGA	00029117	2	N	5,0	14,0	20,0	80,0	11,0	3	■

■ Prodotto standard.
Per i parametri di taglio, vedere My Pages – Suggest su www.secotools.com

HK

Uso generico – Universale – Conica – 3-4 Eliche – Cilindrico – Spigolo vivo conico





N

- Tolleranze:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Riaffilatura possibile



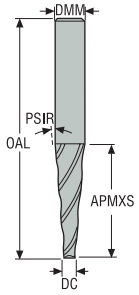
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cilindrico
				mm	mm	mm	mm			
HK150-025	00029119	2	N	2,5	14,0	20,0	80,0	15,0	3	■
HK150-025-MEGA	00029151	2	N	2,5	14,0	20,0	80,0	15,0	3	■
HK150-040	00029124	2	N	4,0	12,0	15,0	65,0	15,0	3	■
HK150-040-MEGA	00029154	2	N	4,0	12,0	15,0	65,0	15,0	3	■
HK150-0651	00029133	2	N	6,5	12,0	10,0	65,0	15,0	3	■
HK150-0651-MEGA	00029160	2	N	6,5	12,0	10,0	65,0	15,0	3	■
HK150-0652	00029138	2	N	6,5	20,0	25,0	90,0	15,0	3	■
HK150-0652-MEGA	00029161	2	N	6,5	20,0	25,0	90,0	15,0	3	■
HK150-080	00029149	2	N	8,0	20,0	20,0	80,0	15,0	4	■
HK150-080-MEGA	00029162	2	N	8,0	20,0	20,0	80,0	15,0	4	■

■ Prodotto standard.

Per i parametri di taglio, vedere My Pages – Suggest su www.secotools.com

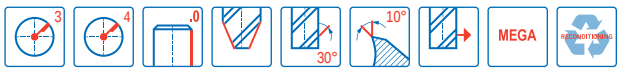
HK

Uso generico – Universale – Conica – 3-4 Eliche – Cilindrico – Spigolo vivo conico



N





- Tolleranze:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Riaffilatura possibile

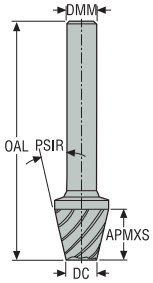
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cilindrico
				mm	mm	mm	mm			
HK200-025	00029165	2	N	2,5	10,0	10,0	75,0	20,0	3	■
HK200-025-MEGA	00029168	2	N	2,5	10,0	10,0	75,0	20,0	3	■
HK200-045	00029166	2	N	4,5	16,0	15,0	90,0	20,0	4	■
HK200-045-MEGA	00029203	2	N	4,5	16,0	15,0	90,0	20,0	4	■

■ Prodotto standard.
Per i parametri di taglio, vedere My Pages – Suggest su www.secotools.com

HK

Uso generico – Universale – Conica – 3-4 Eliche – Cilindrico – Spigolo vivo conico





N

- Tolleranze:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Riaffilatura possibile

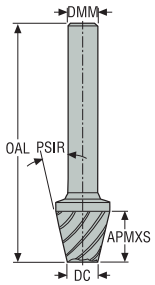


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cilindrico
				mm	mm	mm	mm			
HK300-025	00029208	2	N	2,5	10,0	10,0	75,0	30,0	3	■
HK300-025-MEGA	00029211	2	N	2,5	10,0	10,0	75,0	30,0	3	■
HK300-045	00029210	2	N	4,5	16,0	16,0	90,0	30,0	4	■
HK300-045-MEGA	00029212	2	N	4,5	16,0	16,0	90,0	30,0	4	■

■ Prodotto standard.
Per i parametri di taglio, vedere My Pages – Suggest su www.secotools.com

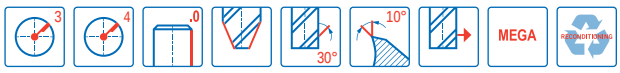
HK

Uso generico – Universale – Conica – 3-4 Eliche – Cilindrico – Spigolo vivo conico



N





- Tolleranze:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Riaffilatura possibile

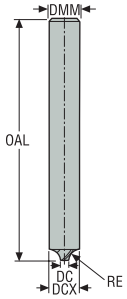
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cilindrico
				mm	mm	mm	mm			
HK450-025	00029215	2	N	2,5	12,0	10,0	75,0	45,0	3	■
HK450-025-MEGA	00029229	2	N	2,5	12,0	10,0	75,0	45,0	3	■
HK450-045	00029217	2	N	4,5	16,0	16,0	90,0	45,0	4	■
HK450-045-MEGA	00029232	2	N	4,5	16,0	16,0	90,0	45,0	4	■

■ Prodotto standard.
Per i parametri di taglio, vedere My Pages – Suggest su www.secotools.com

V31

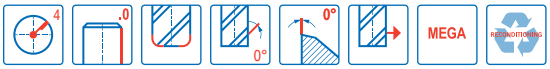
Uso generico – Universale – Concava – 4 Eliche – Cilindrico





D

- Tolleranze:
- DMM= h5
- DC= ±0,04 mm
- RE= ±0,02 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DCX	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm		
31100-MEGA	00029307	2	D	4,0	6,0	6,0	1,0	64,0	1,0	4	■
31200-MEGA	00029315	2	D	4,0	8,0	8,0	2,0	75,0	2,0	4	■
31300-MEGA	00029326	2	D	4,0	10,0	10,0	3,0	75,0	3,0	4	■
31400-MEGA	00029328	2	D	4,0	12,0	12,0	4,0	75,0	4,0	4	■
31050-MEGA	00029285	2	D	5,0	6,0	6,0	0,5	64,0	0,5	4	■
31150-MEGA	00029313	2	D	5,0	8,0	8,0	1,5	75,0	1,5	4	■
31250-MEGA	00029324	2	D	5,0	10,0	10,0	2,5	75,0	2,5	4	■
31350-MEGA	00029327	2	D	5,0	12,0	12,0	3,5	75,0	3,5	4	■
31500-MEGA	00029330	2	D	6,0	16,0	16,0	5,0	75,0	5,0	4	■
31600-MEGA	00029331	2	D	8,0	20,0	20,0	6,0	80,0	6,0	4	■
31999-MEGA	00029335	2	D	8,0	28,0	25,0	10,0	80,0	10,0	4	■
31800-MEGA	00029333	2	D	9,0	25,0	25,0	8,0	75,0	8,0	4	■

■ Prodotto standard.

Parametri di taglio – V31 Contornatura sgrossatura

SMG		a_p/DC	f_z								v_c
			6	8	10	12	16	20	25	28	
P1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	290 (195 — 310) *950 (640 — 1100)*
P2	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,034 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	280 (190 — 305) *910 (620 — 1000)*
P3	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	240 (165 — 260) *790 (540 — 850)*
P4	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	210 (145 — 230) *680 (475 — 760)*
P5	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0034*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
P6	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	230 (155 — 245) *760 (510 — 800)*
P7	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	215 (145 — 230) *710 (475 — 760)*
P8	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	205 (140 — 220) *670 (460 — 730)*
P11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	210 (140 — 225) *680 (460 — 740)*
M1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,034 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	255 (170 — 270) *840 (560 — 890)*
M2	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
M3	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,048 *0,0019*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	150 (105 — 165) *490 (345 — 540)*
M4	E/M/A	0,24 *0,24*	0,016 *0,00065*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,060 *0,0024*	0,065 *0,0026*	110 (75 — 120) *360 (250 — 400)*
M5	E/M/A	0,24 *0,24*	0,016 *0,00065*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,060 *0,0024*	0,065 *0,0026*	95 (65 — 100) *310 (220 — 320)*
K1	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
K2	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	175 (120 — 190) *570 (400 — 620)*
K3	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	150 (100 — 160) *490 (320 — 530)*
K4	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	140 (95 — 150) *460 (310 — 490)*
K5	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	85 (55 — 90) *280 (180 — 300)*
K6	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	125 (85 — 135) *410 (280 — 445)*
K7	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	105 (70 — 115) *345 (220 — 375)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – V31 Contornatura sgrossatura

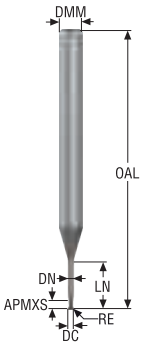
SMG		a_p/DC	f_z								v_c
			6	8	10	12	16	20	25	28	
N1	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	315 (215 — 340) *1025 (710 — 1125)*
N2	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
N3	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	135 (90 — 145) *445 (300 — 475)*
N11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	205 (140 — 220) *670 (460 — 730)*
S2	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	205 (140 — 220) *670 (460 — 730)*
S3	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	265 (180 — 285) *870 (590 — 940)*
S12	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S13	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,040 *0,0016*	0,050 *0,0022*	0,065 *0,0026*	0,075 *0,003*	0,080 *0,0032*	155 (105 — 165) *510 (345 — 540)*
H5	M/A	0,24 *0,24*	0,034 *0,0013*	0,046 *0,0018*	0,055 *0,0022*	0,070 *0,0028*	0,090 *0,0036*	0,11 *0,0044*	0,13 *0,0050*	0,14 *0,0055*	275 (185 — 295) *900 (610 — 950)*
H8	M/A	0,24 *0,24*	0,026 *0,0010*	0,034 *0,0013*	0,044 *0,0017*	0,050 *0,0022*	0,070 *0,0028*	0,085 *0,0050*	0,10 *0,004*	0,11 *0,0044*	270 (185 — 290) *890 (610 — 950)*
H21	M/A	0,24 *0,24*	0,026 *0,0010*	0,034 *0,0013*	0,044 *0,0017*	0,050 *0,0022*	0,070 *0,0028*	0,085 *0,0050*	0,10 *0,004*	0,11 *0,0044*	270 (185 — 290) *890 (610 — 950)*
H31	M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
TS1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
TP1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
GR1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

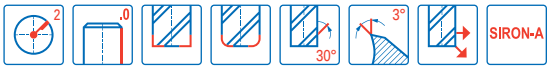
JME542

Miniaturizzato – Universale – Spallamento – 2 Eliche – DMM 4 – Cilindrico – Spigolo vivo o raggio di punta



G





- Tolleranze:
- Run-out= <0,007 mm
- DMM= h5
- DC= Ø0,2-Ø0,4= 0,-0,01 mm
- DC= Ø0,5-Ø3,0= 0,-0,013 mm
- RE= ±0,005 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JME542002G1S.0Z2-SIRA	03171095	1	G	0,2	4,0	0,3	45,0	0,4	0,18	–	14,41	2	■
JME542003G1S.0Z2-SIRA	03171096	1	G	0,3	4,0	0,45	45,0	0,6	0,28	–	14,0	2	■
JME542004G1S.0Z2-SIRA	03171128	1	G	0,4	4,0	0,6	45,0	0,8	0,37	–	13,5	2	■
JME542005G1R005.0Z2-SIRA	03171097	1	G	0,5	4,0	0,8	45,0	1,0	0,46	0,05	13,17	2	■
JME542006G1R005.0Z2-SIRA	03171098	1	G	0,6	4,0	0,9	45,0	1,2	0,56	0,05	12,76	2	■
JME542008G1R005.0Z2-SIRA	03171129	1	G	0,8	4,0	1,2	45,0	1,6	0,76	0,05	11,96	2	■
JME542010G1R010.0Z2-SIRA	03171099	1	G	1,0	4,0	1,5	50,0	2,0	0,95	0,1	11,22	2	■
JME542012G1R010.0Z2-SIRA	03171100	1	G	1,2	4,0	1,8	50,0	2,4	1,15	0,1	10,43	2	■
JME542015G1R015.0Z2-SIRA	03171130	1	G	1,5	4,0	2,3	50,0	3,0	1,45	0,15	9,2	2	■
JME542005G3R005.0Z2-SIRA	03171102	3	G	0,5	4,0	0,8	45,0	2,5	0,46	0,05	11,03	2	■
JME542006G3R005.0Z2-SIRA	03171103	3	G	0,6	4,0	0,9	45,0	3,0	0,56	0,05	10,36	2	■
JME542008G3R005.0Z2-SIRA	03171131	3	G	0,8	4,0	1,2	45,0	4,0	0,76	0,05	9,14	2	■
JME542010G3R010.0Z2-SIRA	03171104	3	G	1,0	4,0	1,5	50,0	5,0	0,95	0,1	8,09	2	■
JME542012G3R010.0Z2-SIRA	03171105	3	G	1,2	4,0	1,8	50,0	6,0	1,15	0,1	7,13	2	■
JME542015G3R015.0Z2-SIRA	03171132	3	G	1,5	4,0	2,3	50,0	7,5	1,45	0,15	5,89	2	■
JME542020G3R015.0Z2-SIRA	03171106	3	G	2,0	4,0	3,0	50,0	10,0	1,94	0,15	4,14	2	■
JME542025G3R015.0Z2-SIRA	03171108	3	G	2,5	4,0	3,8	50,0	12,5	2,4	0,15	2,79	2	■
JME542030G3R015.0Z2-SIRA	03171134	3	G	3,0	4,0	4,5	60,0	15,0	2,85	0,15	1,67	2	■
JME542005G4R005.0Z2-SIRA	03171109	4	G	0,5	4,0	0,8	45,0	4,0	0,46	0,05	9,49	2	■
JME542006G4R005.0Z2-SIRA	03171110	4	G	0,6	4,0	0,9	45,0	5,0	0,56	0,05	8,56	2	■
JME542008G4R005.0Z2-SIRA	03171135	4	G	0,8	4,0	1,2	45,0	7,0	0,76	0,05	7,05	2	■
JME542010G4R010.0Z2-SIRA	03171111	4	G	1,0	4,0	1,5	50,0	8,5	0,95	0,1	6,1	2	■
JME542012G4R010.0Z2-SIRA	03171112	4	G	1,2	4,0	1,8	50,0	10,0	1,15	0,1	5,27	2	■
JME542015G4R015.0Z2-SIRA	03171136	4	G	1,5	4,0	2,3	50,0	12,0	1,45	0,15	4,29	2	■
JME542020G4R015.0Z2-SIRA	03171113	4	G	2,0	4,0	3,0	60,0	16,0	1,94	0,15	2,9	2	■
JME542030G4R015.0Z2-SIRA	03171137	4	G	3,0	4,0	4,5	70,0	24,0	2,85	0,15	1,1	2	■
JME542015G5R015.0Z2-SIRA	03171115	5	G	1,5	4,0	2,3	60,0	15,0	1,45	0,15	3,64	2	■
JME542020G5R015.0Z2-SIRA	03171116	5	G	2,0	4,0	3,0	60,0	20,0	1,94	0,15	2,41	2	■
JME542030G5R015.0Z2-SIRA	03171117	5	G	3,0	4,0	4,5	70,0	30,0	2,85	0,15	0,9	2	■
JME542015G6R015.0Z2-SIRA	03171118	6	G	1,5	4,0	2,3	70,0	22,5	1,45	0,15	2,64	2	■
JME542020G6R015.0Z2-SIRA	03171139	6	G	2,0	4,0	3,0	70,0	30,0	1,94	0,15	1,7	2	■
JME542030G6R015.0Z2-SIRA	03171120	6	G	3,0	4,0	4,5	90,0	45,0	2,85	0,15	0,61	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a αη (lαη, rif.)*

Parametri di taglio – JME542 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	415 (370 — 460)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1350 (1300 — 1500)*
P2	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	405 (360 — 440)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1325 (1200 — 1400)*
P3	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	350 (310 — 380)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1150 (1100 — 1200)*
P4	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	305 (280 — 340)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1000 (920 — 1100)*
P5	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (260 — 320)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (860 — 1000)*
P6	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	330 (300 — 360)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1075 (990 — 1100)*
P7	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	310 (280 — 340)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1025 (920 — 1100)*
P8	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (260 — 320)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (860 — 1000)*
P11	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	300 (270 — 330)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*980 (890 — 1000)*
P12	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (160 — 190)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (530 — 620)*
M1	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	220 (190 — 260)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*720 (630 — 850)*
M2	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	180 (150 — 210)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*590 (500 — 680)*
M3	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	180 (150 — 210)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*590 (500 — 680)*
M4	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	135 (110 — 150)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*445 (370 — 490)*
M5	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	110 (92 — 130)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*360 (310 — 420)*
N1	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	570 (500 — 640)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1875 (1700 — 2000)*
N2	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	570 (500 — 640)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1875 (1700 — 2000)*
N3	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	380 (340 — 420)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1250 (1200 — 1300)*
N11	E/M/A	0.100	0.75	0.0050	0.0075	0.010	0.012	0.015	0.020	0.025	0.030	0.046	0.050	0.060	0.075	510 (440 — 580)
		0,100	*0,75*	*0,00020*	*0,00030*	*0,00040*	*0,00048*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0018*	*0,0020*	*0,0024*	*0,0030*	*1675 (1500 — 1900)*
S11	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	295 (260 — 330)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*970 (860 — 1000)*
S12	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	225 (200 — 250)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*740 (660 — 820)*
S13	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (160 — 200)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (530 — 650)*
H3	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H5	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H7	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H8	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H11	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	325 (290 — 360)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1075 (960 — 1100)*
H12	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	295 (270 — 330)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*970 (890 — 1000)*
H21	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H31	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	195 (170 — 210)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*640 (560 — 680)*
GR1	A	0.500	0.50	0.0030	0.0044	0.0060	0.0075	0.0090	0.012	0.015	0.018	0.024	0.025	0.028	0.032	405 (350 — 460)
		0,500	*0,50*	*0,00012*	*0,00017*	*0,00024*	*0,00030*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0010*	*0,0011*	*0,0013*	*1325 (1200 — 1500)*

Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JME542 Scanalatura

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	215 (200 — 230) *710 (660 — 750)*
P4	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P6	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P11	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P12	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.022 *0,00085*	0.026 *0,0010*	0.028 *0,0011*	110 (98 — 120) *360 (330 — 390)*
M1	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120 — 160) *445 (400 — 520)*
M2	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (91 — 130) *360 (300 — 420)*
M3	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (91 — 130) *360 (300 — 420)*
M4	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	80 (68 — 97) *260 (230 — 310)*
M5	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	70 (57 — 81) *230 (190 — 260)*
N1	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N2	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N3	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	265 (240 — 290) *870 (790 — 950)*
N11	E/M/A	0.24 *0,24*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	350 (300 — 400) *1150 (990 — 1300)*
S11	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	140 (120 — 150) *460 (400 — 490)*
S13	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	110 (93 — 120) *360 (310 — 390)*
H3	M/A	0.095 *0,095*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H5	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H7	M/A	0.095 *0,095*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H8	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H11	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	205 (180 — 230) *670 (600 — 750)*
H12	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
H21	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H31	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	120 (110 — 130) *395 (370 — 420)*
GR1	A	0.50 *0,50*	0.0020 *0,000080*	0.0030 *0,00012*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.018 *0,00070*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	350 (300 — 400) *1150 (990 — 1300)*

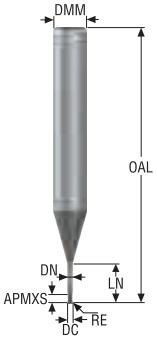
Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JME562

Miniaturizzato – Universale – Spallamento – 2 Eliche – DMM 6 – Cilindrico – Raggio di punta





G

- Tolleranze:
- Run-out= <0,007 mm
- DMM= h5
- DC= 0,-0,013 mm
- RE= ±0,005 mm

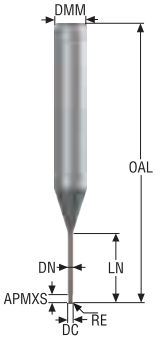


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JME562005G2R005.0Z2-SIRA	03171145	2	G	0,5	6,0	0,8	50,0	1,5	0,46	0,05	13,48	2	■
JME562006G2R005.0Z2-SIRA	03171146	2	G	0,6	6,0	0,9	50,0	2,0	0,56	0,05	12,9	2	■
JME562008G2R005.0Z2-SIRA	03171147	2	G	0,8	6,0	1,2	50,0	2,5	0,76	0,05	12,28	2	■
JME562010G2R010.0Z2-SIRA	03171148	2	G	1,0	6,0	1,5	50,0	4,0	0,95	0,1	10,85	2	■
JME562012G2R010.0Z2-SIRA	03171150	2	G	1,2	6,0	1,8	50,0	4,5	1,15	0,1	10,31	2	■
JME562015G2R015.0Z2-SIRA	03171151	2	G	1,5	6,0	2,3	50,0	5,0	1,45	0,15	9,67	2	■
JME562018G2R015.0Z2-SIRA	03171152	2	G	1,8	6,0	2,7	50,0	5,4	1,75	0,15	9,12	2	■
JME562020G2R015.0Z2-SIRA	03171153	2	G	2,0	6,0	3,0	50,0	6,0	1,94	0,15	8,53	2	■
JME562025G2R015.0Z2-SIRA	03171154	2	G	2,5	6,0	3,8	60,0	7,5	2,4	0,15	7,15	2	■
JME562030G2R015.0Z2-SIRA	03171155	2	G	3,0	6,0	4,5	60,0	9,0	2,85	0,15	5,81	2	■
JME562005G4R005.0Z2-SIRA	03171156	4	G	0,5	6,0	0,8	50,0	3,5	0,46	0,05	11,54	2	■
JME562006G4R005.0Z2-SIRA	03171157	4	G	0,6	6,0	0,9	50,0	4,2	0,56	0,05	10,93	2	■
JME562008G4R005.0Z2-SIRA	03171158	4	G	0,8	6,0	1,2	50,0	5,6	0,76	0,05	9,81	2	■
JME562010G4R010.0Z2-SIRA	03171159	4	G	1,0	6,0	1,5	50,0	7,0	0,95	0,1	8,86	2	■
JME562012G4R010.0Z2-SIRA	03171160	4	G	1,2	6,0	1,8	50,0	8,4	1,15	0,1	8,0	2	■
JME562015G4R015.0Z2-SIRA	03171162	4	G	1,5	6,0	2,3	50,0	10,5	1,45	0,15	6,86	2	■
JME562020G4R015.0Z2-SIRA	03171163	4	G	2,0	6,0	3,0	60,0	14,0	1,94	0,15	5,36	2	■
JME562030G4R015.0Z2-SIRA	03171165	4	G	3,0	6,0	4,5	70,0	21,0	2,85	0,15	3,22	2	■
JME562005G5R005.0Z2-SIRA	03171166	5	G	0,5	6,0	0,8	50,0	5,0	0,46	0,05	10,42	2	■
JME562006G5R005.0Z2-SIRA	03171167	5	G	0,6	6,0	0,9	50,0	6,0	0,56	0,05	9,71	2	■
JME562008G5R005.0Z2-SIRA	03171168	5	G	0,8	6,0	1,2	50,0	8,0	0,76	0,05	8,48	2	■
JME562010G5R010.0Z2-SIRA	03171169	5	G	1,0	6,0	1,5	50,0	10,0	0,95	0,1	7,48	2	■
JME562012G5R010.0Z2-SIRA	03171170	5	G	1,2	6,0	1,8	50,0	12,0	1,15	0,1	6,62	2	■
JME562015G5R015.0Z2-SIRA	03171171	5	G	1,5	6,0	2,3	60,0	15,0	1,45	0,15	5,54	2	■
JME562020G5R015.0Z2-SIRA	03171172	5	G	2,0	6,0	3,0	60,0	20,0	1,94	0,15	4,19	2	■
JME562030G5R015.0Z2-SIRA	03171174	5	G	3,0	6,0	4,5	70,0	30,0	2,85	0,15	2,41	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a αη (lαη, rif.)*

JME562

Miniaturizzato – Universale – Spallamento – 2 Eliche – DMM 6 – Cilindrico – Raggio di punta



G





- Tolleranze:
- Run-out= <0,007 mm
- DMM= h5
- DC= 0,-0,013 mm
- RE= ±0,005 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JME562010G6R010.0Z2-SIRA	03171175	6	G	1,0	6,0	1,5	60,0	15,0	0,95	0,1	5,94	2	■
JME562012G6R010.0Z2-SIRA	03171176	6	G	1,2	6,0	1,8	60,0	18,0	1,15	0,1	5,14	2	■
JME562015G6R015.0Z2-SIRA	03171177	6	G	1,5	6,0	2,3	70,0	22,5	1,45	0,15	4,2	2	■
JME562020G6R015.0Z2-SIRA	03171178	6	G	2,0	6,0	3,0	80,0	30,0	1,94	0,15	3,07	2	■
JME562030G6R015.0Z2-SIRA	03171180	6	G	3,0	6,0	4,5	90,0	45,0	2,85	0,15	1,7	2	■
JME562010G7R010.0Z2-SIRA	03171181	7	G	1,0	6,0	1,5	60,0	20,0	0,95	0,1	4,93	2	■
JME562012G7R010.0Z2-SIRA	03171182	7	G	1,2	6,0	1,8	80,0	24,0	1,15	0,1	4,2	2	■
JME562015G7R015.0Z2-SIRA	03171183	7	G	1,5	6,0	2,3	80,0	30,0	1,45	0,15	3,38	2	■
JME562020G7R015.0Z2-SIRA	03171184	7	G	2,0	6,0	3,0	80,0	40,0	1,94	0,15	2,42	2	■
JME562030G7R015.0Z2-SIRA	03171186	7	G	3,0	6,0	4,5	100,0	60,0	2,85	0,15	1,31	2	■

■ Prodotto standard.

Per i valori WDX: Profondità di taglio max relativa a αη (lαη, rif.)*

Parametri di taglio – JME562 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	415 (370 — 460)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1350 (1300 — 1500)*
P2	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	405 (360 — 440)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1325 (1200 — 1400)*
P3	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	350 (310 — 380)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1150 (1100 — 1200)*
P4	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	305 (280 — 340)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1000 (920 — 1100)*
P5	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (260 — 320)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (860 — 1000)*
P6	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	330 (300 — 360)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1075 (990 — 1100)*
P7	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	310 (280 — 340)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1025 (920 — 1100)*
P8	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (260 — 320)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (860 — 1000)*
P11	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	300 (270 — 330)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*980 (890 — 1000)*
P12	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (160 — 190)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (530 — 620)*
M1	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	220 (190 — 260)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*720 (630 — 850)*
M2	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	180 (150 — 210)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*590 (500 — 680)*
M3	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	180 (150 — 210)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*590 (500 — 680)*
M4	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	135 (110 — 150)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*445 (370 — 490)*
M5	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	110 (92 — 130)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*360 (310 — 420)*
N1	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	570 (500 — 640)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1875 (1700 — 2000)*
N2	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	570 (500 — 640)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1875 (1700 — 2000)*
N3	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	380 (340 — 420)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1250 (1200 — 1300)*
N11	E/M/A	0.100	0.75	0.0050	0.0075	0.010	0.012	0.015	0.020	0.025	0.030	0.046	0.050	0.060	0.075	510 (440 — 580)
		0,100	*0,75*	*0,00020*	*0,00030*	*0,00040*	*0,00048*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0018*	*0,0020*	*0,0024*	*0,0030*	*1675 (1500 — 1900)*
S11	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	295 (260 — 330)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*970 (860 — 1000)*
S12	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	225 (200 — 250)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*740 (660 — 820)*
S13	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (160 — 200)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (530 — 650)*
H3	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H5	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H7	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H8	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H11	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	325 (290 — 360)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1075 (960 — 1100)*
H12	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	295 (270 — 330)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*970 (890 — 1000)*
H21	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H31	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	195 (170 — 210)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*640 (560 — 680)*
GR1	A	0.500	0.50	0.0030	0.0044	0.0060	0.0075	0.0090	0.012	0.015	0.018	0.024	0.025	0.028	0.032	405 (350 — 460)
		0,500	*0,50*	*0,00012*	*0,00017*	*0,00024*	*0,00030*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0010*	*0,0011*	*0,0013*	*1325 (1200 — 1500)*

Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JME562 Scanalatura

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	215 (200 — 230) *710 (660 — 750)*
P4	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P6	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P11	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P12	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.022 *0,00085*	0.026 *0,0010*	0.028 *0,0011*	110 (98 — 120) *360 (330 — 390)*
M1	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120 — 160) *445 (400 — 520)*
M2	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (91 — 130) *360 (300 — 420)*
M3	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (91 — 130) *360 (300 — 420)*
M4	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	80 (68 — 97) *260 (230 — 310)*
M5	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	70 (57 — 81) *230 (190 — 260)*
N1	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N2	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N3	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	265 (240 — 290) *870 (790 — 950)*
N11	E/M/A	0.24 *0,24*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	350 (300 — 400) *1150 (990 — 1300)*
S11	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	140 (120 — 150) *460 (400 — 490)*
S13	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	110 (93 — 120) *360 (310 — 390)*
H3	M/A	0.095 *0,095*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H5	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H7	M/A	0.095 *0,095*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H8	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H11	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	205 (180 — 230) *670 (600 — 750)*
H12	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
H21	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H31	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	120 (110 — 130) *395 (370 — 420)*
GR1	A	0.50 *0,50*	0.0020 *0,000080*	0.0030 *0,00012*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.018 *0,00070*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	350 (300 — 400) *1150 (990 — 1300)*

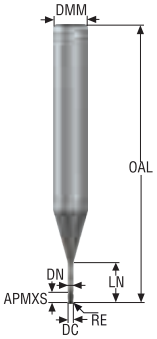
Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JME564

Miniaturizzato – Universale – Spallamento – 4 Eliche – DMM 6 – Cilindrico – Raggio di punta





G

- Tolleranze:
- Run-out= <0-0,007 mm
- DMM= h5
- DC= 0,-0,013 mm
- RE= ±0,005 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JME564005G2R005.0Z4-SIRA	03227166	2	G	0,5	6,0	1,0	50,0	1,5	0,46	0,05	13,48	4	■
JME564006G2R005.0Z4-SIRA	03227271	2	G	0,6	6,0	1,2	50,0	2,0	0,56	0,05	12,9	4	■
JME564008G2R005.0Z4-SIRA	03171194	2	G	0,8	6,0	1,6	50,0	2,5	0,76	0,05	12,28	4	■
JME564010G2R010.0Z4-SIRA	03171195	2	G	1,0	6,0	2,0	50,0	4,0	0,95	0,1	10,85	4	■
JME564012G2R010.0Z4-SIRA	03171196	2	G	1,2	6,0	2,4	50,0	4,5	1,15	0,1	10,31	4	■
JME564015G2R015.0Z4-SIRA	03171197	2	G	1,5	6,0	3,0	50,0	5,0	1,45	0,15	9,67	4	■
JME564020G2R015.0Z4-SIRA	03171198	2	G	2,0	6,0	4,0	50,0	6,0	1,94	0,15	8,53	4	■
JME564025G2R015.0Z4-SIRA	03171199	2	G	2,5	6,0	5,0	60,0	7,5	2,4	0,15	7,15	4	■
JME564030G2R015.0Z4-SIRA	03171200	2	G	3,0	6,0	6,0	60,0	9,0	2,85	0,15	5,81	4	■
JME564005G4R005.0Z4-SIRA	03171201	4	G	0,5	6,0	1,0	50,0	3,5	0,46	0,05	11,54	4	■
JME564006G4R005.0Z4-SIRA	03171202	4	G	0,6	6,0	1,2	50,0	4,2	0,56	0,05	10,93	4	■
JME564008G4R005.0Z4-SIRA	03171203	4	G	0,8	6,0	1,6	50,0	5,6	0,76	0,05	9,81	4	■
JME564010G4R010.0Z4-SIRA	03171204	4	G	1,0	6,0	2,0	50,0	7,0	0,95	0,1	8,86	4	■
JME564012G4R010.0Z4-SIRA	03171205	4	G	1,2	6,0	2,4	50,0	8,4	1,15	0,1	8,0	4	■
JME564015G4R015.0Z4-SIRA	03171206	4	G	1,5	6,0	3,0	50,0	10,5	1,45	0,15	6,86	4	■
JME564020G4R015.0Z4-SIRA	03171207	4	G	2,0	6,0	4,0	60,0	14,0	1,94	0,15	5,36	4	■
JME564030G4R015.0Z4-SIRA	03171209	4	G	3,0	6,0	6,0	70,0	21,0	2,85	0,15	3,22	4	■

■ Prodotto standard.

Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JME564 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z									v_c
				0.5	0.6	0.8	1.0	1.2	1.5	2.0	2.5	3	
P1	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	395 (360 — 430) *1300 (1200 — 1400)*
P2	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	385 (350 — 420) *1275 (1200 — 1300)*
P3	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	330 (300 — 360) *1075 (990 — 1100)*
P4	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P5	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 300) *920 (830 — 980)*
P6	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	310 (280 — 340) *1025 (920 — 1100)*
P7	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (270 — 320) *970 (890 — 1000)*
P8	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 300) *920 (830 — 980)*
P11	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	285 (260 — 310) *940 (860 — 1000)*
P12	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	170 (160 — 180) *560 (530 — 590)*
M1	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (200 — 280) *770 (660 — 910)*
M2	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530 — 720)*
M3	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530 — 720)*
M4	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	145 (120 — 160) *475 (400 — 520)*
M5	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (99 — 140) *395 (330 — 450)*
N1	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	550 (490 — 610) *1800 (1700 — 2000)*
N2	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	550 (490 — 610) *1800 (1700 — 2000)*
N3	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 410) *1200 (1100 — 1300)*
N11	E/M/A	0.100 *0,100*	0.90 *0,90*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	490 (430 — 560) *1600 (1500 — 1800)*
S11	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	285 (250 — 320) *940 (830 — 1000)*
S12	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (190 — 250) *720 (630 — 820)*
S13	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	170 (150 — 190) *560 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.060 *0,060*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.038 *0,0015*	0.042 *0,0017*	125 (95 — 150) *410 (320 — 490)*
H5	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	240 (210 — 260) *790 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.060 *0,060*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.038 *0,0015*	0.042 *0,0017*	125 (95 — 150) *410 (320 — 490)*
H8	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	240 (210 — 260) *790 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (270 — 340) *1000 (890 — 1100)*
H12	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	275 (250 — 310) *900 (830 — 1000)*
H21	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	240 (210 — 260) *790 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.048 *0,0019*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.65 *0,50*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00085*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	390 (340 — 440) *1300 (1200 — 1400)*

Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JME564 Scanalatura

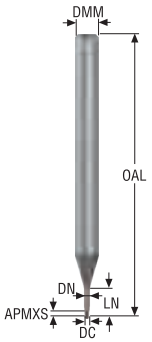
SMG		a_p/DC	f_z									v_c
			0.5	0.6	0.8	1.0	1.2	1.5	2.0	2.5	3	
P1	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P2	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	245 (220 — 270) *800 (730 — 880)*
P3	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	210 (190 — 230) *690 (630 — 750)*
P4	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P5	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	175 (160 — 190) *570 (530 — 620)*
P6	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P8	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	175 (160 — 190) *570 (530 — 620)*
P11	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P12	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.026 *0,0010*	0.030 *0,0012*	105 (96 — 110) *345 (320 — 360)*
M1	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (110 — 150) *445 (370 — 490)*
M2	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (89 — 120) *360 (300 — 390)*
M3	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (89 — 120) *360 (300 — 390)*
M4	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	80 (67 — 95) *260 (220 — 310)*
M5	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	65 (56 — 79) *215 (190 — 250)*
N1	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	390 (350 — 440) *1275 (1200 — 1400)*
N2	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	390 (350 — 440) *1275 (1200 — 1400)*
N3	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	260 (230 — 290) *850 (760 — 950)*
N11	E/M/A	0.15 *0,15*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.048 *0,0019*	0.055 *0,0022*	345 (300 — 390) *1125 (990 — 1200)*
S11	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120 — 150) *445 (400 — 490)*
S13	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	105 (92 — 120) *345 (310 — 390)*
H3	M/A	0.0060 *0,0060*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (59 — 98) *260 (200 — 320)*
H5	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (140 — 170) *520 (460 — 550)*
H7	M/A	0.0060 *0,0060*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (59 — 98) *260 (200 — 320)*
H8	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	160 (140 — 170) *520 (460 — 550)*
H11	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
H12	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	185 (170 — 200) *610 (560 — 650)*
H21	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	160 (140 — 170) *520 (460 — 550)*
H31	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.025 *0,0010*	0.028 *0,0011*	120 (110 — 130) *395 (370 — 420)*
GR1	A	0.20 *0,20*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.024 *0,00095*	0.026 *0,0010*	325 (280 — 370) *1075 (920 — 1200)*

Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JMB542

Miniaturizzato – Universale – A testa sferica – 2 Eliche – DMM 4 – Cilindrico



G





- Tolleranze:
- Run-out=<0,007 mm
- DMM= h5
- DC= 0,-0,01 mm
- RE= ±0,005 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JMB542002G1B.0Z2-SIRA	03171221	1	G	0,2	4,0	0,2	45,0	0,4	0,18	0,1	14,57	2	■
JMB542003G1B.0Z2-SIRA	03171222	1	G	0,3	4,0	0,3	45,0	0,6	0,28	0,15	14,24	2	■
JMB542004G1B.0Z2-SIRA	03171223	1	G	0,4	4,0	0,4	45,0	0,8	0,37	0,2	13,81	2	■
JMB542005G1B.0Z2-SIRA	03171224	1	G	0,5	4,0	0,5	45,0	1,0	0,46	0,25	13,47	2	■
JMB542006G1B.0Z2-SIRA	03171225	1	G	0,6	4,0	0,6	45,0	1,2	0,56	0,3	13,14	2	■
JMB542008G1B.0Z2-SIRA	03171226	1	G	0,8	4,0	0,8	45,0	1,6	0,76	0,4	12,46	2	■
JMB542010G1B.0Z2-SIRA	03171228	1	G	1,0	4,0	1,0	50,0	2,0	0,95	0,5	11,77	2	■
JMB542012G1B.0Z2-SIRA	03171229	1	G	1,2	4,0	1,2	50,0	2,4	1,15	0,6	11,07	2	■
JMB542015G1B.0Z2-SIRA	03171230	1	G	1,5	4,0	1,5	50,0	3,0	1,45	0,75	9,88	2	■
JMB542005G3B.0Z2-SIRA	03171231	3	G	0,5	4,0	0,5	45,0	2,5	0,46	0,25	11,25	2	■
JMB542006G3B.0Z2-SIRA	03171233	3	G	0,6	4,0	0,6	45,0	3,0	0,56	0,3	10,61	2	■
JMB542008G3B.0Z2-SIRA	03171234	3	G	0,8	4,0	0,8	45,0	4,0	0,76	0,4	9,44	2	■
JMB542010G3B.0Z2-SIRA	03171235	3	G	1,0	4,0	1,0	50,0	5,0	0,95	0,5	8,38	2	■
JMB542012G3B.0Z2-SIRA	03171236	3	G	1,2	4,0	1,2	50,0	6,0	1,15	0,6	7,44	2	■
JMB542015G3B.0Z2-SIRA	03171237	3	G	1,5	4,0	1,5	50,0	7,5	1,45	0,75	6,13	2	■
JMB542020G3B.0Z2-SIRA	03171238	3	G	2,0	4,0	2,0	50,0	10,0	1,94	1,0	4,4	2	■
JMB542030G3B.0Z2-SIRA	03171240	3	G	3,0	4,0	3,0	60,0	15,0	2,85	1,5	1,81	2	■
JMB542005G4B.0Z2-SIRA	03171241	4	G	0,5	4,0	0,5	45,0	4,0	0,46	0,25	9,65	2	■
JMB542006G4B.0Z2-SIRA	03171242	4	G	0,6	4,0	0,6	45,0	5,0	0,56	0,3	8,74	2	■
JMB542008G4B.0Z2-SIRA	03171243	4	G	0,8	4,0	0,8	45,0	7,0	0,76	0,4	7,23	2	■
JMB542010G4B.0Z2-SIRA	03171244	4	G	1,0	4,0	1,0	50,0	8,5	0,95	0,5	6,27	2	■
JMB542012G4B.0Z2-SIRA	03171245	4	G	1,2	4,0	1,2	50,0	10,0	1,15	0,6	5,44	2	■
JMB542015G4B.0Z2-SIRA	03171246	4	G	1,5	4,0	1,5	50,0	12,0	1,45	0,75	4,44	2	■
JMB542020G4B.0Z2-SIRA	03171247	4	G	2,0	4,0	2,0	60,0	16,0	1,94	1,0	3,02	2	■
JMB542030G4B.0Z2-SIRA	03171249	4	G	3,0	4,0	3,0	70,0	24,0	2,85	1,5	1,16	2	■
JMB542015G5B.0Z2-SIRA	03171250	5	G	1,5	4,0	1,5	60,0	15,0	1,45	0,75	3,75	2	■
JMB542020G5B.0Z2-SIRA	03171251	5	G	2,0	4,0	2,0	60,0	20,0	1,94	1,0	2,5	2	■
JMB542030G5B.0Z2-SIRA	03171253	5	G	3,0	4,0	3,0	70,0	30,0	2,85	1,5	0,93	2	■
JMB542015G6B.0Z2-SIRA	03171254	6	G	1,5	4,0	1,5	70,0	22,5	1,45	0,75	2,7	2	■
JMB542020G6B.0Z2-SIRA	03171255	6	G	2,0	4,0	2,0	70,0	30,0	1,94	1,0	1,74	2	■
JMB542030G6B.0Z2-SIRA	03171257	6	G	3,0	4,0	3,0	90,0	45,0	2,85	1,5	0,63	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JMB542 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100 — 1300)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	355 (320 — 390) *1175 (1100 — 1200)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 330) *1000 (920 — 1000)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (240 — 290) *890 (790 — 950)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 310) *950 (860 — 1000)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (250 — 300) *890 (830 — 980)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (240 — 290) *870 (790 — 950)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	155 (140 — 170) *510 (460 — 550)*
M1	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	215 (180 — 250) *710 (600 — 820)*
M2	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M3	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M4	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	130 (110 — 150) *425 (370 — 490)*
M5	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (90 — 120) *360 (300 — 390)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500 — 1700)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500 — 1700)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960 — 1100)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	430 (370 — 480) *1400 (1300 — 1500)*
S11	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (250 — 330) *950 (830 — 1000)*
S12	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 190) *570 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890 — 1000)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	275 (240 — 300) *900 (790 — 980)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.028 *0,0011*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	405 (350 — 460) *1325 (1200 — 1500)*

Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JMB542 Scanalatura

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	215 (200 — 230) *710 (660 — 750)*
P4	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P6	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P11	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P12	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (98 — 120) *360 (330 — 390)*
M1	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120 — 160) *445 (400 — 520)*
M2	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (90 — 130) *360 (300 — 420)*
M3	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (90 — 130) *360 (300 — 420)*
M4	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	80 (68 — 97) *260 (230 — 310)*
M5	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	70 (57 — 81) *230 (190 — 260)*
N1	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N2	E/M/A	0.26 *0,26*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N3	E/M/A	0.26 *0,26*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	265 (240 — 290) *870 (790 — 950)*
N11	E/M/A	0.24 *0,24*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	350 (300 — 390) *1150 (990 — 1200)*
S11	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	140 (120 — 150) *460 (400 — 490)*
S13	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	105 (93 — 120) *345 (310 — 390)*
H3	M/A	0.10 *0,10*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H5	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H7	M/A	0.10 *0,10*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H8	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H11	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	205 (180 — 230) *670 (600 — 750)*
H12	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
H21	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H31	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	120 (110 — 130) *395 (370 — 420)*
GR1	A	0.50 *0,50*	0.0020 *0,000080*	0.0030 *0,00012*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.018 *0,00070*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	350 (300 — 390) *1150 (990 — 1200)*

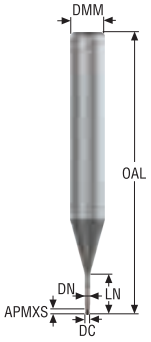
Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JMB562

Miniaturizzato – Universale – A testa sferica – 2 Eliche – DMM 6 – Cilindrico





G

- Tolleranze:
- Run-out=<0,007 mm
- DMM= h5
- DC= 0,-0,01 mm
- RE= ±0,005 mm

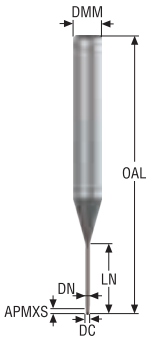


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JMB562005G2B.0Z2-SIRA	03171261	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	13,69	2	■
JMB562006G2B.0Z2-SIRA	03171262	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	13,13	2	■
JMB562008G2B.0Z2-SIRA	03171263	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	12,6	2	■
JMB562010G2B.0Z2-SIRA	03171264	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	11,15	2	■
JMB562012G2B.0Z2-SIRA	03171265	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	10,67	2	■
JMB562015G2B.0Z2-SIRA	03171266	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,07	2	■
JMB562018G2B.0Z2-SIRA	03171267	2	G	1,8	6,0	1,8	50,0	5,4	1,75	0,9	9,61	2	■
JMB562020G2B.0Z2-SIRA	03171268	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,05	2	■
JMB562025G2B.0Z2-SIRA	03171269	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	7,71	2	■
JMB562030G2B.0Z2-SIRA	03171270	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	6,35	2	■
JMB562005G4B.0Z2-SIRA	03171271	4	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	11,7	2	■
JMB562006G4B.0Z2-SIRA	03171272	4	G	0,6	6,0	0,6	50,0	4,2	0,56	0,3	11,1	2	■
JMB562008G4B.0Z2-SIRA	03171273	4	G	0,8	6,0	0,8	50,0	5,6	0,76	0,4	10,02	2	■
JMB562010G4B.0Z2-SIRA	03171274	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	2	■
JMB562012G4B.0Z2-SIRA	03171275	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	8,22	2	■
JMB562015G4B.0Z2-SIRA	03171276	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	7,07	2	■
JMB562020G4B.0Z2-SIRA	03171277	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	5,57	2	■
JMB562030G4B.0Z2-SIRA	03171279	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	3,38	2	■
JMB562005G5B.0Z2-SIRA	03171280	5	G	0,5	6,0	0,5	50,0	5,0	0,46	0,25	10,54	2	■
JMB562006G5B.0Z2-SIRA	03171281	5	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	9,85	2	■
JMB562008G5B.0Z2-SIRA	03171282	5	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	8,64	2	■
JMB562010G5B.0Z2-SIRA	03171283	5	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	7,63	2	■
JMB562012G5B.0Z2-SIRA	03171284	5	G	1,2	6,0	1,2	50,0	12,0	1,15	0,6	6,77	2	■
JMB562015G5B.0Z2-SIRA	03171285	5	G	1,5	6,0	1,5	60,0	15,0	1,45	0,75	5,68	2	■
JMB562020G5B.0Z2-SIRA	03171287	5	G	2,0	6,0	2,0	60,0	20,0	1,94	1,0	4,32	2	■
JMB562030G5B.0Z2-SIRA	03171289	5	G	3,0	6,0	3,0	70,0	30,0	2,85	1,5	2,5	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

JMB562

Miniaturizzato – Universale – A testa sferica – 2 Eliche – DMM 6 – Cilindrico



G





- Tolleranze:
- Run-out=<0,007 mm
- DMM= h5
- DC= 0,-0,01 mm
- RE= ±0,005 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JMB562010G6B.0Z2-SIRA	03171290	6	G	1,0	6,0	1,0	60,0	15,0	0,95	0,5	6,04	2	■
JMB562012G6B.0Z2-SIRA	03171291	6	G	1,2	6,0	1,2	60,0	18,0	1,15	0,6	5,24	2	■
JMB562015G6B.0Z2-SIRA	03171292	6	G	1,5	6,0	1,5	70,0	22,5	1,45	0,75	4,28	2	■
JMB562020G6B.0Z2-SIRA	03171293	6	G	2,0	6,0	2,0	80,0	30,0	1,94	1,0	3,14	2	■
JMB562030G6B.0Z2-SIRA	03171295	6	G	3,0	6,0	3,0	90,0	45,0	2,85	1,5	1,74	2	■
JMB562010G7B.0Z2-SIRA	03171296	7	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	4,99	2	■
JMB562012G7B.0Z2-SIRA	03171297	7	G	1,2	6,0	1,2	80,0	24,0	1,15	0,6	4,27	2	■
JMB562015G7B.0Z2-SIRA	03171298	7	G	1,5	6,0	1,5	80,0	30,0	1,45	0,75	3,43	2	■
JMB562020G7B.0Z2-SIRA	03171299	7	G	2,0	6,0	2,0	80,0	40,0	1,94	1,0	2,47	2	■
JMB562030G7B.0Z2-SIRA	03171301	7	G	3,0	6,0	3,0	100,0	60,0	2,85	1,5	1,34	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a αη (lαη, rif.)*

Parametri di taglio – JMB562 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	365 (330 — 400)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1200 (1100 — 1300)*
P2	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	355 (320 — 390)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1175 (1100 — 1200)*
P3	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	305 (280 — 330)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1000 (920 — 1000)*
P4	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	270 (240 — 290)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*890 (790 — 950)*
P5	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
P6	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (260 — 310)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (860 — 1000)*
P7	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	270 (250 — 300)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*890 (830 — 980)*
P8	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
P11	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	265 (240 — 290)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*870 (790 — 950)*
P12	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	155 (140 — 170)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*510 (460 — 550)*
M1	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	215 (180 — 250)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*710 (600 — 820)*
M2	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (150 — 200)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (500 — 650)*
M3	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (150 — 200)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (500 — 650)*
M4	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	130 (110 — 150)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*425 (370 — 490)*
M5	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	110 (90 — 120)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*360 (300 — 390)*
N1	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	485 (430 — 540)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1600 (1500 — 1700)*
N2	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	485 (430 — 540)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1600 (1500 — 1700)*
N3	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	325 (290 — 360)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1075 (960 — 1100)*
N11	E/M/A	0.100	0.75	0.0050	0.0075	0.010	0.012	0.015	0.020	0.025	0.030	0.046	0.050	0.060	0.075	430 (370 — 480)
		0,100	*0,75*	*0,00020*	*0,00030*	*0,00040*	*0,00048*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0018*	*0,0020*	*0,0024*	*0,0030*	*1400 (1300 — 1500)*
S11	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (250 — 330)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (830 — 1000)*
S12	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	225 (200 — 250)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*740 (660 — 820)*
S13	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (150 — 190)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (500 — 620)*
H3	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H5	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	235 (210 — 260)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*770 (690 — 850)*
H7	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H8	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	235 (210 — 260)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*770 (690 — 850)*
H11	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	300 (270 — 330)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*980 (890 — 1000)*
H12	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	275 (240 — 300)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*900 (790 — 980)*
H21	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	235 (210 — 260)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*770 (690 — 850)*
H31	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	180 (160 — 200)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*590 (530 — 650)*
GR1	A	0.500	0.50	0.0030	0.0044	0.0060	0.0075	0.0090	0.012	0.015	0.018	0.028	0.030	0.038	0.040	405 (350 — 460)
		0,500	*0,50*	*0,00012*	*0,00017*	*0,00024*	*0,00030*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,0011*	*0,0012*	*0,0015*	*0,0016*	*1325 (1200 — 1500)*

Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JMB562 Scanalatura

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	215 (200 — 230) *710 (660 — 750)*
P4	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P6	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P11	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P12	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (98 — 120) *360 (330 — 390)*
M1	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120 — 160) *445 (400 — 520)*
M2	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (90 — 130) *360 (300 — 420)*
M3	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (90 — 130) *360 (300 — 420)*
M4	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	80 (68 — 97) *260 (230 — 310)*
M5	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	70 (57 — 81) *230 (190 — 260)*
N1	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N2	E/M/A	0.26 *0,26*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N3	E/M/A	0.26 *0,26*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	265 (240 — 290) *870 (790 — 950)*
N11	E/M/A	0.24 *0,24*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	350 (300 — 390) *1150 (990 — 1200)*
S11	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	140 (120 — 150) *460 (400 — 490)*
S13	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	105 (93 — 120) *345 (310 — 390)*
H3	M/A	0.10 *0,10*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H5	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H7	M/A	0.10 *0,10*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H8	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H11	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	205 (180 — 230) *670 (600 — 750)*
H12	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
H21	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H31	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	120 (110 — 130) *395 (370 — 420)*
GR1	A	0.50 *0,50*	0.0020 *0,000080*	0.0030 *0,00012*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.018 *0,00070*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	350 (300 — 390) *1150 (990 — 1200)*

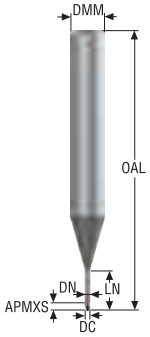
Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JMB563

Miniaturizzato – Universale – A testa sferica – 3 Eliche – DMM 6 – Cilindrico





G

- Tolleranze:
- Run-out=<0,007 mm
- DMM= h5
- DC= 0,-0,02 mm
- RE= ±0,01 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JMB563010G2B.0Z3-SIRA	03171307	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	11,15	3	■
JMB563012G2B.0Z3-SIRA	03171308	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	10,67	3	■
JMB563015G2B.0Z3-SIRA	03171309	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,07	3	■
JMB563020G2B.0Z3-SIRA	03171310	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,05	3	■
JMB563025G2B.0Z3-SIRA	03171311	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	7,71	3	■
JMB563030G2B.0Z3-SIRA	03171312	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	6,35	3	■
JMB563010G4B.0Z3-SIRA	03171316	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	3	■
JMB563012G4B.0Z3-SIRA	03171317	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	8,22	3	■
JMB563015G4B.0Z3-SIRA	03171318	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	7,07	3	■
JMB563020G4B.0Z3-SIRA	03171319	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	5,57	3	■
JMB563030G4B.0Z3-SIRA	03171321	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	3,38	3	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JMB563 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z						v_c
				1	1.2	1.5	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	460 (410 — 500) *1500 (1400 — 1600)*
P2	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	445 (400 — 490) *1450 (1400 — 1600)*
P3	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	385 (350 — 420) *1275 (1200 — 1300)*
P4	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	340 (310 — 370) *1125 (1100 — 1200)*
P5	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 350) *1075 (960 — 1100)*
P6	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100 — 1300)*
P7	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	340 (310 — 380) *1125 (1100 — 1200)*
P8	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 350) *1075 (960 — 1100)*
P11	M/E/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	230 (190 — 270) *750 (630 — 880)*
P12	M/E/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120 — 160) *445 (400 — 520)*
M1	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (230 — 320) *890 (760 — 1000)*
M2	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (180 — 250) *720 (600 — 820)*
M3	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (180 — 250) *720 (600 — 820)*
M4	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	165 (140 — 190) *540 (460 — 620)*
M5	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120 — 160) *445 (400 — 520)*
N1	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	590 (520 — 660) *1925 (1800 — 2100)*
N2	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	590 (520 — 660) *1925 (1800 — 2100)*
N3	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	395 (350 — 440) *1300 (1200 — 1400)*
N11	E/M/A	0.100 *0,100*	0.65 *0,65*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	520 (450 — 590) *1700 (1500 — 1900)*
S11	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	345 (300 — 390) *1125 (990 — 1200)*
S12	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (230 — 300) *870 (760 — 980)*
S13	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	205 (180 — 230) *670 (600 — 750)*
H3	M/A	0.0250 *0,0250*	0.095 *0,095*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	155 (120 — 190) *510 (400 — 620)*
H5	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H7	M/A	0.0250 *0,0250*	0.095 *0,095*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	155 (120 — 190) *510 (400 — 620)*
H8	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H11	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	375 (330 — 420) *1225 (1100 — 1300)*
H12	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	345 (310 — 380) *1125 (1100 — 1200)*
H21	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H31	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	450 (390 — 510) *1475 (1300 — 1600)*

Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi



ACCIAIO E GHISA

Seco offre una gamma completa di frese a spallamento retto in metallo duro integrale ad alte prestazioni, frese a testa sferica e frese integrali per finitura che aumentano la produttività su acciaio e ghisa.

- JHP993, JHP951 e JH142 per tipo con smusso o raggio.
- JHB970, JH112, JH150, JH160 per tipo a testa sferica.

Selezione utensile acciaio e ghisa

					
Nome		JHP993	JHP951	JH142	JHB970
Pag.		193	199	203, 395	145, 206
Famiglia		HPM	HPM	HSM/TORNADO	HSM/TORNADO
Tipo di fresa					
Attacco	Cilindrico	■	■	■	■
	Weldon	■	■		
Numero di eliche		3,4,5	3,4,5	2-4-5-6	2
Adduz. refrig. interna					
	Metrico	4-25	3-20	2-12	2-16
	Pollici				
Lunghezze disponibili		2,3	2	2,3,6	1,2,3
Operazione					
					
SMG					
P1		●	●	●	●
P2		●	●	●	●
P3		●	●	●	●
P4		●	●	●	●
P5		●	●	●	●
P6		●	●	●	●
P7		●	●	●	●
P8		●	●	●	●
P11-12		○	○	●	○
K1		●	●	●	
K2		●	●	●	
K3		●	●	●	
K4		●	●	●	
K5		●	●	●	
K6		●	●	●	
K7		●	●	●	

■ Prodotto standard ☐ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

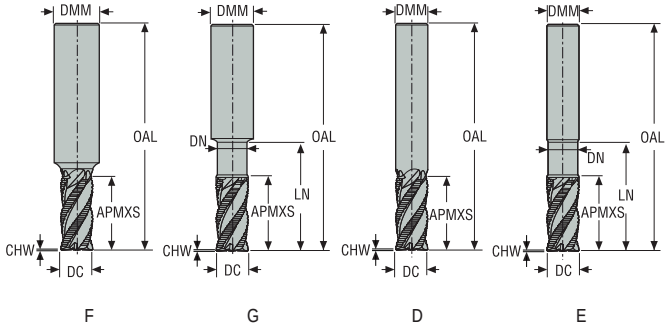
Selezione utensile acciaio e ghisa

				
Nome		JH112	JH150	JH160
Pag.		208, 398	401	403
Famiglia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Tipo di fresa				
Attacco	Cilindrico	■	■	■
	Weldon			
Numero di eliche		2	4	4
Adduz. refrig. interna				
	Metrico	2-12	6-12	3-12
	Pollici			
Lunghezze disponibili		1,2,3,4,5,6	2	2
Operazione				
				
SMG				
P1				●
P2				●
P3				●
P4				●
P5				●
P6				●
P7				●
P8				●
P11-12				○
K1		●	●	
K2		●	●	
K3		●	●	
K4		●	●	
K5		●	●	
K6		●	●	
K7		●	●	

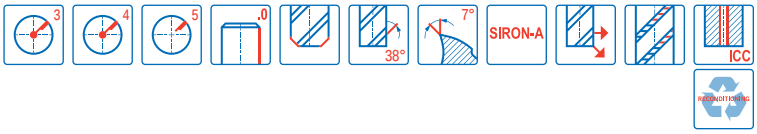
■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

JHP993

Alte prestazioni – Acciaio – Spallamento – 3-5 Eliche – Cilindrico – Smusso







- Tolleranze:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø6

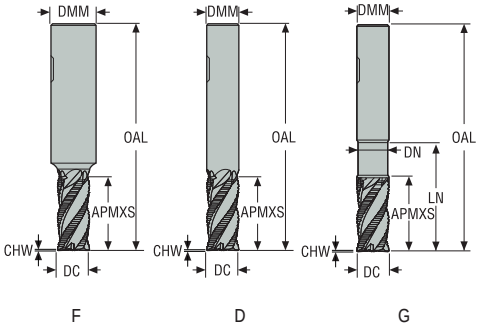
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JHP993040F2C.0Z3-SIRA	02826806	2	F	–	4,0	6,0	10,0	50,0	12,56	4,0	0,15	3	■
JHP993050F2C.0Z4-SIRA	02826808	2	F	–	5,0	6,0	12,0	55,0	14,75	5,0	0,15	4	■
JHP993060D2C.0Z4-SIRA	02826809	2	D	–	6,0	6,0	14,0	55,0	–	–	0,2	4	■
JHP993075F2C.0Z4-SIRA	02826811	2	F	–	7,5	8,0	17,0	60,0	20,0	7,5	0,2	4	■
JHP993080D2C.0Z4A-SIRA	02826814	2	D	■	8,0	8,0	18,0	60,0	–	–	0,2	4	■
JHP993080D2C.0Z4-SIRA	02826812	2	D	–	8,0	8,0	18,0	60,0	–	–	0,2	4	■
JHP993095F2C.0Z4-SIRA	02826816	2	F	–	9,5	10,0	20,0	70,0	23,0	9,5	0,2	4	■
JHP993100D2C.0Z4A-SIRA	02826818	2	D	■	10,0	10,0	22,0	70,0	–	–	0,2	4	■
JHP993100D2C.0Z4-SIRA	02826817	2	D	–	10,0	10,0	22,0	70,0	–	–	0,2	4	■
JHP993115F2C.0Z4-SIRA	02826820	2	F	–	11,5	12,0	25,0	80,0	28,0	11,5	0,2	4	■
JHP993120D2C.0Z4A-SIRA	02826822	2	D	■	12,0	12,0	26,0	80,0	–	–	0,2	4	■
JHP993120D2C.0Z4-SIRA	02826821	2	D	–	12,0	12,0	26,0	80,0	–	–	0,2	4	■
JHP993140D2C.0Z4-SIRA	02826824	2	D	–	14,0	14,0	30,0	80,0	–	–	0,3	4	■
JHP993160D2C.0Z4A-SIRA	02856501	2	D	■	16,0	16,0	34,0	90,0	–	–	0,3	4	■
JHP993160D2C.0Z4-SIRA	02856499	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	4	■
JHP993160D2C.0Z5-SIRA	02826825	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	5	■
JHP993200D2C.0Z4A-SIRA	02856506	2	D	■	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.0Z4-SIRA	02856505	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.0Z5-SIRA	02826828	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	5	■
JHP993250D2C.0Z4A-SIRA	02856510	2	D	■	25,0	25,0	52,0	125,0	–	–	0,5	4	■
JHP993040G3C.0Z3-SIRA	02826807	3	G	–	4,0	6,0	10,0	55,0	15,0	3,7	0,15	3	■
JHP993060E3C.0Z4-SIRA	02826810	3	E	–	6,0	6,0	14,0	65,0	24,0	5,6	0,2	4	■
JHP993080E3C.0Z4-SIRA	02826815	3	E	–	8,0	8,0	18,0	70,0	32,0	7,4	0,2	4	■
JHP993100E3C.0Z4-SIRA	02826819	3	E	–	10,0	10,0	22,0	85,0	40,0	9,4	0,2	4	■
JHP993120E3C.0Z4-SIRA	02826823	3	E	–	12,0	12,0	26,0	100,0	50,0	11,4	0,2	4	■
JHP993160E3C.0Z4-SIRA	02856502	3	E	–	16,0	16,0	34,0	110,0	60,0	15,4	0,3	4	■
JHP993200E3C.0Z4-SIRA	02856507	3	E	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	4	■

■ Prodotto standard.

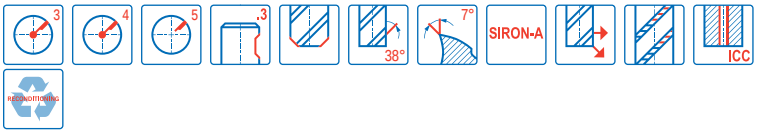
JHP993

Alte prestazioni – Acciaio – Spallamento – 3-5 Eliche – Weldon – Smusso





- Tolleranze:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø6



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP993040F2C.3Z3-SIRA	02828150	2	F	–	4,0	6,0	10,0	50,0	12,56	4,0	0,15	3	■
JHP993050F2C.3Z4-SIRA	02828152	2	F	–	5,0	6,0	12,0	55,0	14,75	5,0	0,15	4	■
JHP993060D2C.3Z4-SIRA	02828153	2	D	–	6,0	6,0	14,0	55,0	–	–	0,2	4	■
JHP993075F2C.3Z4-SIRA	02828155	2	F	–	7,5	8,0	17,0	60,0	20,0	7,5	0,2	4	■
JHP993080D2C.3Z4A-SIRA	02828246	2	D	■	8,0	8,0	16,0	60,0	–	–	0,2	4	□
JHP993080D2C.3Z4-SIRA	02828156	2	D	–	8,0	8,0	18,0	60,0	–	–	0,2	4	■
JHP993095F2C.3Z4-SIRA	02828158	2	F	–	9,5	10,0	20,0	70,0	23,0	9,5	0,2	4	■
JHP993100D2C.3Z4A-SIRA	02828247	2	D	■	10,0	10,0	22,0	70,0	–	–	0,2	4	□
JHP993100D2C.3Z4-SIRA	02828159	2	D	–	10,0	10,0	22,0	70,0	–	–	0,2	4	■
JHP993120D2C.3Z4A-SIRA	02828248	2	D	■	12,0	12,0	26,0	80,0	–	–	0,2	4	□
JHP993120D2C.3Z4-SIRA	02828162	2	D	–	12,0	12,0	26,0	80,0	–	–	0,2	4	■
JHP993140D2C.3Z4-SIRA	02828164	2	D	–	14,0	14,0	30,0	80,0	–	–	0,3	4	■
JHP993160D2C.3Z4A-SIRA	02856512	2	D	■	16,0	16,0	34,0	90,0	–	–	0,3	4	□
JHP993160D2C.3Z4-SIRA	02856500	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	4	■
JHP993160D2C.3Z5-SIRA	02828165	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	5	■
JHP993200D2C.3Z4A-SIRA	02856513	2	D	■	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.3Z4-SIRA	02856504	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.3Z5-SIRA	02828167	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	5	■
JHP993250D2C.3Z4A-SIRA	02856514	2	D	■	25,0	25,0	52,0	125,0	–	–	0,5	4	□
JHP993250D2C.3Z4-SIRA	02856509	2	D	–	25,0	25,0	52,0	125,0	–	–	0,5	4	■
JHP993060E3C.3Z4-SIRA	02828154	3	E	–	6,0	6,0	14,0	65,0	24,0	5,6	0,2	4	■
JHP993080E3C.3Z4-SIRA	02828157	3	E	–	8,0	8,0	18,0	70,0	32,0	7,4	0,2	4	■
JHP993100E3C.3Z4-SIRA	02828160	3	E	–	10,0	10,0	22,0	85,0	40,0	9,4	0,2	4	■
JHP993120E3C.3Z4-SIRA	02828163	3	E	–	12,0	12,0	26,0	100,0	50,0	11,4	0,2	4	■
JHP993160E3C.3Z4-SIRA	02856503	3	E	–	16,0	16,0	34,0	110,0	60,0	15,4	0,3	4	■
JHP993200E3C.3Z4-SIRA	02856508	3	E	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	4	■
JHP993200E3C.3Z5-SIRA	02828168	3	E	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	5	■
JHP993250E3C.3Z4-SIRA	02856511	3	E	–	25,0	25,0	52,0	150,0	90,0	24,0	0,5	4	■

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

Parametri di taglio – JHP993 Contornatura PCEDC=3 e PCEDC=4

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	230 (200 — 260) *750 (660 — 850)*
P2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	225 (200 — 250) *740 (660 — 820)*
P3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	195 (170 — 220) *640 (560 — 720)*
P4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	175 (150 — 190) *570 (500 — 620)*
P5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	165 (150 — 190) *540 (500 — 620)*
P6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	175 (160 — 200) *570 (530 — 650)*
P8	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
P11	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	110 (95 — 120) *360 (320 — 390)*
K1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	200 (180 — 220) *660 (600 — 720)*
K3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	170 (150 — 190) *560 (500 — 620)*
K4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
K5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	100 (86 — 110) *330 (290 — 360)*
K6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
K7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	125 (110 — 140) *410 (370 — 450)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JHP993 Contornatura PCEDC=5

SMG		a_e/DC	a_p/DC	f_z		v_c
				16	20	
P1	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.22 *0,0085*	205 (180 — 230) *670 (600 — 750)*
P2	E/M/A	0.376 *0,376*	1.0 *1,0*	0.18 *0,0070*	0.22 *0,0085*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.20 *0,0080*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	165 (150 — 180) *540 (500 — 590)*
P7	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	155 (140 — 170) *510 (460 — 550)*
P8	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
P11	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	150 (130 — 170) *490 (430 — 550)*
P12	E/M/A	0.376 *0,376*	1.0 *1,0*	0.11 *0,0044*	0.13 *0,0050*	100 (85 — 110) *330 (280 — 360)*
K1	E/M/A	0.376 *0,376*	1.0 *1,0*	0.18 *0,0070*	0.22 *0,0085*	195 (170 — 220) *640 (560 — 720)*
K2	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	175 (160 — 200) *570 (530 — 650)*
K3	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	150 (130 — 170) *490 (430 — 550)*
K4	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
K5	E/M/A	0.376 *0,376*	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	85 (75 — 99) *280 (250 — 320)*
K6	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	125 (110 — 140) *410 (370 — 450)*
K7	E/M/A	0.376 *0,376*	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	110 (96 — 120) *360 (320 — 390)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JHP993 Scanalatura PCEDC=3 e PCEDC=4

SMG		a_p/DC	f_z										v_c
			4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	165 (150 — 190) *540 (500 — 620)*
P4	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	155 (140 — 170) *510 (460 — 550)*
P7	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	150 (130 — 160) *490 (430 — 520)*
P8	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	140 (130 — 160) *460 (430 — 520)*
P11	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	145 (130 — 160) *475 (430 — 520)*
P12	E/M/A	1.5 *1,5*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	90 (76 — 100) *295 (250 — 320)*
K1	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	195 (170 — 220) *640 (560 — 720)*
K2	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	170 (150 — 190) *560 (500 — 620)*
K3	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	145 (130 — 160) *475 (430 — 520)*
K4	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	135 (120 — 150) *445 (400 — 490)*
K5	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	80 (70 — 93) *260 (230 — 300)*
K6	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
K7	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	105 (90 — 110) *345 (300 — 360)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JHP993 Scanalatura PCEDC=5

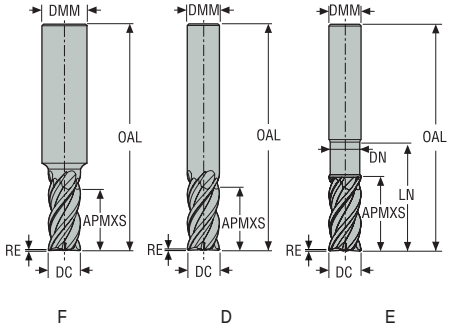
SMG		a_p/DC	f_z		v_c
			16	20	
P1	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
P2	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.22 *0,0085*	155 (140 — 170) *510 (460 — 550)*
P3	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	135 (120 — 150) *445 (400 — 490)*
P4	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	120 (110 — 130) *395 (370 — 420)*
P5	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	115 (99 — 130) *375 (330 — 420)*
P6	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	130 (120 — 140) *425 (400 — 450)*
P7	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
P8	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	115 (99 — 130) *375 (330 — 420)*
P11	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
P12	E/M/A	0.44 *0,44*	0.11 *0,0044*	0.13 *0,0050*	80 (68 — 89) *260 (230 — 290)*
K1	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.22 *0,0085*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	140 (120 — 150) *460 (400 — 490)*
K3	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
K4	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	115 (97 — 120) *375 (320 — 390)*
K5	E/M/A	0.44 *0,44*	0.14 *0,0055*	0.17 *0,0065*	70 (60 — 79) *230 (200 — 250)*
K6	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	100 (86 — 110) *330 (290 — 360)*
K7	E/M/A	0.44 *0,44*	0.14 *0,0055*	0.17 *0,0065*	90 (77 — 100) *295 (260 — 320)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JHP951

Alte prestazioni – Spallamento – Acciaio – 3-5 Eliche – Cilindrico – Raggio di punta o smusso







- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

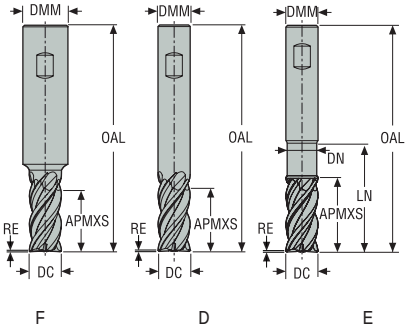
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm		
JHP951030F2C.0Z3-SIRA	02828192	2	F	3,0	6,0	8,0	50,0	10,25	3,0	0,1	–	3	■
JHP951030F2R020.0Z3-SIRA	02828191	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,2	3	■
JHP951030F2R050.0Z3-SIRA	02828190	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,5	3	■
JHP951040F2C.0Z4-SIRA	02828197	2	F	4,0	6,0	10,0	55,0	13,25	4,0	0,15	–	4	■
JHP951040F2R020.0Z4-SIRA	02828194	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,2	4	■
JHP951040F2R050.0Z4-SIRA	02828195	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,5	4	■
JHP951050F2C.0Z4-SIRA	02828201	2	F	5,0	6,0	12,0	55,0	15,25	5,0	0,2	–	4	■
JHP951050F2R020.0Z4-SIRA	02828199	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,2	4	■
JHP951050F2R050.0Z4-SIRA	02828198	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,5	4	■
JHP951060D2C.0Z4-SIRA	02828205	2	D	6,0	6,0	14,0	55,0	–	–	0,2	–	4	■
JHP951060D2R020.0Z4-SIRA	02828203	2	D	6,0	6,0	14,0	55,0	–	–	–	0,2	4	■
JHP951060D2R050.0Z4-SIRA	02828202	2	D	6,0	6,0	14,0	55,0	–	–	–	0,5	4	■
JHP951080D2C.0Z4-SIRA	02828212	2	D	8,0	8,0	18,0	60,0	–	–	0,3	–	4	■
JHP951080D2R020.0Z4-SIRA	02828209	2	D	8,0	8,0	18,0	60,0	–	–	–	0,2	4	■
JHP951080D2R050.0Z4-SIRA	02828207	2	D	8,0	8,0	18,0	60,0	–	–	–	0,5	4	■
JHP951080D2R100.0Z4-SIRA	02828208	2	D	8,0	8,0	18,0	60,0	–	–	–	1,0	4	■
JHP951100E2C.0Z4-SIRA	02828218	2	E	10,0	10,0	22,0	70,0	28,0	9,4	0,3	–	4	■
JHP951100E2R050.0Z4-SIRA	02828216	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	0,5	4	■
JHP951100E2R100.0Z4-SIRA	02828214	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	1,0	4	■
JHP951120E2C.0Z4-SIRA	02828226	2	E	12,0	12,0	26,0	80,0	33,0	11,4	0,4	–	4	■
JHP951120E2R050.0Z4-SIRA	02828224	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	0,5	4	■
JHP951120E2R100.0Z4-SIRA	02828222	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	1,0	4	■
JHP951160E2C.0Z4-SIRA	02927873	2	E	16,0	16,0	34,0	90,0	40,0	15,0	0,5	–	4	■
JHP951160E2C.0Z5-SIRA	02828232	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	■
JHP951160E2R050.0Z4-SIRA	02927875	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	■
JHP951160E2R050.0Z5-SIRA	02828230	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	■
JHP951160E2R100.0Z4-SIRA	02927876	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	■
JHP951160E2R100.0Z5-SIRA	02828231	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	1,0	5	■

■ Prodotto standard.

JHP951

Alte prestazioni – Spallamento – Acciaio – 3-5 Eliche – Weldon – Raggio di punta o smusso





- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JHP951030F2C.3Z3-SIRA	02828193	2	F	3,0	6,0	8,0	50,0	10,25	3,0	0,1	–	3	■
JHP951030F2R020.3Z3-SIRA	02828260	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,2	3	■
JHP951030F2R050.3Z3-SIRA	02828259	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,5	3	□
JHP951040F2C.3Z4-SIRA	02828196	2	F	4,0	6,0	10,0	55,0	13,25	4,0	0,15	–	4	■
JHP951040F2R020.3Z4-SIRA	02828261	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,2	4	□
JHP951040F2R050.3Z4-SIRA	02828262	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,5	4	□
JHP951050F2C.3Z4-SIRA	02828200	2	F	5,0	6,0	12,0	55,0	15,25	5,0	0,2	–	4	■
JHP951050F2R020.3Z4-SIRA	02828264	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,2	4	□
JHP951050F2R050.3Z4-SIRA	02828263	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,5	4	□
JHP951060D2C.3Z4-SIRA	02828206	2	D	6,0	6,0	14,0	55,0	–	–	0,2	–	4	■
JHP951060D2R020.3Z4-SIRA	02828266	2	D	6,0	6,0	14,0	55,0	–	–	–	0,2	4	□
JHP951060D2R050.3Z4-SIRA	02828265	2	D	6,0	6,0	14,0	55,0	–	–	–	0,5	4	□
JHP951080D2C.3Z4-SIRA	02828210	2	D	8,0	8,0	18,0	60,0	–	–	0,3	–	4	■
JHP951080D2R020.3Z4-SIRA	02828269	2	D	8,0	8,0	18,0	60,0	–	–	–	0,2	4	□
JHP951080D2R050.3Z4-SIRA	02828267	2	D	8,0	8,0	18,0	60,0	–	–	–	0,5	4	■
JHP951080D2R100.3Z4-SIRA	02828268	2	D	8,0	8,0	18,0	60,0	–	–	–	1,0	4	□
JHP951100E2C.3Z4-SIRA	02828220	2	E	10,0	10,0	22,0	70,0	28,0	9,4	0,3	–	4	■
JHP951100E2R050.3Z4-SIRA	02828271	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	0,5	4	□
JHP951100E2R100.3Z4-SIRA	02828270	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	1,0	4	□
JHP951120E2C.3Z4-SIRA	02828228	2	E	12,0	12,0	26,0	80,0	33,0	11,4	0,4	–	4	■
JHP951120E2R050.3Z4-SIRA	02828273	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	0,5	4	□
JHP951120E2R100.3Z4-SIRA	02828272	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	1,0	4	□
JHP951160E2C.3Z4-SIRA	02927874	2	E	16,0	16,0	34,0	90,0	40,0	15,0	0,5	–	4	■
JHP951160E2C.3Z5-SIRA	02828233	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	■
JHP951160E2R050.3Z4-SIRA	02927879	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	□
JHP951160E2R050.3Z5-SIRA	02828275	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	□
JHP951160E2R100.3Z4-SIRA	02927880	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	□
JHP951160E2R100.3Z5-SIRA	02828276	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	1,0	5	□
JHP951200E2R050.3Z4-SIRA	02927877	2	E	20,0	20,0	42,0	100,0	48,0	19,0	–	0,5	4	■
JHP951200E2R050.3Z5-SIRA	02828235	2	E	20,0	20,0	42,0	100,0	48,0	19,4	–	0,5	5	■
JHP951200E2R100.3Z4-SIRA	02927878	2	E	20,0	20,0	42,0	100,0	48,0	19,0	–	1,0	4	■
JHP951200E2R100.3Z5-SIRA	02828234	2	E	20,0	20,0	42,0	100,0	48,0	19,4	–	1,0	5	■

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

Parametri di taglio – JHP951 Contornatura

SMG		a_e/DC	a_p/DC	f_z									v_c
				3	4	5	6	8	10	12	16	20	
P1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	230 (200 — 260) *750 (660 — 850)*
P2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	220 (200 — 250) *720 (660 — 820)*
P3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	190 (170 — 210) *620 (560 — 680)*
P4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	170 (150 — 190) *560 (500 — 620)*
P5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	175 (150 — 190) *570 (500 — 620)*
P8	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P11	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.400 *0,400*	1.7 *1,7*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	110 (94 — 120) *360 (310 — 390)*
K1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	200 (180 — 220) *660 (600 — 720)*
K3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (150 — 190) *560 (500 — 620)*
K4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
K5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	100 (85 — 110) *330 (280 — 360)*
K6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	140 (130 — 160) *460 (430 — 520)*
K7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	125 (110 — 140) *410 (370 — 450)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JHP951 Scanalatura

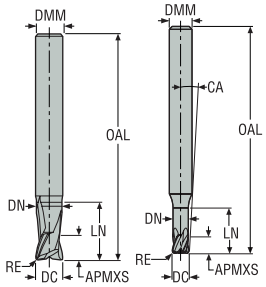
SMG		a_p/DC	f_z									v_c
			3	4	5	6	8	10	12	16	20	
P1	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*
P2	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	190 (170 — 210) *620 (560 — 680)*
P3	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	140 (120 — 150) *460 (400 — 490)*
P6	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
P7	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	145 (130 — 160) *475 (430 — 520)*
P8	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	140 (120 — 150) *460 (400 — 490)*
P11	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	145 (130 — 160) *475 (430 — 520)*
P12	E/M/A	1.5 *1,5*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	85 (75 — 99) *280 (250 — 320)*
K1	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*
K2	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	170 (150 — 190) *560 (500 — 620)*
K3	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	140 (130 — 160) *460 (430 — 520)*
K4	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	135 (120 — 150) *445 (400 — 490)*
K5	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.15 *0,0060*	80 (70 — 92) *260 (230 — 300)*
K6	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	120 (110 — 130) *395 (370 — 420)*
K7	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.15 *0,0060*	105 (89 — 110) *345 (300 — 360)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

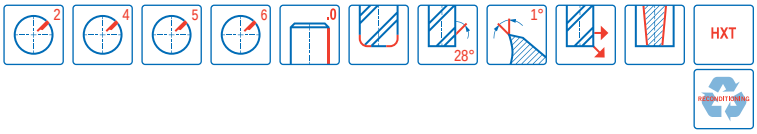
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH142

Alta velocità – Alta precisione – Torico – Acciaio temprato – 2-6 Eliche – Cilindrico – Raggio di punta







- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Riaffilatura possibile se DC è ≥Ø6

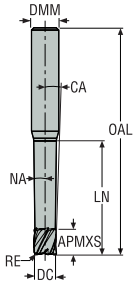
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	■

■ Prodotto standard. Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

JH142

Alta velocità – Alta precisione – Torico – Acciaio temprato – 2-5 Eliche – Cilindrico – Raggio di punta





J

- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Riaffilatura possibile se DC è ≥Ø6



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JH142020J3R030.0Z2-HXT	02968255	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	2	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	4	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	2	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	4	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	2	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	4	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	2	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	4	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	2	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	4	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	2	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	4	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	2	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	4	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	4	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	5	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	4	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	5	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	5	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	5	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	5	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	5	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	5	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	5	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	5	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	5	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	5	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	4	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	4	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	4	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	4	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	4	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	4	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	4	■

■ Prodotto standard. Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JH142 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600 — 1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	470 (450 — 520) *1550 (1500 — 1700)*
P3	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	405 (390 — 450) *1325 (1300 — 1400)*
P4	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	360 (340 — 390) *1175 (1200 — 1200)*
P5	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
P6	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	385 (370 — 420) *1275 (1300 — 1300)*
P7	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	365 (350 — 400) *1200 (1200 — 1300)*
P8	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	340 (330 — 380) *1125 (1100 — 1200)*
P11	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	355 (340 — 390) *1175 (1200 — 1200)*
K1	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K2	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	300 (290 — 330) *980 (960 — 1000)*
K3	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	255 (240 — 280) *840 (790 — 910)*
K4	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	245 (230 — 260) *800 (760 — 850)*
K5	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K6	A/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (480 — 550) *1650 (1600 — 1800)*
K7	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	440 (420 — 490) *1450 (1400 — 1600)*
H3	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H5	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	305 (290 — 330) *1000 (960 — 1000)*
H7	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H8	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H11	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	390 (360 — 420) *1275 (1200 — 1300)*
H12	M/A	0.0500 *0,0500*	0.050 *0,050*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	345 (320 — 370) *1125 (1100 — 1200)*
H21	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H31	M/A	0.0300 *0,0300*	0.030 *0,030*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	140 (120 — 160) *460 (400 — 520)*

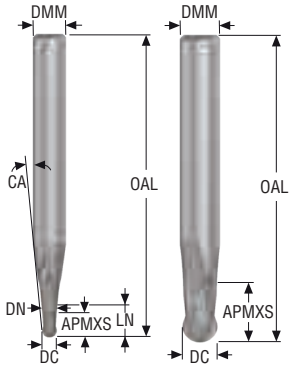
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

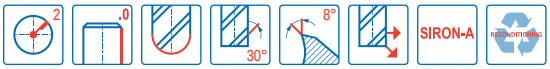
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JHB970

Alta velocità – Universale – A testa sferica – 2 Eliche – Cilindrico







- Tolleranze:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm			
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	2,5	2	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	–	2	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	–	2	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	–	2	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	–	2	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	8,0	2	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	7,5	2	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	5,5	2	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	4,5	2	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	3,0	2	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,0	2	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	2,5	2	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	–	2	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	–	2	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	–	2	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	–	2	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	8,0	2	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	5,5	2	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	3,0	2	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	2,5	2	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	–	2	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	–	2	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	–	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JHB970 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
P1	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	210 (190 — 230) *690 (630 — 750)*
P2	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	205 (180 — 230) *670 (600 — 750)*
P3	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
P4	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	155 (140 — 170) *510 (460 — 550)*
P5	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P6	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	170 (150 — 190) *560 (500 — 620)*
P7	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	160 (140 — 180) *520 (460 — 590)*
P8	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P11	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	75 (67 — 86) *245 (220 — 280)*
P12	M	0.200 *0,200*	1.0 *1,0*	0.0070 *0,00028*	0.0085 *0,00034*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	48 (42 — 53) *155 (140 — 170)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	90 (80 — 100) *295 (270 — 320)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	75 (65 — 85) *245 (220 — 270)*
M3	E	0.150 *0,150*	1.0 *1,0*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	65 (55 — 75) *215 (190 — 240)*
M4	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	49 (42 — 56) *160 (140 — 180)*
M5	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	41 (35 — 47) *135 (120 — 150)*
S1	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	50 (40 — 59) *165 (140 — 190)*
S2	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	40 (33 — 48) *130 (110 — 150)*
S3	E	0.100 *0,100*	0.60 *0,60*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0070 *0,00028*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.028 *0,0011*	30 (20 — 39) *100 (66 — 120)*
S11	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79 — 100) *295 (260 — 320)*
S12	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.200 *0,200*	1.0 *1,0*	0.0085 *0,00034*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*

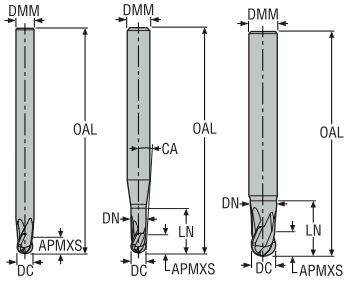
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH112

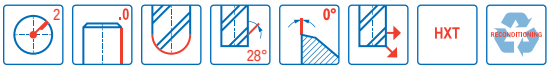
Alta velocità – Alta precisione – Acciaio temprato – A testa sferica – 2 Eliche – Cilindrico





D G E

- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Riaffilatura possibile se DC è ≥Ø6



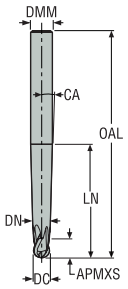
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm			
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	6,45	2	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	3,3	2	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	–	2	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,0	2	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	–	2	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	–	2	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	–	2	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	2,5	2	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	–	2	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	–	2	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	–	2	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	–	2	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	8,12	2	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	7,39	2	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	5,5	2	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	3,81	2	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	3,34	2	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,0	2	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	2,78	2	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	–	2	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	–	2	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	–	2	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	3,82	2	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	2,91	2	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	1,97	2	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	0,53	2	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	–	2	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	–	2	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	–	2	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	–	2	■

■ Prodotto standard.

Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

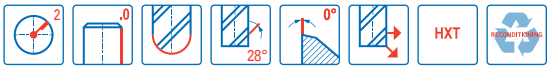
JH112

Alta velocità – Alta precisione – Acciaio temprato – A testa sferica – 2 Eliche – Cilindrico



J





- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm			
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	35,0	1,9	3,3	2	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	40,0	2,8	2,2	2	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	52,0	3,7	1,2	2	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	56,0	4,6	1,6	2	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	56,0	5,6	1,1	2	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	62,0	7,4	1,0	2	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	61,0	9,4	1,0	2	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	62,0	5,6	2,0	2	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	67,0	7,4	1,8	2	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	79,0	9,4	0,8	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a αη (lαη, rif.)*

Parametri di taglio – JH112 Copiatura finitura

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	520 (500 — 730) *1700 (1700 — 2300)*
K2	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	445 (430 — 630) *1450 (1500 — 2000)*
K3	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	380 (360 — 530) *1250 (1200 — 1700)*
K4	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (350 — 510) *1175 (1200 — 1600)*
K5	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K6	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	610 (550 — 900) *2000 (1900 — 2900)*
K7	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	680 (560 — 790) *2225 (1900 — 2500)*
H3	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H5	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H7	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H8	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H11	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (300 — 420) *1175 (990 — 1300)*
H12	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	330 (280 — 380) *1075 (920 — 1200)*
H21	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H31	M	0.30 *0,30*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	300 (290 — 430) *980 (960 — 1400)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JH112 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100 — 1400)*
K2	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	280 (270 — 390) *920 (890 — 1200)*
K3	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	235 (230 — 330) *770 (760 — 1000)*
K4	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	225 (220 — 320) *740 (730 — 1000)*
K5	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	280 (250 — 410) *920 (830 — 1300)*
K6	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K7	E	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	420 (350 — 490) *1375 (1200 — 1600)*
H3	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H5	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H7	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H8	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H11	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	225 (190 — 260) *740 (630 — 850)*
H12	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	205 (170 — 240) *670 (560 — 780)*
H21	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H31	M	0.200 *0,200*	0.10 *0,10*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	200 (200 — 280) *660 (660 — 910)*

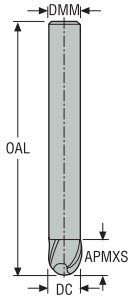
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH150

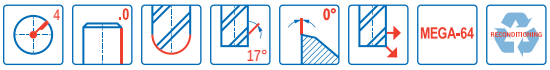
Alta velocità – Acciaio temprato – A testa sferica – 4 Eliche – Cilindrico





D

- Tolleranze:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
				mm	mm	mm	mm		
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	4	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	4	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	4	■

■ Prodotto standard.

Parametri di taglio – JH150 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100 — 1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890 — 1000)*
K3	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (230 — 270) *690 (760 — 880)*
K5	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	255 (270 — 330) *840 (890 — 1000)*
K6	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	375 (390 — 500) *1225 (1300 — 1600)*
K7	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	325 (340 — 430) *1075 (1200 — 1400)*
H3	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H5	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H7	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H8	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H11	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	230 (210 — 250) *750 (690 — 820)*
H12	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 230) *690 (630 — 750)*
H21	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H31	M	0.150 *0,150*	0.060 *0,060*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	125 (130 — 180) *410 (430 — 590)*

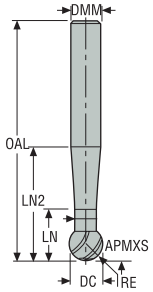
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH160

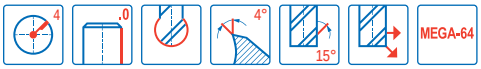
Alta velocità – Acciaio temprato – A testa sferica – 4 Eliche – Cilindrico





E

- Tolleranze:
- DMM= h5
- DC= 0,02/-0,06 mm
- SA=250°



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm		
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	9,0	1,8	1,5	4	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	11,0	2,4	2,0	4	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	13,0	3,0	2,5	4	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	17,3	3,6	3,0	4	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	21,3	4,8	4,0	4	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	27,9	6,0	5,0	4	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	31,8	7,2	6,0	4	■

■ Prodotto standard.

Parametri di taglio – JH160 Copiatura finitura

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
P1	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	550 (450 — 700) *1800 (1500 — 2200)*
P2	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	530 (440 — 680) *1750 (1500 — 2200)*
P3	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	460 (380 — 590) *1500 (1300 — 1900)*
P4	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	405 (340 — 520) *1325 (1200 — 1700)*
P5	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P6	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	430 (360 — 560) *1400 (1200 — 1800)*
P7	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	410 (340 — 520) *1350 (1200 — 1700)*
P8	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P11	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	395 (330 — 510) *1300 (1100 — 1600)*
P12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	235 (200 — 300) *770 (660 — 980)*
H3	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H5	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H7	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H8	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H11	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	430 (400 — 460) *1400 (1400 — 1500)*
H12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	355 (340 — 380) *1175 (1200 — 1200)*
H21	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H31	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	165 (180 — 210) *540 (600 — 680)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi



ACCIAIO INOSSIDABILE E MATERIALI S

Seco offre una gamma completa di frese a spallamento retto in metallo duro integrale ad alte prestazioni, frese a testa sferica e frese integrali per finitura che aumentano la produttività su acciaio inossidabile, acciaio e materiali S ISO.

- JS754, JS755, JS720, JHP751, JHP760, JHP770, JHP780, JHP794, JCG790, JH770, JH740, JH710, JH790, JH730, JHP994, SHF712, SME714, SME716 e JCO710 per tipo con smusso o raggio.
- JS730, JH780, JHB720, JH721, JH722, SMB713, SMB714 e SMB716 per tipo a testa sferica.
- JH724, JH726, JH734, JH736, JH744, JH746 per tipo a barile.

Selezione utensile acciaio inossidabile e materiali S

								
Nome		JS754	JS755	JS720	JS730	JHP751	JHP760	JHP770
Pag.		221	238	249	269	273	276	280
Famiglia		SOLID²	SOLID²	SOLID²	SOLID²	HPM	HPM	HPM
Tipo di fresa								
Attacco	Cilindrico	■	■	■	■	■	■	■
	Weldon	■	■	■	□	■	■	■
	Safelock	□	□	□	□			□
Numero di eliche		4	5	6-9	6	2-4	2,3,4	4-5
Adduz. refrig. interna		■					■	■
	Metrico	3-25	6-25	6-25	6-25	2-20	4-25	6-25
	Pollici							
Lunghezze disponibili		2,3	2,3	2,3	2,3	1,2	2,3	2
Operazione								
								
								
								
SMG								
M1		•	•	•	•		•	
M2		•	•	•	•		•	
M3		•	•	•	•		•	
M4		•	•	•	•		•	
M5		•	•	•	•		•	
S1		•	•	•	•	•		
S2		•	•	•	•	•		
S3		•	•	•	•	•		
S11		•	•	•	•	•		•
S12		•	•	•	•	•		•
S13		•	•	•	•	•		•

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni. □ Safe-Lock disponibile, tempo di consegna 6 giorni
• Prima scelta ○ Scelta alternativa

Selezione utensile acciaio inossidabile e materiali S



		JHP780	JHP794	JCG790	JH724	JH726	JH734	JH736	JH744	JH746
Nome										
Pag.		287	276	294	326	326	300	302	304	306
Famiglia		HPM	HPM	Ceramic	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO
Tipo di fresa		r	r	r						
Attacco	Cilindrico	■		■	■	■	■	■	■	■
	Weldon	■	■							
	Safelock	□								
Numero di eliche		4	4	5-6	6	6	4	6	4	6
Adduz. refrig. interna		■	■						■	■
	Metrico	6-25	6-25	6-25	10	10	6-16	10-16	4-16	10-16
	Pollici									
Lunghezze disponibili		2	2	2	2	2	2	2	2,4	2
Operazione										
SMG										
M1			●		●	●	●	●	●	●
M2			●		●	●	●	●	●	●
M3			●		●	●	●	●	●	●
M4			●		●	●				
M5			●		●	●				
S1		●		●	●	●				
S2		●		●	●	●				
S3		●		●	●	●				
S11					●	●	●	●	●	●
S12					●	●	●	●	●	●
S13					●	●	●	●	●	●

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni. □ Safe-Lock disponibile, tempo di consegna 6 giorni
● Prima scelta ○ Scelta alternativa

Selezione utensile acciaio inossidabile e materiali S

								
Nome		JH770	JH740	JH710	JH790	JH730	JHP994	JH780
Pag.		308	310	312	314	316	318	320
Famiglia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HPM	HSM/TORNADO
Tipo di fresa								
Attacco	Cilindrico	■	■	■	■	■	■	■
	Weldon							
	Safelock							
Numero di eliche		3,4,5,6	4-5	5	6	5,6,7	4	4
Adduz. refrig. interna								
	Metrico	3-10	6-10	6-8	9,5	6-10	6-10	1,83-4,89
	Pollici							
Lunghezze disponibili		2	2	2	2,3	2	3	2
Operazione								
								
								
SMG								
M1								
M2								
M3								
M4								
M5								
S1								
S2		●	●	●	●	●	●	●
S3								
S11		●	●	●	●	●	●	
S12		●	●	●	●	●	●	●
S13								

■ Prodotto standard ☐ Weldon disponibile, tempo di consegna 3 giorni. ☐ Safe-Lock disponibile, tempo di consegna 6 giorni
● Prima scelta ○ Scelta alternativa

Selezione utensile acciaio inossidabile e materiali S





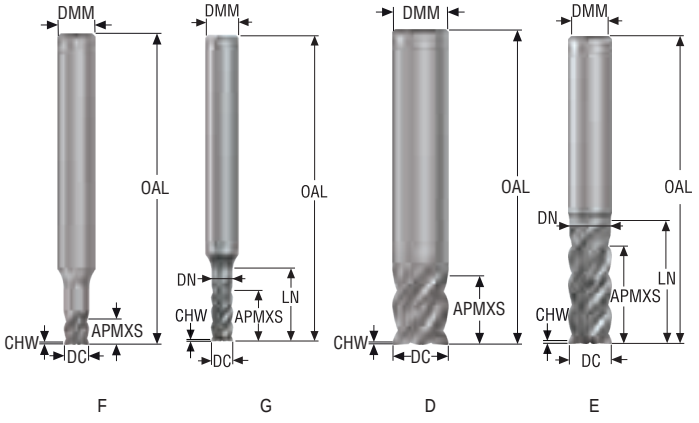


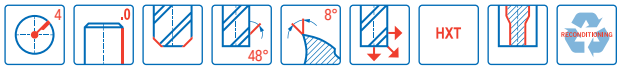

Nome		JHB720	JH721	JH722	SHF712	SME714/716	SMB713/714/416
Pag.		322	324	326	385	385	178
Famiglia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HFM	MINI	MINI
Tipo di fresa							
Attacco	Cilindrico	■	■	■	■	■	■
	Weldon						
	Safelock						
Numero di eliche		3	6	6	3-4-5	3-4-5	4
Adduz. refrig. interna							
	Metrico	2-16	6-8	10	1-10	1-10	0,5-3,0
	Pollici						
Lunghezze disponibili		2	2	2	1,2,3,4	1,2,3,4	2,4
Operazione							
SMG							
M1		●					
M2		●					
M3		●					
M4		●					
M5		●					
S1		○					
S2		○	●	●	●	●	●
S3		○					
S11		●	●	●			
S12		●	●	●	●	●	●
S13		●					

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Cilindrico – Smusso







- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile se DC è ≥Ø6

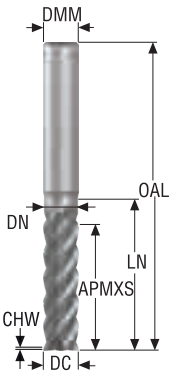
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS754030F1C.0Z4-HXT	10165556	1	F	3,0	6,0	4,0	50,0	6,0	3,05	0,035	4	■
JS754040F1C.0Z4-HXT	10164855	1	F	4,0	6,0	6,0	50,0	9,0	4,05	0,045	4	■
JS754050F1C.0Z4-HXT	10165557	1	F	5,0	6,0	7,0	50,0	10,0	5,05	0,055	4	■
JS754060D1C.0Z4-HXT	10164856	1	D	6,0	6,0	8,0	50,0	–	–	0,075	4	■
JS754080D1C.0Z4-HXT	10164857	1	D	8,0	8,0	11,0	58,0	–	–	0,1	4	■
JS754100D1C.0Z4-HXT	10164858	1	D	10,0	10,0	13,0	58,0	–	–	0,125	4	■
JS754120D1C.0Z4-HXT	10164859	1	D	12,0	12,0	15,0	67,0	–	–	0,15	4	■
JS754160D1C.0Z4-HXT	10164860	1	D	16,0	16,0	19,0	73,0	–	–	0,2	4	■
JS754030G2C.0Z4-HXT	03186807	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,035	4	■
JS754040G2C.0Z4-HXT	03186808	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,045	4	■
JS754050G2C.0Z4-HXT	03186809	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,055	4	■
JS754060E2C.0Z4-HXT	03186810	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.0Z4-HXT	03186811	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.0Z4-HXT	03186812	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.0Z4-HXT	03186813	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754160E2C.0Z4-HXT	03186814	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754200E2C.0Z4-HXT	03186815	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■
JS754250E2C.0Z4-HXT	03186816	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	4	■
JS754060E3C.0Z4-HXT	03186823	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E3C.0Z4-HXT	03186824	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E3C.0Z4-HXT	03186825	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E3C.0Z4-HXT	03186826	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E3C.0Z4-HXT	03186827	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E3C.0Z4-HXT	03186828	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■
JS754250E3C.0Z4-HXT	03186829	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	4	■

■ Prodotto standard.

JS754

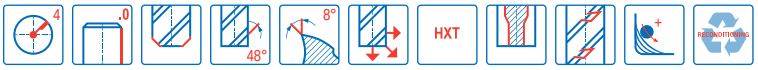
Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Cilindrico – Smusso – Rompitruciolo





E

- Tolleranze:
- DMM= h5
- DC= e7
- Rompitruciolo
- Riaffilatura possibile

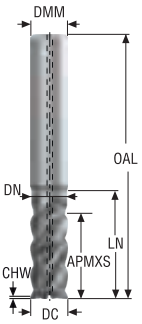


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JS754100E2C.0Z4C-HXT	03186817	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.0Z4C-HXT	03186818	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754060E3C.0Z4C-HXT	03200550	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E3C.0Z4C-HXT	03200551	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E3C.0Z4C-HXT	03186830	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E3C.0Z4C-HXT	03186831	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E3C.0Z4C-HXT	03186832	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E3C.0Z4C-HXT	03186833	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■

■ Prodotto standard.

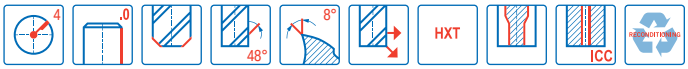
JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Cilindrico – Smusso – ICC



E





- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile

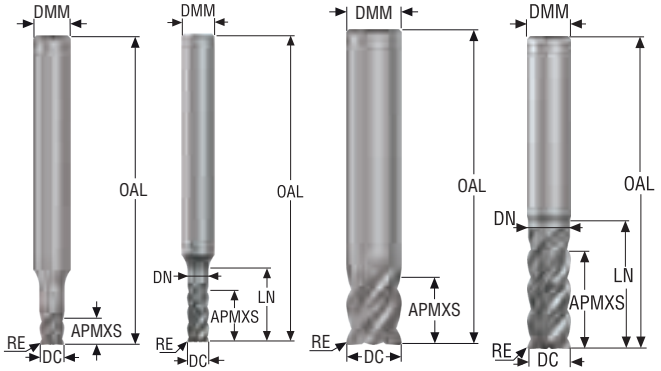
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.0Z4A-HXT	03186834	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.0Z4A-HXT	03186835	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.0Z4A-HXT	03186836	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.0Z4A-HXT	03186837	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754160E2C.0Z4A-HXT	03186838	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754200E2C.0Z4A-HXT	03186839	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■

■ Prodotto standard.

JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Cilindrico – Raggio di punta







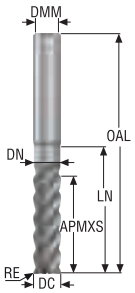
- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS754030F1R020.0Z4-HXT	10165558	1	F	3,0	6,0	4,0	50,0	6,0	3,05	0,2	4	■
JS754040F1R020.0Z4-HXT	10164867	1	F	4,0	6,0	6,0	50,0	9,0	4,05	0,2	4	■
JS754050F1R020.0Z4-HXT	10165559	1	F	5,0	6,0	7,0	50,0	10,0	5,05	0,2	4	■
JS754060D1R020.0Z4-HXT	10164868	1	D	6,0	6,0	8,0	50,0	–	–	0,2	4	■
JS754060D1R050.0Z4-HXT	10164869	1	D	6,0	6,0	8,0	50,0	–	–	0,5	4	■
JS754080D1R050.0Z4-HXT	10164871	1	D	8,0	8,0	11,0	58,0	–	–	0,5	4	■
JS754100D1R050.0Z4-HXT	10164873	1	D	10,0	10,0	13,0	58,0	–	–	0,5	4	■
JS754100D1R100.0Z4-HXT	10164874	1	D	10,0	10,0	13,0	58,0	–	–	1,0	4	■
JS754120D1R050.0Z4-HXT	10164875	1	D	12,0	12,0	15,0	67,0	–	–	0,5	4	■
JS754120D1R100.0Z4-HXT	10164876	1	D	12,0	12,0	15,0	67,0	–	–	1,0	4	■
JS754160D1R050.0Z4-HXT	10164877	1	D	16,0	16,0	19,0	73,0	–	–	0,5	4	■
JS754160D1R100.0Z4-HXT	10164878	1	D	16,0	16,0	19,0	73,0	–	–	1,0	4	■
JS754030G2R020.0Z4-HXT	03186840	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,2	4	■
JS754040G2R020.0Z4-HXT	03186841	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,2	4	■
JS754050G2R020.0Z4-HXT	03186842	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,2	4	■
JS754060E2R020.0Z4-HXT	03186843	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	■
JS754060E2R050.0Z4-HXT	03186844	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JS754060E2R100.0Z4-HXT	03186845	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JS754080E2R050.0Z4-HXT	03186846	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JS754080E2R100.0Z4-HXT	03186847	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JS754100E2R050.0Z4-HXT	03186848	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JS754100E2R100.0Z4-HXT	03186849	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JS754100E2R150.0Z4-HXT	03200552	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	4	■
JS754100E2R200.0Z4-HXT	03186850	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	4	■
JS754100E2R300.0Z4-HXT	03186851	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	4	■
JS754120E2R050.0Z4-HXT	03186852	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JS754120E2R100.0Z4-HXT	03186853	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JS754120E2R150.0Z4-HXT	03200553	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	4	■
JS754120E2R200.0Z4-HXT	03186854	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	4	■
JS754120E2R300.0Z4-HXT	03186855	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	4	■
JS754160E2R050.0Z4-HXT	03186856	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JS754160E2R100.0Z4-HXT	03186857	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JS754160E2R200.0Z4-HXT	03186858	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	4	■

■ Prodotto standard.

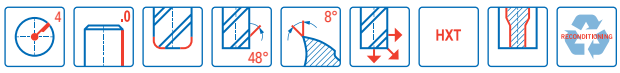
JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Cilindrico – Raggio di punta



E





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

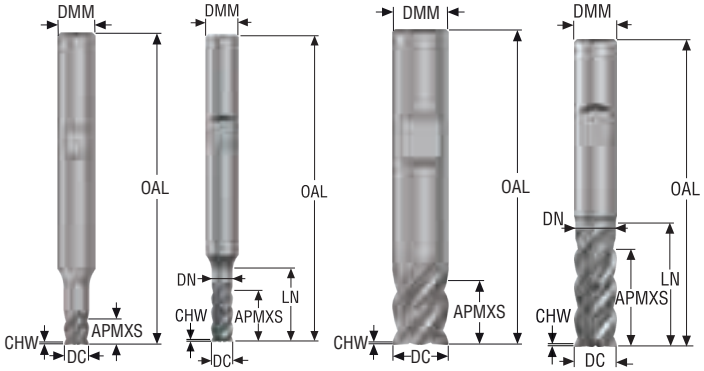
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS754160E2R300.0Z4-HXT	03186859	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	■
JS754160E2R400.0Z4-HXT	03186860	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	■
JS754160E2R600.0Z4-HXT	03186861	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	■
JS754200E2R050.0Z4-HXT	03186862	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	■
JS754200E2R100.0Z4-HXT	03186863	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	■
JS754200E2R200.0Z4-HXT	03186864	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	■
JS754200E2R300.0Z4-HXT	03186865	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	■
JS754200E2R400.0Z4-HXT	03186866	2	E	20,0	20,0	40,0	104,0	51,0	19,0	4,0	4	■
JS754200E2R600.0Z4-HXT	03186867	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	■
JS754060E3R020.0Z4-HXT	03186873	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	■
JS754060E3R050.0Z4-HXT	03186874	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	■
JS754060E3R100.0Z4-HXT	03186875	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	■
JS754080E3R050.0Z4-HXT	03186876	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	■
JS754080E3R100.0Z4-HXT	03186877	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	■
JS754100E3R050.0Z4-HXT	03186878	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	■
JS754100E3R100.0Z4-HXT	03186879	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	■
JS754100E3R200.0Z4-HXT	03186880	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	■
JS754100E3R300.0Z4-HXT	03186881	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	■
JS754120E3R050.0Z4-HXT	03186882	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	■
JS754120E3R100.0Z4-HXT	03186883	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	■
JS754120E3R200.0Z4-HXT	03186884	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	■
JS754120E3R300.0Z4-HXT	03186885	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	■
JS754160E3R050.0Z4-HXT	03186886	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	■
JS754160E3R100.0Z4-HXT	03186887	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	■
JS754160E3R200.0Z4-HXT	03186888	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	■
JS754160E3R300.0Z4-HXT	03186889	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	■
JS754160E3R400.0Z4-HXT	03186890	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	■
JS754160E3R600.0Z4-HXT	03186891	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	■
JS754200E3R050.0Z4-HXT	03186892	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	■
JS754200E3R100.0Z4-HXT	03186893	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	■
JS754200E3R200.0Z4-HXT	03186894	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	■
JS754200E3R300.0Z4-HXT	03186895	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	■
JS754200E3R400.0Z4-HXT	03186896	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	■
JS754200E3R600.0Z4-HXT	03186897	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	■

■ Prodotto standard.

JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Weldon – Smusso







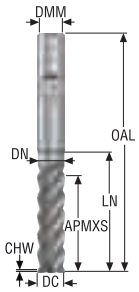
- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS754030F1C.3Z4-HXT	10165658	1	F	3,0	6,0	4,0	50,0	6,0	3,05	0,035	4	□
JS754040F1C.3Z4-HXT	10164861	1	F	4,0	6,0	6,0	50,0	9,0	4,05	0,045	4	□
JS754050F1C.3Z4-HXT	10165660	1	F	5,0	6,0	7,0	50,0	10,0	5,05	0,055	4	□
JS754060D1C.3Z4-HXT	10164862	1	D	6,0	6,0	8,0	50,0	–	–	0,075	4	□
JS754080D1C.3Z4-HXT	10164863	1	D	8,0	8,0	11,0	58,0	–	–	0,1	4	□
JS754100D1C.3Z4-HXT	10164864	1	D	10,0	10,0	13,0	58,0	–	–	0,125	4	□
JS754120D1C.3Z4-HXT	10164865	1	D	12,0	12,0	15,0	67,0	–	–	0,15	4	□
JS754160D1C.3Z4-HXT	10164866	1	D	16,0	16,0	19,0	73,0	–	–	0,2	4	□
JS754030G2C.3Z4-HXT	03186975	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,035	4	□
JS754040G2C.3Z4-HXT	03186976	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,045	4	□
JS754050G2C.3Z4-HXT	03186977	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,055	4	□
JS754060E2C.3Z4-HXT	03186978	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.3Z4-HXT	03186979	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.3Z4-HXT	03186980	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.3Z4-HXT	03186981	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754160E2C.3Z4-HXT	03186982	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754200E2C.3Z4-HXT	03186983	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■
JS754250E2C.3Z4-HXT	03186984	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	4	■
JS754060E3C.3Z4-HXT	03186990	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E3C.3Z4-HXT	03186991	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E3C.3Z4-HXT	03186992	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E3C.3Z4-HXT	03186993	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E3C.3Z4-HXT	03186994	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E3C.3Z4-HXT	03186995	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■
JS754250E3C.3Z4-HXT	03186996	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	4	■

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

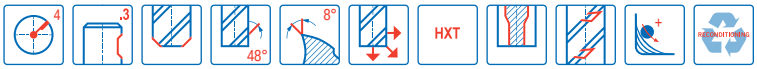
JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Weldon – Smusso – Rompitruciolo



E





- Tolleranze:
- DMM= h5
- DC= e7
- Rompitruciolo
- Riaffilatura possibile

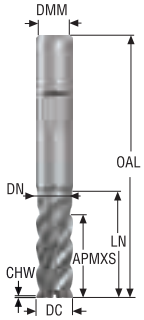
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JS754100E2C.3Z4C-HXT	03186985	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.3Z4C-HXT	03186986	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754060E3C.3Z4C-HXT	03200562	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E3C.3Z4C-HXT	03200563	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E3C.3Z4C-HXT	03186997	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E3C.3Z4C-HXT	03186998	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E3C.3Z4C-HXT	03186999	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E3C.3Z4C-HXT	03187000	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■

■ Prodotto standard.

JS754

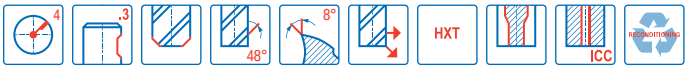
Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Weldon – Smusso – ICC





E

- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile

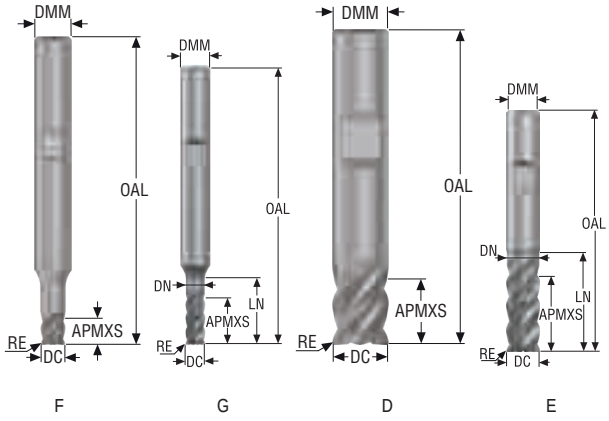


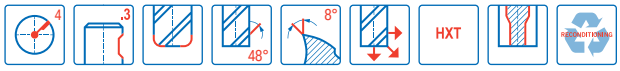
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.3Z4A-HXT	03187001	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.3Z4A-HXT	03187002	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.3Z4A-HXT	03187003	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.3Z4A-HXT	03187004	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754160E2C.3Z4A-HXT	03187005	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754200E2C.3Z4A-HXT	03187006	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■

■ Prodotto standard.

JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Weldon – Raggio di punta







- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

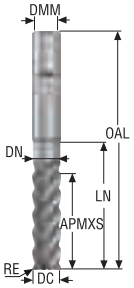
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS754030F1R020.3Z4-HXT	10165560	1	F	3,0	6,0	4,0	50,0	6,0	3,05	0,2	4	□
JS754040F1R020.3Z4-HXT	10164879	1	F	4,0	6,0	6,0	50,0	9,0	4,05	0,2	4	□
JS754050F1R020.3Z4-HXT	10165561	1	F	5,0	6,0	7,0	50,0	10,0	5,05	0,2	4	□
JS754060D1R020.3Z4-HXT	10164880	1	D	6,0	6,0	8,0	50,0	–	–	0,2	4	□
JS754060D1R050.3Z4-HXT	10164881	1	D	6,0	6,0	8,0	50,0	–	–	0,5	4	□
JS754080D1R050.3Z4-HXT	10164883	1	D	8,0	8,0	11,0	58,0	–	–	0,5	4	□
JS754100D1R050.3Z4-HXT	10164885	1	D	10,0	10,0	13,0	58,0	–	–	0,5	4	□
JS754100D1R100.3Z4-HXT	10164886	1	D	10,0	10,0	13,0	58,0	–	–	1,0	4	□
JS754120D1R050.3Z4-HXT	10164887	1	D	12,0	12,0	15,0	67,0	–	–	0,5	4	□
JS754120D1R100.3Z4-HXT	10164888	1	D	12,0	12,0	15,0	67,0	–	–	1,0	4	□
JS754160D1R050.3Z4-HXT	10164889	1	D	16,0	16,0	19,0	73,0	–	–	0,5	4	□
JS754160D1R100.3Z4-HXT	10164890	1	D	16,0	16,0	19,0	73,0	–	–	1,0	4	□
JS754030G2R020.3Z4-HXT	03187007	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,2	4	□
JS754040G2R020.3Z4-HXT	03187008	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,2	4	□
JS754050G2R020.3Z4-HXT	03187009	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,2	4	□
JS754060E2R020.3Z4-HXT	03187010	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	■
JS754060E2R050.3Z4-HXT	03187011	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JS754060E2R100.3Z4-HXT	03187012	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JS754080E2R050.3Z4-HXT	03187013	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JS754080E2R100.3Z4-HXT	03187014	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JS754100E2R050.3Z4-HXT	03187015	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JS754100E2R100.3Z4-HXT	03187016	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JS754100E2R150.3Z4-HXT	03200564	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	4	■
JS754100E2R200.3Z4-HXT	03187017	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	4	■
JS754100E2R300.3Z4-HXT	03187018	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	4	■
JS754120E2R050.3Z4-HXT	03187019	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JS754120E2R100.3Z4-HXT	03187020	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JS754120E2R150.3Z4-HXT	03200565	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	4	■
JS754120E2R200.3Z4-HXT	03187021	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	4	■
JS754120E2R300.3Z4-HXT	03187022	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	4	■
JS754160E2R050.3Z4-HXT	03187023	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JS754160E2R100.3Z4-HXT	03187024	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JS754160E2R200.3Z4-HXT	03187025	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	4	■
JS754160E2R300.3Z4-HXT	03187026	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	■
JS754160E2R400.3Z4-HXT	03187027	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	■
JS754160E2R600.3Z4-HXT	03187028	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	■

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Weldon – Raggio di punta





E

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

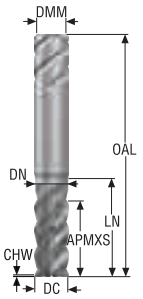


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS754200E2R050.3Z4-HXT	03187029	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	■
JS754200E2R100.3Z4-HXT	03187030	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	■
JS754200E2R200.3Z4-HXT	03187031	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	■
JS754200E2R300.3Z4-HXT	03187032	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	■
JS754200E2R400.3Z4-HXT	03187033	2	E	20,0	20,0	40,0	104,0	51,0	19,0	4,0	4	■
JS754200E2R600.3Z4-HXT	03187034	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	■
JS754060E3R020.3Z4-HXT	03187040	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	□
JS754060E3R050.3Z4-HXT	03187041	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	□
JS754060E3R100.3Z4-HXT	03187042	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	□
JS754080E3R050.3Z4-HXT	03187043	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	□
JS754080E3R100.3Z4-HXT	03187044	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	□
JS754100E3R050.3Z4-HXT	03187045	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	□
JS754100E3R100.3Z4-HXT	03187046	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	□
JS754100E3R200.3Z4-HXT	03187047	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	□
JS754100E3R300.3Z4-HXT	03187049	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	□
JS754120E3R050.3Z4-HXT	03187050	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	□
JS754120E3R100.3Z4-HXT	03187051	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	□
JS754120E3R200.3Z4-HXT	03187052	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	□
JS754120E3R300.3Z4-HXT	03187053	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	□
JS754160E3R050.3Z4-HXT	03187054	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	□
JS754160E3R100.3Z4-HXT	03187055	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	□
JS754160E3R200.3Z4-HXT	03187056	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	□
JS754160E3R300.3Z4-HXT	03187057	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	□
JS754160E3R400.3Z4-HXT	03187058	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	□
JS754160E3R600.3Z4-HXT	03187059	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	□
JS754200E3R050.3Z4-HXT	03187060	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	□
JS754200E3R100.3Z4-HXT	03187061	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	□
JS754200E3R200.3Z4-HXT	03187062	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	□
JS754200E3R300.3Z4-HXT	03187063	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	□
JS754200E3R400.3Z4-HXT	03187064	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	□
JS754200E3R600.3Z4-HXT	03187065	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	□

□ Weldon disponibile. Il tempo di consegna è di 3 giorni.

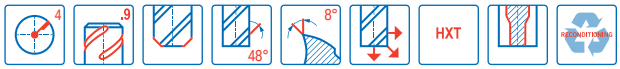
JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Safelock – Smusso



E





- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile

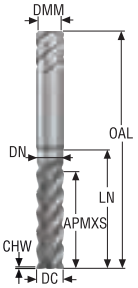
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
				mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.9Z4-HXT	03187144	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	☐
JS754080E2C.9Z4-HXT	03187145	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	☐
JS754100E2C.9Z4-HXT	03187146	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	☐
JS754120E2C.9Z4-HXT	03187147	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	☐
JS754160E2C.9Z4-HXT	03187148	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	☐
JS754200E2C.9Z4-HXT	03187149	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	☐
JS754250E2C.9Z4-HXT	03187150	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	4	☐
JS754060E3C.9Z4-HXT	03187153	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	☐
JS754080E3C.9Z4-HXT	03187154	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	☐
JS754100E3C.9Z4-HXT	03187155	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	☐
JS754120E3C.9Z4-HXT	03187156	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	☐
JS754160E3C.9Z4-HXT	03187157	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	☐
JS754200E3C.9Z4-HXT	03187158	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	☐
JS754250E3C.9Z4-HXT	03187159	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	4	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.

JS754

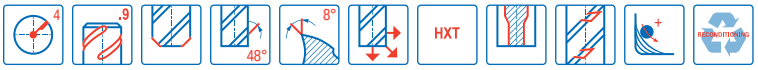
Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Safelock – Smusso – Rompitruciolo





E

- Tolleranze:
- DMM= h5
- DC= e7
- Rompitruciolo
- Riaffilatura possibile

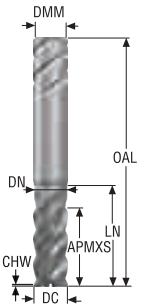


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JS754100E2C.9Z4C-HXT	03187151	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	☐
JS754120E2C.9Z4C-HXT	03187152	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	☐
JS754060E3C.9Z4C-HXT	03200571	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	☐
JS754080E3C.9Z4C-HXT	03200572	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	☐
JS754100E3C.9Z4C-HXT	03187160	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	☐
JS754120E3C.9Z4C-HXT	03187161	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	☐
JS754160E3C.9Z4C-HXT	03187162	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	☐
JS754200E3C.9Z4C-HXT	03187163	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.

JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Safelock – Smusso – ICC



E





- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile

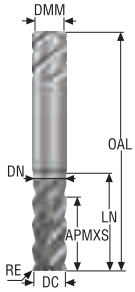
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.9Z4A-HXT	03187164	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	☐
JS754080E2C.9Z4A-HXT	03187165	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	☐
JS754100E2C.9Z4A-HXT	03187166	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	☐
JS754120E2C.9Z4A-HXT	03187167	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	☐
JS754160E2C.9Z4A-HXT	03187168	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	☐
JS754200E2C.9Z4A-HXT	03187169	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.
ICC = Canale adduzione refrigerante interna

JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Safelock – Raggio di punta





E

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

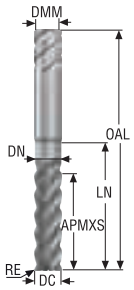


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm	mm	mm		
JS754060E2R020.9Z4-HXT	03187170	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	☐
JS754060E2R050.9Z4-HXT	03187171	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	☐
JS754060E2R100.9Z4-HXT	03187172	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	☐
JS754080E2R050.9Z4-HXT	03187173	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	☐
JS754080E2R100.9Z4-HXT	03187174	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	☐
JS754100E2R050.9Z4-HXT	03187175	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	☐
JS754100E2R100.9Z4-HXT	03187176	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	☐
JS754100E2R150.9Z4-HXT	03200573	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	4	☐
JS754100E2R200.9Z4-HXT	03187177	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	4	☐
JS754100E2R300.9Z4-HXT	03187178	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	4	☐
JS754120E2R050.9Z4-HXT	03187179	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	☐
JS754120E2R100.9Z4-HXT	03187180	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	☐
JS754120E2R150.9Z4-HXT	03200832	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	4	☐
JS754120E2R200.9Z4-HXT	03187181	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	4	☐
JS754120E2R300.9Z4-HXT	03187182	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	4	☐
JS754160E2R050.9Z4-HXT	03187183	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	☐
JS754160E2R100.9Z4-HXT	03187184	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	☐
JS754160E2R200.9Z4-HXT	03187185	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	4	☐
JS754160E2R300.9Z4-HXT	03187186	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	☐
JS754160E2R400.9Z4-HXT	03187187	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	☐
JS754160E2R600.9Z4-HXT	03187188	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	☐
JS754200E2R050.9Z4-HXT	03187189	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	☐
JS754200E2R100.9Z4-HXT	03187190	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	☐
JS754200E2R200.9Z4-HXT	03187191	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	☐
JS754200E2R300.9Z4-HXT	03187192	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	☐
JS754200E2R400.9Z4-HXT	03187193	2	E	20,0	20,0	40,0	104,0	51,0	19,0	4,0	4	☐
JS754200E2R600.9Z4-HXT	03187194	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.

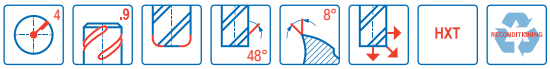
JS754

Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Safelock – Raggio di punta



E





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm	mm	mm		
JS754060E3R020.9Z4-HXT	03187197	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	☐
JS754060E3R050.9Z4-HXT	03187198	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	☐
JS754060E3R100.9Z4-HXT	03187199	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	☐
JS754080E3R050.9Z4-HXT	03187200	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	☐
JS754080E3R100.9Z4-HXT	03187201	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	☐
JS754100E3R050.9Z4-HXT	03187202	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	☐
JS754100E3R100.9Z4-HXT	03187203	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	☐
JS754100E3R200.9Z4-HXT	03187204	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	☐
JS754100E3R300.9Z4-HXT	03187205	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	☐
JS754120E3R050.9Z4-HXT	03187206	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	☐
JS754120E3R100.9Z4-HXT	03187207	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	☐
JS754120E3R200.9Z4-HXT	03187208	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	☐
JS754120E3R300.9Z4-HXT	03187209	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	☐
JS754160E3R050.9Z4-HXT	03187210	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	☐
JS754160E3R100.9Z4-HXT	03187211	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	☐
JS754160E3R200.9Z4-HXT	03187212	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	☐
JS754160E3R300.9Z4-HXT	03187213	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	☐
JS754160E3R400.9Z4-HXT	03187214	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	☐
JS754160E3R600.9Z4-HXT	03187215	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	☐
JS754200E3R050.9Z4-HXT	03187216	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	☐
JS754200E3R100.9Z4-HXT	03187217	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	☐
JS754200E3R200.9Z4-HXT	03187218	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	☐
JS754200E3R300.9Z4-HXT	03187219	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	☐
JS754200E3R400.9Z4-HXT	03187220	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	☐
JS754200E3R600.9Z4-HXT	03187221	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.

Parametri di taglio – JS754 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P11	M/A/D/E	0.400 *0,400*	0.80 *0,80*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	165 (130 — 180) *540 (430 — 590)*
P12	M/A/D/E	0.400 *0,400*	0.80 *0,80*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	105 (83 — 120) *345 (280 — 390)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96 — 130) *360 (320 — 420)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 110) *295 (260 — 360)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (44 — 76) *195 (150 — 240)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	46 (34 — 59) *150 (120 — 190)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	39 (29 — 49) *130 (96 — 160)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	50 (26 — 68) *165 (86 — 220)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	41 (21 — 55) *135 (69 — 180)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	36 (19 — 48) *120 (63 — 150)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	110 (73 — 140) *360 (240 — 450)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	85 (56 — 110) *280 (190 — 360)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	65 (44 — 87) *215 (150 — 280)*

Parametri di taglio – JS754 Scanalatura

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P11	M/A/D/E	0.80 *0,80*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	150 (120 — 170) *490 (400 — 550)*
P12	M/A/D/E	0.80 *0,80*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	90 (69 — 100) *295 (230 — 320)*
M1	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (85 — 120) *310 (280 — 390)*
M2	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	80 (69 — 97) *260 (230 — 310)*
M3	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	55 (39 — 67) *180 (130 — 210)*
M4	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	40 (29 — 50) *130 (96 — 160)*
M5	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	33 (25 — 42) *110 (83 — 130)*
S1	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	41 (21 — 54) *135 (69 — 170)*
S2	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	33 (17 — 43) *110 (56 — 140)*
S3	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	28 (15 — 37) *90 (50 — 120)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (63 — 120) *310 (210 — 390)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	70 (48 — 95) *230 (160 — 310)*
S13	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	55 (38 — 74) *180 (130 — 240)*

Se il raggio supera il 15% del valore DC, ridurre fz del 20%

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS754-2C Sgrossatura avanzata a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P11	M/A/D/E	0.100 *0,100*	2.0 *2,0*	0.15 *0,0060*	0.17 *0,0065*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	170 (150 — 190) *560 (500 — 620)*
M1	E	0.100 *0,100*	2.0 *2,0*	0.11 *0,0044*	0.13 *0,0050*	205 (180 — 230) *670 (600 — 750)*
M2	E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	170 (150 — 190) *560 (500 — 620)*
M3	E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	130 (120 — 150) *425 (400 — 490)*
M4	E	0.100 *0,100*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	100 (86 — 110) *330 (290 — 360)*
M5	E	0.100 *0,100*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	85 (72 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	60 (35 — 80) *195 (120 — 260)*
S3	E	0.0500 *0,0500*	2.0 *2,0*	0.080 *0,0032*	0.095 *0,0038*	50 (31 — 70) *165 (110 — 220)*
S11	E	0.0800 *0,0800*	2.0 *2,0*	0.070 *0,0028*	0.085 *0,0034*	165 (140 — 190) *540 (460 — 620)*
S12	E	0.0800 *0,0800*	2.0 *2,0*	0.070 *0,0028*	0.085 *0,0034*	125 (110 — 150) *410 (370 — 490)*
S13	E	0.0800 *0,0800*	2.0 *2,0*	0.060 *0,0024*	0.070 *0,0028*	100 (84 — 110) *330 (280 — 360)*

Parametri di taglio – JS754-3C Sgrossatura avanzata a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P11	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M1	E	0.100 *0,100*	4.0 *4,0*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	205 (170 — 230) *670 (560 — 750)*
M2	E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 190) *560 (460 — 620)*
M3	E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 150) *425 (370 — 490)*
M4	E	0.100 *0,100*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	100 (86 — 110) *330 (290 — 360)*
M5	E	0.100 *0,100*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	85 (72 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	55 (35 — 80) *180 (120 — 260)*
S3	E	0.0500 *0,0500*	4.0 *4,0*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	50 (30 — 70) *165 (99 — 220)*
S11	E	0.0800 *0,0800*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	165 (140 — 190) *540 (460 — 620)*
S12	E	0.0800 *0,0800*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 150) *410 (370 — 490)*
S13	E	0.0800 *0,0800*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (84 — 110) *330 (280 — 360)*

Se il raggio supera il 15% del valore DC, ridurre fz del 20%

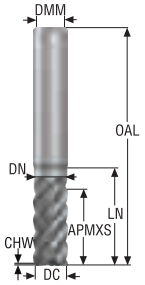
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS755

Alte prestazioni – Spallamento – ISO– M e ISO– S – 5 Eliche – Cilindrico – Smusso





E

- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile

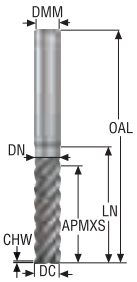


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2C.0Z5-HXT	03186907	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	■
JS755080E2C.0Z5-HXT	03186908	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	■
JS755100E2C.0Z5-HXT	03186909	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	■
JS755120E2C.0Z5-HXT	03186910	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	■
JS755160E2C.0Z5-HXT	03186911	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	■
JS755200E2C.0Z5-HXT	03186912	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	■
JS755250E2C.0Z5-HXT	03186913	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	■
JS755060E3C.0Z5-HXT	03186914	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	■
JS755080E3C.0Z5-HXT	03186915	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	■
JS755100E3C.0Z5-HXT	03186916	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.0Z5-HXT	03186917	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.0Z5-HXT	03186918	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.0Z5-HXT	03186919	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■
JS755250E3C.0Z5-HXT	03186920	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	■

■ Prodotto standard.

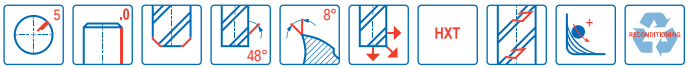
JS755

Alte prestazioni – Spallamento – ISO– M e ISO– S – 5 Eliche – Cilindrico – Smusso – Rompitruciolo



E





- Tolleranze:
- DMM= h5
- DC= e7
- Rompitruciolo
- Riaffilatura possibile

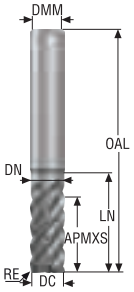
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JS755100E3C.0Z5C-HXT	03186921	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.0Z5C-HXT	03186922	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.0Z5C-HXT	03186923	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.0Z5C-HXT	03186924	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■

■ Prodotto standard.

JS755

Alte prestazioni – Spallamento – ISO– M e ISO– S – 5 Eliche – Cilindrico – Raggio di punta





E

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

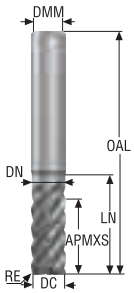


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2R020.0Z5-HXT	03186925	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	■
JS755060E2R050.0Z5-HXT	03186926	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	■
JS755060E2R100.0Z5-HXT	03186927	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	■
JS755080E2R050.0Z5-HXT	03186928	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	■
JS755080E2R100.0Z5-HXT	03186929	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	■
JS755100E2R050.0Z5-HXT	03186930	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	■
JS755100E2R100.0Z5-HXT	03186931	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	■
JS755100E2R200.0Z5-HXT	03186932	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	■
JS755100E2R300.0Z5-HXT	03186933	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	■
JS755120E2R050.0Z5-HXT	03186934	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	■
JS755120E2R100.0Z5-HXT	03186935	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	■
JS755120E2R200.0Z5-HXT	03186936	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	■
JS755120E2R300.0Z5-HXT	03186937	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	■
JS755160E2R050.0Z5-HXT	03186938	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	■
JS755160E2R100.0Z5-HXT	03186939	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	■
JS755160E2R600.0Z5-HXT	03186940	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	■
JS755200E2R050.0Z5-HXT	03186941	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	■
JS755200E2R100.0Z5-HXT	03186942	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	■
JS755200E2R600.0Z5-HXT	03186943	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	■

■ Prodotto standard.

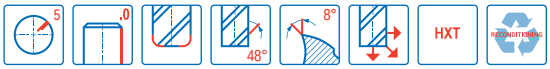
JS755

Alte prestazioni – Spallamento – ISO– M e ISO– S – 5 Eliche – Cilindrico – Raggio di punta



E





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

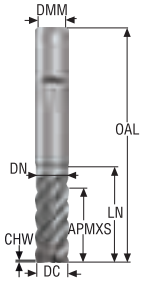
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS755060E3R020.0Z5-HXT	03186946	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	■
JS755060E3R050.0Z5-HXT	03186947	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	■
JS755060E3R100.0Z5-HXT	03186948	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	■
JS755080E3R050.0Z5-HXT	03186949	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	■
JS755080E3R100.0Z5-HXT	03186950	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	■
JS755100E3R050.0Z5-HXT	03186951	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	■
JS755100E3R100.0Z5-HXT	03186952	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	■
JS755100E3R200.0Z5-HXT	03186953	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	■
JS755100E3R300.0Z5-HXT	03186954	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	■
JS755120E3R050.0Z5-HXT	03186955	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	■
JS755120E3R100.0Z5-HXT	03186956	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	■
JS755120E3R200.0Z5-HXT	03186957	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	■
JS755120E3R300.0Z5-HXT	03186958	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	■
JS755160E3R050.0Z5-HXT	03186959	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	■
JS755160E3R600.0Z5-HXT	03186960	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	■
JS755200E3R050.0Z5-HXT	03186961	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	■
JS755200E3R600.0Z5-HXT	03186962	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	■

■ Prodotto standard.

JS755

Alte prestazioni – Spallamento – ISO– M e ISO– S – 5 Eliche – Weldon – Smusso





E

- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile

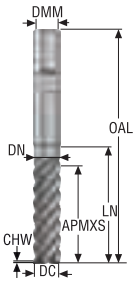


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2C.3Z5-HXT	03187083	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	■
JS755080E2C.3Z5-HXT	03187084	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	■
JS755100E2C.3Z5-HXT	03187085	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	■
JS755120E2C.3Z5-HXT	03187086	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	■
JS755160E2C.3Z5-HXT	03187087	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	■
JS755200E2C.3Z5-HXT	03187088	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	■
JS755250E2C.3Z5-HXT	03187089	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	■
JS755060E3C.3Z5-HXT	03187090	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	■
JS755080E3C.3Z5-HXT	03187091	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	■
JS755100E3C.3Z5-HXT	03187092	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.3Z5-HXT	03187093	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.3Z5-HXT	03187094	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.3Z5-HXT	03187095	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■
JS755250E3C.3Z5-HXT	03187096	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	■

■ Prodotto standard.

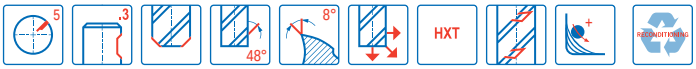
JS755

Alte prestazioni – Spallamento – ISO– M e ISO– S – 5 Eliche – Weldon – Smusso – Rompitruciolo



E





- Tolleranze:
- DMM= h5
- DC= e7
- Rompitruciolo
- Riaffilatura possibile

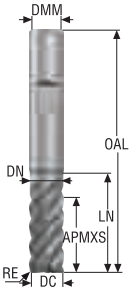
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JS755100E3C.3Z5C-HXT	03187097	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.3Z5C-HXT	03187098	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.3Z5C-HXT	03187099	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.3Z5C-HXT	03187100	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■

■ Prodotto standard.

JS755

Alte prestazioni – Spallamento – ISO– M e ISO– S – 5 Eliche – Weldon – Raggio di punta





E

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

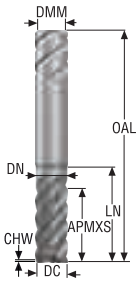


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2R020.3Z5-HXT	03187101	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	■
JS755060E2R050.3Z5-HXT	03187102	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	■
JS755060E2R100.3Z5-HXT	03187103	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	■
JS755080E2R050.3Z5-HXT	03187104	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	■
JS755080E2R100.3Z5-HXT	03187105	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	■
JS755100E2R050.3Z5-HXT	03187106	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	■
JS755100E2R100.3Z5-HXT	03187107	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	■
JS755100E2R200.3Z5-HXT	03187108	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	■
JS755100E2R300.3Z5-HXT	03187109	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	■
JS755120E2R050.3Z5-HXT	03187110	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	■
JS755120E2R100.3Z5-HXT	03187111	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	■
JS755120E2R200.3Z5-HXT	03187112	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	■
JS755120E2R300.3Z5-HXT	03187113	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	■
JS755160E2R050.3Z5-HXT	03187114	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	■
JS755160E2R100.3Z5-HXT	03187115	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	■
JS755160E2R600.3Z5-HXT	03187116	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	■
JS755200E2R050.3Z5-HXT	03187117	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	■
JS755200E2R100.3Z5-HXT	03187118	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	■
JS755200E2R600.3Z5-HXT	03187119	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	■
JS755060E3R020.3Z5-HXT	03187122	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	□
JS755060E3R050.3Z5-HXT	03187123	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	□
JS755060E3R100.3Z5-HXT	03187124	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	□
JS755080E3R050.3Z5-HXT	03187125	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	□
JS755080E3R100.3Z5-HXT	03187126	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	□
JS755100E3R050.3Z5-HXT	03187127	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	□
JS755100E3R100.3Z5-HXT	03187128	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	□
JS755100E3R200.3Z5-HXT	03187129	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	□
JS755100E3R300.3Z5-HXT	03187130	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	□
JS755120E3R050.3Z5-HXT	03187131	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	□
JS755120E3R100.3Z5-HXT	03187132	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	□
JS755120E3R200.3Z5-HXT	03187133	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	□
JS755120E3R300.3Z5-HXT	03187134	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	□
JS755160E3R050.3Z5-HXT	03187135	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	□
JS755160E3R600.3Z5-HXT	03187136	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	□
JS755200E3R050.3Z5-HXT	03187137	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	□
JS755200E3R600.3Z5-HXT	03187138	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	□

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

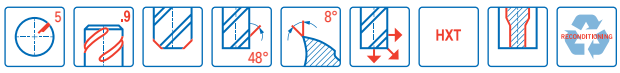
JS755

Alte prestazioni – Spallamento – ISO– M e ISO– S – 5 Eliche – Safelock – Smusso



E





- Tolleranze:
- DMM= h5
- DC= e7
- Riaffilatura possibile

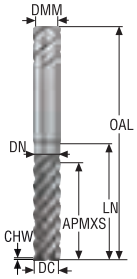
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2C.9Z5-HXT	03187235	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	☐
JS755080E2C.9Z5-HXT	03187236	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	☐
JS755100E2C.9Z5-HXT	03187237	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	☐
JS755120E2C.9Z5-HXT	03187238	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	☐
JS755160E2C.9Z5-HXT	03187239	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	☐
JS755200E2C.9Z5-HXT	03187240	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	☐
JS755250E2C.9Z5-HXT	03187241	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	☐
JS755060E3C.9Z5-HXT	03187242	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	☐
JS755080E3C.9Z5-HXT	03187243	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	☐
JS755100E3C.9Z5-HXT	03187244	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	☐
JS755120E3C.9Z5-HXT	03187245	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	☐
JS755160E3C.9Z5-HXT	03187246	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	☐
JS755200E3C.9Z5-HXT	03187247	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	☐
JS755250E3C.9Z5-HXT	03187248	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.

JS755

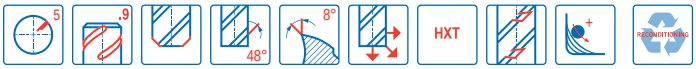
Alte prestazioni – Spallamento – ISO– M e ISO– S – 5 Eliche – Safelock – Smusso – Rompitruciolo





E

- Tolleranze:
- DMM= h5
- DC= e7
- Rompitruciolo
- Riaffilatura possibile

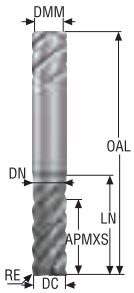


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JS755100E3C.9Z5C-HXT	03187249	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	☐
JS755120E3C.9Z5C-HXT	03187250	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	☐
JS755160E3C.9Z5C-HXT	03187252	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	☐
JS755200E3C.9Z5C-HXT	03187253	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.

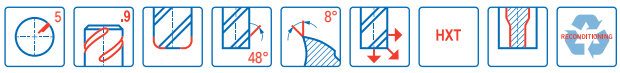
JS755

Alte prestazioni – Spallamento – ISO– M e ISO– S – 5 Eliche – Safelock – Raggio di punta



E





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2R020.9Z5-HXT	03187254	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	☐
JS755060E2R050.9Z5-HXT	03187255	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	☐
JS755060E2R100.9Z5-HXT	03187256	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	☐
JS755080E2R050.9Z5-HXT	03187257	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	☐
JS755080E2R100.9Z5-HXT	03187258	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	☐
JS755100E2R050.9Z5-HXT	03187259	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	☐
JS755100E2R100.9Z5-HXT	03187260	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	☐
JS755100E2R200.9Z5-HXT	03187261	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	☐
JS755100E2R300.9Z5-HXT	03187262	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	☐
JS755120E2R050.9Z5-HXT	03187263	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	☐
JS755120E2R100.9Z5-HXT	03187264	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	☐
JS755120E2R200.9Z5-HXT	03187265	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	☐
JS755120E2R300.9Z5-HXT	03187266	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	☐
JS755160E2R050.9Z5-HXT	03187267	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	☐
JS755160E2R100.9Z5-HXT	03187269	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	☐
JS755160E2R600.9Z5-HXT	03187270	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	☐
JS755200E2R050.9Z5-HXT	03187271	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	☐
JS755200E2R100.9Z5-HXT	03187272	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	☐
JS755200E2R600.9Z5-HXT	03187273	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	☐
JS755060E3R020.9Z5-HXT	03187276	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	☐
JS755060E3R050.9Z5-HXT	03187277	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	☐
JS755060E3R100.9Z5-HXT	03187279	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	☐
JS755080E3R050.9Z5-HXT	03187280	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	☐
JS755080E3R100.9Z5-HXT	03187281	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	☐
JS755100E3R050.9Z5-HXT	03187282	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	☐
JS755100E3R100.9Z5-HXT	03187283	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	☐
JS755100E3R200.9Z5-HXT	03187284	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	☐
JS755100E3R300.9Z5-HXT	03187285	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	☐
JS755120E3R050.9Z5-HXT	03187286	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	☐
JS755120E3R100.9Z5-HXT	03187287	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	☐
JS755120E3R200.9Z5-HXT	03187288	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	☐
JS755120E3R300.9Z5-HXT	03187289	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	☐
JS755160E3R050.9Z5-HXT	03187290	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	☐
JS755160E3R600.9Z5-HXT	03187291	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	☐
JS755200E3R050.9Z5-HXT	03187292	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	☐
JS755200E3R600.9Z5-HXT	03187293	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.

Parametri di taglio – JS755 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P11	M/A/D/E	0.400 *0,400*	1.1 *1,1*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	135 (97 — 150) *445 (320 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	85 (63 — 99) *280 (210 — 320)*
M1	E	0.400 *0,400*	1.1 *1,1*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
M2	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	140 (120 — 150) *460 (400 — 490)*
M3	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (92 — 120) *360 (310 — 390)*
M4	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	85 (71 — 95) *280 (240 — 310)*
M5	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	70 (59 — 79) *230 (200 — 250)*
S1	E	0.0300 *0,0300*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	70 (48 — 110) *230 (160 — 360)*
S2	E	0.0300 *0,0300*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	60 (39 — 89) *195 (130 — 290)*
S3	E	0.0300 *0,0300*	2.0 *2,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	50 (34 — 78) *165 (120 — 250)*
S11	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	140 (120 — 160) *460 (400 — 520)*
S12	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (91 — 120) *360 (300 — 390)*
S13	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	85 (73 — 100) *280 (240 — 320)*

Parametri di taglio – JS755_3C Sgrossatura avanzata a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P11	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M1	E	0.100 *0,100*	4.0 *4,0*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	205 (170 — 220) *670 (560 — 720)*
M2	E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M3	E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	100 (85 — 110) *330 (280 — 360)*
M5	E	0.100 *0,100*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	85 (71 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	55 (35 — 80) *180 (120 — 260)*
S3	E	0.0500 *0,0500*	4.0 *4,0*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	50 (31 — 70) *165 (110 — 220)*
S11	E	0.0800 *0,0800*	4.0 *4,0*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 190) *520 (460 — 620)*
S12	E	0.0800 *0,0800*	4.0 *4,0*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	4.0 *4,0*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (83 — 110) *330 (280 — 360)*

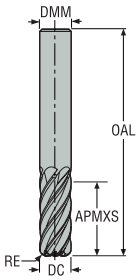
Se il raggio supera il 15% del valore DC, ridurre fz del 20%

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

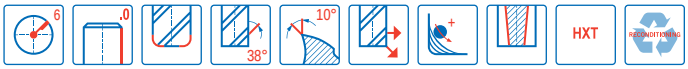
JS720

Alte prestazioni – Titanio – Spallamento – 6 Eliche – Cilindrico – Raggio di punta



D





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

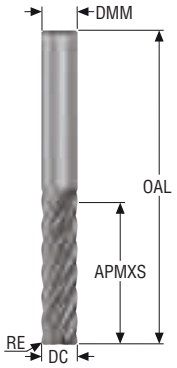
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JS720060D2R050.0Z6-HXT	03060293	2	D	6,0	6,0	17,0	57,0	0,5	6	■
JS720060D2R100.0Z6-HXT	03060294	2	D	6,0	6,0	17,0	57,0	1,0	6	■
JS720080D2R050.0Z6-HXT	03060295	2	D	8,0	8,0	23,0	63,0	0,5	6	■
JS720080D2R100.0Z6-HXT	03061294	2	D	8,0	8,0	23,0	63,0	1,0	6	■
JS720100D2R050.0Z6-HXT	03060296	2	D	10,0	10,0	26,0	72,0	0,5	6	■
JS720100D2R100.0Z6-HXT	03060298	2	D	10,0	10,0	26,0	72,0	1,0	6	■
JS720100D2R200.0Z6-HXT	03060299	2	D	10,0	10,0	26,0	72,0	2,0	6	■
JS720100D2R300.0Z6-HXT	03060300	2	D	10,0	10,0	26,0	72,0	3,0	6	■
JS720120D2R050.0Z6-HXT	03060301	2	D	12,0	12,0	30,0	83,0	0,5	6	■
JS720120D2R100.0Z6-HXT	03060304	2	D	12,0	12,0	30,0	83,0	1,0	6	■
JS720120D2R200.0Z6-HXT	03060305	2	D	12,0	12,0	30,0	83,0	2,0	6	■
JS720120D2R300.0Z6-HXT	03060306	2	D	12,0	12,0	30,0	83,0	3,0	6	■
JS720160D2R050.0Z6-HXT	03060307	2	D	16,0	16,0	44,0	99,0	0,5	6	■
JS720160D2R100.0Z6-HXT	03060309	2	D	16,0	16,0	44,0	99,0	1,0	6	■
JS720160D2R200.0Z6-HXT	03060310	2	D	16,0	16,0	44,0	99,0	2,0	6	■
JS720160D2R300.0Z6-HXT	03060311	2	D	16,0	16,0	44,0	99,0	3,0	6	■
JS720160D2R400.0Z6-HXT	03060312	2	D	16,0	16,0	44,0	99,0	4,0	6	■
JS720160D2R600.0Z6-HXT	03060313	2	D	16,0	16,0	44,0	99,0	6,0	6	■
JS720200D2R050.0Z6-HXT	10228426	2	D	20,0	20,0	45,0	105,0	0,5	6	■
JS720200D2R100.0Z6-HXT	10228427	2	D	20,0	20,0	45,0	105,0	1,0	6	■
JS720200D2R200.0Z6-HXT	10228428	2	D	20,0	20,0	45,0	105,0	2,0	6	■
JS720200D2R300.0Z6-HXT	10228429	2	D	20,0	20,0	45,0	105,0	3,0	6	■
JS720250D2R050.0Z6-HXT	10228430	2	D	25,0	25,0	50,0	125,0	0,5	6	■
JS720250D2R100.0Z6-HXT	10228431	2	D	25,0	25,0	50,0	125,0	1,0	6	■
JS720250D2R200.0Z6-HXT	10228432	2	D	25,0	25,0	50,0	125,0	2,0	6	■
JS720250D2R300.0Z6-HXT	03169498	2	D	25,0	25,0	50,0	125,0	3,0	6	■

■ Prodotto standard.

JS720

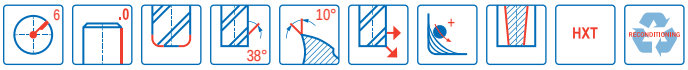
Alte prestazioni – Titanio – Spallamento – 6 Eliche – Cilindrico – Raggio di punta





D

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

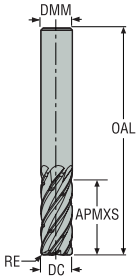


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JS720080D3R050.0Z6-HXT	10228433	3	D	8,0	8,0	32,0	80,0	0,5	6	■
JS720080D3R100.0Z6-HXT	10228434	3	D	8,0	8,0	32,0	80,0	1,0	6	■
JS720100D3R050.0Z6-HXT	10228435	3	D	10,0	10,0	40,0	89,0	0,5	6	■
JS720100D3R100.0Z6-HXT	10228436	3	D	10,0	10,0	40,0	89,0	1,0	6	■
JS720100D3R200.0Z6-HXT	10228437	3	D	10,0	10,0	40,0	89,0	2,0	6	■
JS720120D3R050.0Z6-HXT	10228438	3	D	12,0	12,0	45,0	100,0	0,5	6	■
JS720120D3R100.0Z6-HXT	10228439	3	D	12,0	12,0	45,0	100,0	1,0	6	■
JS720120D3R200.0Z6-HXT	10228440	3	D	12,0	12,0	45,0	100,0	2,0	6	■
JS720160D3R050.0Z6-HXT	10228441	3	D	16,0	16,0	65,0	130,0	0,5	6	■
JS720160D3R100.0Z6-HXT	10228442	3	D	16,0	16,0	65,0	130,0	1,0	6	■
JS720160D3R200.0Z6-HXT	10228443	3	D	16,0	16,0	65,0	130,0	2,0	6	■
JS720160D3R300.0Z6-HXT	03169497	3	D	16,0	16,0	65,0	130,0	3,0	6	■
JS720200D3R050.0Z6-HXT	03060314	3	D	20,0	20,0	62,0	121,0	0,5	6	■
JS720200D3R100.0Z6-HXT	03060316	3	D	20,0	20,0	62,0	121,0	1,0	6	■
JS720200D3R200.0Z6-HXT	03060317	3	D	20,0	20,0	62,0	121,0	2,0	6	■
JS720200D3R300.0Z6-HXT	03060318	3	D	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R400.0Z6-HXT	03060319	3	D	20,0	20,0	62,0	121,0	4,0	6	■
JS720200D3R500.0Z6-HXT	03060320	3	D	20,0	20,0	62,0	121,0	5,0	6	■
JS720200D3R600.0Z6-HXT	03060321	3	D	20,0	20,0	62,0	121,0	6,0	6	■
JS720250D3R050.0Z6-HXT	03060322	3	D	25,0	25,0	78,0	146,0	0,5	6	■
JS720250D3R100.0Z6-HXT	03060323	3	D	25,0	25,0	78,0	146,0	1,0	6	■
JS720250D3R200.0Z6-HXT	03060324	3	D	25,0	25,0	78,0	146,0	2,0	6	■
JS720250D3R300.0Z6-HXT	03060325	3	D	25,0	25,0	78,0	146,0	3,0	6	■
JS720250D3R400.0Z6-HXT	03060326	3	D	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.0Z6-HXT	03060327	3	D	25,0	25,0	78,0	146,0	6,0	6	■

■ Prodotto standard.

JS720

Alte prestazioni – Titanio – Spallamento – 6 Eliche – Cilindrico – Raggio di punta – Rompitruciolo



D





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Rompitruciolo
- Riaffilatura possibile

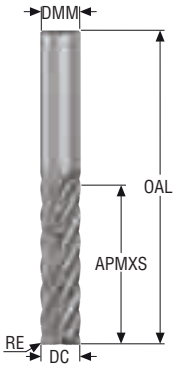
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm		
JS720080D2R050.0Z6C-HXT	10228513	2	D	■	8,0	8,0	23,0	63,0	0,5	6	■
JS720080D2R100.0Z6C-HXT	10228514	2	D	■	8,0	8,0	23,0	63,0	1,0	6	■
JS720100D2R050.0Z6C-HXT	03060297	2	D	■	10,0	10,0	26,0	72,0	0,5	6	■
JS720100D2R100.0Z6C-HXT	10228515	2	D	■	10,0	10,0	26,0	72,0	1,0	6	■
JS720120D2R050.0Z6C-HXT	03060302	2	D	■	12,0	12,0	30,0	83,0	0,5	6	■
JS720120D2R100.0Z6C-HXT	03298280	2	D	■	12,0	12,0	30,0	83,0	1,0	6	■
JS720120D2R200.0Z6C-HXT	03298281	2	D	■	12,0	12,0	30,0	83,0	2,0	6	■
JS720120D2R250.0Z6C-HXT	03298282	2	D	■	12,0	12,0	30,0	83,0	2,5	6	■
JS720120D2R300.0Z6C-HXT	03298283	2	D	■	12,0	12,0	30,0	83,0	3,0	6	■
JS720120D2R310.0Z6C-HXT	03298284	2	D	■	12,0	12,0	30,0	83,0	3,1	6	■
JS720160D2R050.0Z6C-HXT	03060308	2	D	■	16,0	16,0	44,0	99,0	0,5	6	■
JS720160D2R100.0Z6C-HXT	03298285	2	D	■	16,0	16,0	44,0	99,0	1,0	6	■
JS720160D2R200.0Z6C-HXT	03298286	2	D	■	16,0	16,0	44,0	99,0	2,0	6	■
JS720160D2R250.0Z6C-HXT	03298287	2	D	■	16,0	16,0	44,0	99,0	2,5	6	■
JS720160D2R300.0Z6C-HXT	03298288	2	D	■	16,0	16,0	44,0	99,0	3,0	6	■
JS720160D2R310.0Z6C-HXT	03298289	2	D	■	16,0	16,0	44,0	99,0	3,1	6	■
JS720160D2R400.0Z6C-HXT	03298290	2	D	■	16,0	16,0	44,0	99,0	4,0	6	■
JS720160D2R600.0Z6C-HXT	03298291	2	D	■	16,0	16,0	44,0	99,0	6,0	6	■

■ Prodotto standard.

JS720

Alte prestazioni – Titanio – Spallamento – 6 Eliche – Cilindrico – Raggio di punta – Rompitruciolo





D

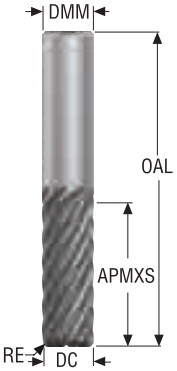
- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Rompitruciolo
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm		
JS720160D3R050.0Z6C-HXT	10228516	3	D	■	16,0	16,0	65,0	130,0	0,5	6	■
JS720160D3R100.0Z6C-HXT	10228517	3	D	■	16,0	16,0	65,0	130,0	1,0	6	■
JS720160D3R200.0Z6C-HXT	10228518	3	D	■	16,0	16,0	65,0	130,0	2,0	6	■
JS720160D3R300.0Z6C-HXT	10228519	3	D	■	16,0	16,0	65,0	130,0	3,0	6	■
JS720200D3R050.0Z6C-HXT	03060315	3	D	■	20,0	20,0	62,0	121,0	0,5	6	■
JS720200D3R100.0Z6C-HXT	03298292	3	D	■	20,0	20,0	62,0	121,0	1,0	6	■
JS720200D3R200.0Z6C-HXT	03298293	3	D	■	20,0	20,0	62,0	121,0	2,0	6	■
JS720200D3R250.0Z6C-HXT	03298294	3	D	■	20,0	20,0	62,0	121,0	2,5	6	■
JS720200D3R300.0Z6C-HXT	03298295	3	D	■	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R310.0Z6C-HXT	03298296	3	D	■	20,0	20,0	62,0	121,0	3,1	6	■
JS720200D3R400.0Z6C-HXT	03298297	3	D	■	20,0	20,0	62,0	121,0	4,0	6	■
JS720200D3R500.0Z6C-HXT	03298298	3	D	■	20,0	20,0	62,0	121,0	5,0	6	■
JS720200D3R600.0Z6C-HXT	03298299	3	D	■	20,0	20,0	62,0	121,0	6,0	6	■
JS720250D3R050.0Z6C-HXT	03066270	3	D	■	25,0	25,0	78,0	146,0	0,5	6	■
JS720250D3R100.0Z6C-HXT	03298300	3	D	■	25,0	25,0	78,0	146,0	1,0	6	■
JS720250D3R200.0Z6C-HXT	03298301	3	D	■	25,0	25,0	78,0	146,0	2,0	6	■
JS720250D3R300.0Z6C-HXT	03298302	3	D	■	25,0	25,0	78,0	146,0	3,0	6	■
JS720250D3R400.0Z6C-HXT	03298303	3	D	■	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.0Z6C-HXT	03298304	3	D	■	25,0	25,0	78,0	146,0	6,0	6	■

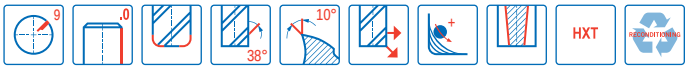
■ Prodotto standard.

JS720

Alte prestazioni – Titanio – Spallamento – 9 Eliche – Cilindrico – Raggio di punta



D





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JS720100D2R050.0Z9-HXT	10067510	2	D	10,0	10,0	26,0	72,0	0,5	9	■
JS720100D2R100.0Z9-HXT	10067511	2	D	10,0	10,0	26,0	72,0	1,0	9	■
JS720100D2R200.0Z9-HXT	10067512	2	D	10,0	10,0	26,0	72,0	2,0	9	■
JS720120D2R050.0Z9-HXT	10067513	2	D	12,0	12,0	30,0	83,0	0,5	9	■
JS720120D2R100.0Z9-HXT	10067514	2	D	12,0	12,0	30,0	83,0	1,0	9	■
JS720120D2R200.0Z9-HXT	10067515	2	D	12,0	12,0	30,0	83,0	2,0	9	■
JS720160D2R100.0Z9-HXT	10008152	2	D	16,0	16,0	44,0	99,0	1,0	9	■
JS720160D2R200.0Z9-HXT	10008153	2	D	16,0	16,0	44,0	99,0	2,0	9	■
JS720160D2R300.0Z9-HXT	10008154	2	D	16,0	16,0	44,0	99,0	3,0	9	■
JS720200D2R100.0Z9-HXT	10228393	2	D	20,0	20,0	45,0	105,0	1,0	9	■
JS720200D2R200.0Z9-HXT	10228394	2	D	20,0	20,0	45,0	105,0	2,0	9	■
JS720200D2R300.0Z9-HXT	10228395	2	D	20,0	20,0	45,0	105,0	3,0	9	■
JS720250D2R100.0Z9-HXT	10008155	2	D	25,0	25,0	50,0	125,0	1,0	9	■
JS720250D2R200.0Z9-HXT	10008156	2	D	25,0	25,0	50,0	125,0	2,0	9	■
JS720250D2R300.0Z9-HXT	10008157	2	D	25,0	25,0	50,0	125,0	3,0	9	■
JS720100D3R050.0Z9-HXT	10067516	3	D	10,0	10,0	40,0	89,0	0,5	9	■
JS720100D3R100.0Z9-HXT	10067517	3	D	10,0	10,0	40,0	89,0	1,0	9	■
JS720100D3R200.0Z9-HXT	10067518	3	D	10,0	10,0	40,0	89,0	2,0	9	■
JS720120D3R050.0Z9-HXT	10067519	3	D	12,0	12,0	45,0	100,0	0,5	9	■
JS720120D3R100.0Z9-HXT	10067520	3	D	12,0	12,0	45,0	100,0	1,0	9	■
JS720120D3R200.0Z9-HXT	10067521	3	D	12,0	12,0	45,0	100,0	2,0	9	■
JS720160D3R100.0Z9-HXT	10008158	3	D	16,0	16,0	65,0	130,0	1,0	9	■
JS720160D3R200.0Z9-HXT	10008159	3	D	16,0	16,0	65,0	130,0	2,0	9	■
JS720160D3R300.0Z9-HXT	10008160	3	D	16,0	16,0	65,0	130,0	3,0	9	■
JS720200D3R100.0Z9-HXT	10008161	3	D	20,0	20,0	62,0	121,0	1,0	9	■
JS720200D3R200.0Z9-HXT	10008162	3	D	20,0	20,0	62,0	121,0	2,0	9	■
JS720200D3R300.0Z9-HXT	10008163	3	D	20,0	20,0	62,0	121,0	3,0	9	■
JS720250D3R100.0Z9-HXT	10008164	3	D	25,0	25,0	78,0	146,0	1,0	9	■
JS720250D3R200.0Z9-HXT	10008165	3	D	25,0	25,0	78,0	146,0	2,0	9	■
JS720250D3R300.0Z9-HXT	10008166	3	D	25,0	25,0	78,0	146,0	3,0	9	■

■ Prodotto standard.

JS720

Alte prestazioni – Titanio – Spallamento – 9 Eliche – Cilindrico – Raggio di punta – Rompitruciolo





D

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

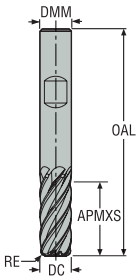


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm		
JS720100D3R050.0Z9C-HXT	10067522	3	D	■	10,0	10,0	40,0	89,0	0,5	9	■
JS720100D3R100.0Z9C-HXT	10067523	3	D	■	10,0	10,0	40,0	89,0	1,0	9	■
JS720100D3R200.0Z9C-HXT	10067524	3	D	■	10,0	10,0	40,0	89,0	2,0	9	■
JS720120D3R050.0Z9C-HXT	10067525	3	D	■	12,0	12,0	45,0	100,0	0,5	9	■
JS720120D3R100.0Z9C-HXT	10067526	3	D	■	12,0	12,0	45,0	100,0	1,0	9	■
JS720120D3R200.0Z9C-HXT	10067527	3	D	■	12,0	12,0	45,0	100,0	2,0	9	■
JS720160D3R100.0Z9C-HXT	10067528	3	D	■	16,0	16,0	65,0	130,0	1,0	9	■
JS720160D3R200.0Z9C-HXT	10067529	3	D	■	16,0	16,0	65,0	130,0	2,0	9	■
JS720160D3R300.0Z9C-HXT	10067530	3	D	■	16,0	16,0	65,0	130,0	3,0	9	■
JS720200D3R100.0Z9C-HXT	10067531	3	D	■	20,0	20,0	62,0	121,0	1,0	9	■
JS720200D3R200.0Z9C-HXT	10067532	3	D	■	20,0	20,0	62,0	121,0	2,0	9	■
JS720200D3R300.0Z9C-HXT	10067533	3	D	■	20,0	20,0	62,0	121,0	3,0	9	■
JS720250D3R100.0Z9C-HXT	10067534	3	D	■	25,0	25,0	78,0	146,0	1,0	9	■
JS720250D3R200.0Z9C-HXT	10067535	3	D	■	25,0	25,0	78,0	146,0	2,0	9	■
JS720250D3R300.0Z9C-HXT	10067536	3	D	■	25,0	25,0	78,0	146,0	3,0	9	■

■ Prodotto standard.

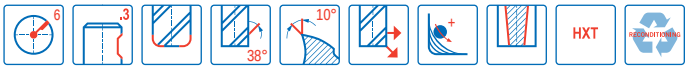
JS720

Alte prestazioni – Titanio – Spallamento – 6 Eliche – Weldon – Raggio di punta



D





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

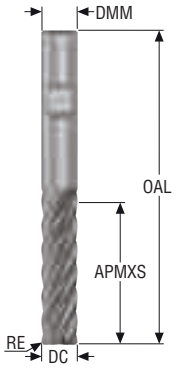
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS720060D2R050.3Z6-HXT	03060339	2	D	6,0	6,0	17,0	57,0	0,5	6	☐
JS720060D2R100.3Z6-HXT	03060340	2	D	6,0	6,0	17,0	57,0	1,0	6	☐
JS720080D2R050.3Z6-HXT	03060341	2	D	8,0	8,0	23,0	63,0	0,5	6	☐
JS720080D2R100.3Z6-HXT	03061295	2	D	8,0	8,0	23,0	63,0	1,0	6	☐
JS720100D2R050.3Z6-HXT	03060342	2	D	10,0	10,0	26,0	72,0	0,5	6	☐
JS720100D2R100.3Z6-HXT	03060344	2	D	10,0	10,0	26,0	72,0	1,0	6	☐
JS720100D2R200.3Z6-HXT	03060345	2	D	10,0	10,0	26,0	72,0	2,0	6	☐
JS720100D2R300.3Z6-HXT	03060346	2	D	10,0	10,0	26,0	72,0	3,0	6	☐
JS720120D2R050.3Z6-HXT	03060347	2	D	12,0	12,0	30,0	83,0	0,5	6	☐
JS720120D2R100.3Z6-HXT	03060349	2	D	12,0	12,0	30,0	83,0	1,0	6	☐
JS720120D2R200.3Z6-HXT	03060350	2	D	12,0	12,0	30,0	83,0	2,0	6	☐
JS720120D2R300.3Z6-HXT	03060351	2	D	12,0	12,0	30,0	83,0	3,0	6	☐
JS720160D2R050.3Z6-HXT	03060352	2	D	16,0	16,0	44,0	99,0	0,5	6	☐
JS720160D2R100.3Z6-HXT	03060354	2	D	16,0	16,0	44,0	99,0	1,0	6	☐
JS720160D2R200.3Z6-HXT	03060355	2	D	16,0	16,0	44,0	99,0	2,0	6	☐
JS720160D2R300.3Z6-HXT	03060356	2	D	16,0	16,0	44,0	99,0	3,0	6	☐
JS720160D2R400.3Z6-HXT	03060357	2	D	16,0	16,0	44,0	99,0	4,0	6	☐
JS720160D2R600.3Z6-HXT	03060358	2	D	16,0	16,0	44,0	99,0	6,0	6	☐
JS720200D2R050.3Z6-HXT	10228444	2	D	20,0	20,0	45,0	105,0	0,5	6	☐
JS720200D2R100.3Z6-HXT	10228445	2	D	20,0	20,0	45,0	105,0	1,0	6	☐
JS720200D2R200.3Z6-HXT	10228446	2	D	20,0	20,0	45,0	105,0	2,0	6	☐
JS720200D2R300.3Z6-HXT	10228447	2	D	20,0	20,0	45,0	105,0	3,0	6	☐
JS720250D2R050.3Z6-HXT	10228448	2	D	25,0	25,0	50,0	125,0	0,5	6	☐
JS720250D2R100.3Z6-HXT	10228449	2	D	25,0	25,0	50,0	125,0	1,0	6	☐
JS720250D2R200.3Z6-HXT	10228450	2	D	25,0	25,0	50,0	125,0	2,0	6	☐
JS720250D2R300.3Z6-HXT	10228451	2	D	25,0	25,0	50,0	125,0	3,0	6	☐

☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS720

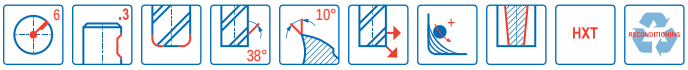
Alte prestazioni – Titanio – Spallamento – 6 Eliche – Weldon – Raggio di punta





D

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

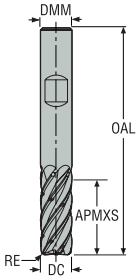


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS720080D3R050.3Z6-HXT	10228452	3	D	8,0	8,0	32,0	80,0	0,5	6	□
JS720080D3R100.3Z6-HXT	10228453	3	D	8,0	8,0	32,0	80,0	1,0	6	□
JS720100D3R050.3Z6-HXT	10228454	3	D	10,0	10,0	40,0	89,0	0,5	6	□
JS720100D3R100.3Z6-HXT	10228455	3	D	10,0	10,0	40,0	89,0	1,0	6	□
JS720100D3R200.3Z6-HXT	10228456	3	D	10,0	10,0	40,0	89,0	2,0	6	□
JS720120D3R050.3Z6-HXT	10228457	3	D	12,0	12,0	45,0	100,0	0,5	6	□
JS720120D3R100.3Z6-HXT	10228458	3	D	12,0	12,0	45,0	100,0	1,0	6	□
JS720120D3R200.3Z6-HXT	10228459	3	D	12,0	12,0	45,0	100,0	2,0	6	□
JS720160D3R050.3Z6-HXT	10228460	3	D	16,0	16,0	65,0	130,0	0,5	6	□
JS720160D3R100.3Z6-HXT	10228461	3	D	16,0	16,0	65,0	130,0	1,0	6	□
JS720160D3R200.3Z6-HXT	10228462	3	D	16,0	16,0	65,0	130,0	2,0	6	□
JS720160D3R300.3Z6-HXT	10228463	3	D	16,0	16,0	6,0	130,0	3,0	6	□
JS720200D3R050.3Z6-HXT	03060359	3	D	20,0	20,0	62,0	121,0	0,5	6	□
JS720200D3R100.3Z6-HXT	03060361	3	D	20,0	20,0	62,0	121,0	1,0	6	□
JS720200D3R200.3Z6-HXT	03060362	3	D	20,0	20,0	62,0	121,0	2,0	6	□
JS720200D3R300.3Z6-HXT	03060363	3	D	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R400.3Z6-HXT	03060364	3	D	20,0	20,0	62,0	121,0	4,0	6	□
JS720200D3R500.3Z6-HXT	03060365	3	D	20,0	20,0	62,0	121,0	5,0	6	□
JS720200D3R600.3Z6-HXT	03060366	3	D	20,0	20,0	62,0	121,0	6,0	6	□
JS720250D3R050.3Z6-HXT	03060367	3	D	25,0	25,0	78,0	146,0	0,5	6	□
JS720250D3R100.3Z6-HXT	03060368	3	D	25,0	25,0	78,0	146,0	1,0	6	□
JS720250D3R200.3Z6-HXT	03060369	3	D	25,0	25,0	78,0	146,0	2,0	6	□
JS720250D3R300.3Z6-HXT	03060370	3	D	25,0	25,0	78,0	146,0	3,0	6	□
JS720250D3R400.3Z6-HXT	03060371	3	D	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.3Z6-HXT	03060372	3	D	25,0	25,0	78,0	146,0	6,0	6	□

□ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS720

Alte prestazioni – Titanio – Spallamento – 6 Eliche – Weldon – Raggio di punta – Rompitruciolo



D





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Rompitruciolo
- Riaffilatura possibile

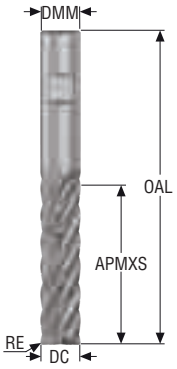
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS720080D2R050.3Z6C-HXT	10228520	2	D	■	8,0	8,0	23,0	63,0	0,5	6	□
JS720080D2R100.3Z6C-HXT	10228521	2	D	■	8,0	8,0	23,0	63,0	1,0	6	□
JS720100D2R050.3Z6C-HXT	03060343	2	D	■	10,0	10,0	26,0	72,0	0,5	6	□
JS720100D2R100.3Z6C-HXT	10228522	2	D	■	10,0	10,0	26,0	72,0	1,0	6	□
JS720120D2R050.3Z6C-HXT	03060348	2	D	■	12,0	12,0	30,0	83,0	0,5	6	□
JS720120D2R100.3Z6C-HXT	03298308	2	D	■	12,0	12,0	30,0	83,0	1,0	6	□
JS720120D2R200.3Z6C-HXT	03298309	2	D	■	12,0	12,0	30,0	83,0	2,0	6	□
JS720120D2R250.3Z6C-HXT	03298310	2	D	■	12,0	12,0	30,0	83,0	2,5	6	□
JS720120D2R300.3Z6C-HXT	03298311	2	D	■	12,0	12,0	30,0	83,0	3,0	6	□
JS720120D2R310.3Z6C-HXT	03298312	2	D	■	12,0	12,0	30,0	83,0	3,1	6	□
JS720160D2R050.3Z6C-HXT	03060353	2	D	■	16,0	16,0	44,0	99,0	0,5	6	■
JS720160D2R100.3Z6C-HXT	03298313	2	D	■	16,0	16,0	44,0	99,0	1,0	6	■
JS720160D2R200.3Z6C-HXT	03298314	2	D	■	16,0	16,0	44,0	99,0	2,0	6	■
JS720160D2R250.3Z6C-HXT	03298315	2	D	■	16,0	16,0	44,0	99,0	2,5	6	■
JS720160D2R300.3Z6C-HXT	03298316	2	D	■	16,0	16,0	44,0	99,0	3,0	6	■
JS720160D2R310.3Z6C-HXT	03298317	2	D	■	16,0	16,0	44,0	99,0	3,1	6	■
JS720160D2R400.3Z6C-HXT	03298318	2	D	■	16,0	16,0	44,0	99,0	4,0	6	■
JS720160D2R600.3Z6C-HXT	03298319	2	D	■	16,0	16,0	44,0	99,0	6,0	6	■

□ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS720

Alte prestazioni – Titanio – Spallamento – 6 Eliche – Weldon – Raggio di punta – Rompitruciolo





D

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Rompitruciolo
- Riaffilatura possibile

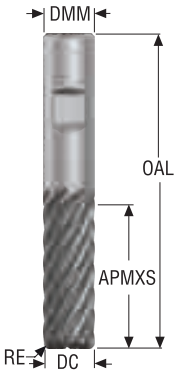


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS720160D3R050.3Z6C-HXT	10228523	3	D	■	16,0	16,0	65,0	130,0	0,5	6	□
JS720160D3R100.3Z6C-HXT	10228524	3	D	■	16,0	16,0	65,0	130,0	1,0	6	□
JS720160D3R200.3Z6C-HXT	10228525	3	D	■	16,0	16,0	65,0	130,0	2,0	6	□
JS720160D3R300.3Z6C-HXT	10228526	3	D	■	16,0	16,0	65,0	130,0	3,0	6	□
JS720200D3R050.3Z6C-HXT	03060360	3	D	■	20,0	20,0	62,0	121,0	0,5	6	■
JS720200D3R100.3Z6C-HXT	03298320	3	D	■	20,0	20,0	62,0	121,0	1,0	6	■
JS720200D3R200.3Z6C-HXT	03298321	3	D	■	20,0	20,0	62,0	121,0	2,0	6	■
JS720200D3R250.3Z6C-HXT	03298322	3	D	■	20,0	20,0	62,0	121,0	2,5	6	■
JS720200D3R300.3Z6C-HXT	03298323	3	D	■	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R310.3Z6C-HXT	03298324	3	D	■	20,0	20,0	62,0	121,0	3,1	6	■
JS720200D3R400.3Z6C-HXT	03298325	3	D	■	20,0	20,0	62,0	121,0	4,0	6	■
JS720200D3R500.3Z6C-HXT	03298326	3	D	■	20,0	20,0	62,0	121,0	5,0	6	■
JS720200D3R600.3Z6C-HXT	03298327	3	D	■	20,0	20,0	62,0	121,0	6,0	6	■
JS720250D3R050.3Z6C-HXT	03066460	3	D	■	25,0	25,0	78,0	146,0	0,5	6	■
JS720250D3R100.3Z6C-HXT	03298328	3	D	■	25,0	25,0	78,0	146,0	1,0	6	■
JS720250D3R200.3Z6C-HXT	03298329	3	D	■	25,0	25,0	78,0	146,0	2,0	6	■
JS720250D3R300.3Z6C-HXT	03298330	3	D	■	25,0	25,0	78,0	146,0	3,0	6	■
JS720250D3R400.3Z6C-HXT	03298331	3	D	■	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.3Z6C-HXT	03298332	3	D	■	25,0	25,0	78,0	146,0	6,0	6	■

□ Weldon disponibile. Il tempo di consegna è di 3 giorni.

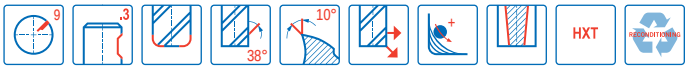
JS720

Alte prestazioni – Titanio – Spallamento – 9 Eliche – Weldon – Raggio di punta



D





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS720100D2R050.3Z9-HXT	10067881	2	D	10,0	10,0	26,0	72,0	0,5	9	☐
JS720100D2R100.3Z9-HXT	10067882	2	D	10,0	10,0	26,0	72,0	1,0	9	☐
JS720100D2R200.3Z9-HXT	10067883	2	D	10,0	10,0	26,0	72,0	2,0	9	☐
JS720120D2R050.3Z9-HXT	10067884	2	D	12,0	12,0	30,0	83,0	0,5	9	☐
JS720120D2R100.3Z9-HXT	10067885	2	D	12,0	12,0	30,0	83,0	1,0	9	☐
JS720120D2R200.3Z9-HXT	10067886	2	D	12,0	12,0	30,0	83,0	2,0	9	☐
JS720160D2R100.3Z9-HXT	10008279	2	D	16,0	16,0	44,0	99,0	1,0	9	☐
JS720160D2R200.3Z9-HXT	10008280	2	D	16,0	16,0	44,0	99,0	2,0	9	☐
JS720160D2R300.3Z9-HXT	10008281	2	D	16,0	16,0	44,0	99,0	3,0	9	☐
JS720200D2R100.3Z9-HXT	10228396	2	D	20,0	20,0	45,0	105,0	1,0	9	☐
JS720200D2R200.3Z9-HXT	10228397	2	D	20,0	20,0	45,0	105,0	2,0	9	☐
JS720200D2R300.3Z9-HXT	10228398	2	D	20,0	20,0	45,0	105,0	3,0	9	☐
JS720250D2R100.3Z9-HXT	10008282	2	D	25,0	25,0	50,0	125,0	1,0	9	☐
JS720250D2R200.3Z9-HXT	10008283	2	D	25,0	25,0	50,0	125,0	2,0	9	☐
JS720250D2R300.3Z9-HXT	10008284	2	D	25,0	25,0	50,0	125,0	3,0	9	☐
JS720100D3R050.3Z9-HXT	10067887	3	D	10,0	10,0	40,0	89,0	0,5	9	☐
JS720100D3R100.3Z9-HXT	10067888	3	D	10,0	10,0	40,0	89,0	1,0	9	☐
JS720100D3R200.3Z9-HXT	10067889	3	D	10,0	10,0	40,0	89,0	2,0	9	☐
JS720120D3R050.3Z9-HXT	10067890	3	D	12,0	12,0	45,0	100,0	0,5	9	☐
JS720120D3R100.3Z9-HXT	10067891	3	D	12,0	12,0	45,0	100,0	1,0	9	☐
JS720120D3R200.3Z9-HXT	10067892	3	D	12,0	12,0	45,0	100,0	2,0	9	☐
JS720160D3R100.3Z9-HXT	10008285	3	D	16,0	16,0	65,0	130,0	1,0	9	☐
JS720160D3R200.3Z9-HXT	10008286	3	D	16,0	16,0	65,0	130,0	2,0	9	☐
JS720160D3R300.3Z9-HXT	10008287	3	D	16,0	16,0	65,0	130,0	3,0	9	☐
JS720200D3R100.3Z9-HXT	10008288	3	D	20,0	20,0	62,0	121,0	1,0	9	☐
JS720200D3R200.3Z9-HXT	10008289	3	D	20,0	20,0	62,0	121,0	2,0	9	☐
JS720200D3R300.3Z9-HXT	10008290	3	D	20,0	20,0	62,0	121,0	3,0	9	☐
JS720250D3R100.3Z9-HXT	10008292	3	D	25,0	25,0	78,0	146,0	1,0	9	☐
JS720250D3R200.3Z9-HXT	10008293	3	D	25,0	25,0	78,0	146,0	2,0	9	☐
JS720250D3R300.3Z9-HXT	10008294	3	D	25,0	25,0	78,0	146,0	3,0	9	☐

☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS720

Alte prestazioni – Titanio – Spallamento – 9 Eliche – Weldon – Raggio di punta – Rompitruciolo





D

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

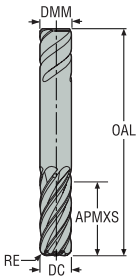


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS720100D3R050.3Z9C-HXT	10067893	3	D	■	10,0	10,0	40,0	89,0	0,5	9	□
JS720100D3R100.3Z9C-HXT	10067894	3	D	■	10,0	10,0	40,0	89,0	1,0	9	□
JS720100D3R200.3Z9C-HXT	10067895	3	D	■	10,0	10,0	40,0	89,0	2,0	9	□
JS720120D3R050.3Z9C-HXT	10067897	3	D	■	12,0	12,0	45,0	100,0	0,5	9	□
JS720120D3R100.3Z9C-HXT	10067898	3	D	■	12,0	12,0	45,0	100,0	1,0	9	□
JS720120D3R200.3Z9C-HXT	10067899	3	D	■	12,0	12,0	45,0	100,0	2,0	9	□
JS720160D3R100.3Z9C-HXT	10067900	3	D	■	16,0	16,0	65,0	130,0	1,0	9	□
JS720160D3R200.3Z9C-HXT	10067901	3	D	■	16,0	16,0	65,0	130,0	2,0	9	□
JS720160D3R300.3Z9C-HXT	10067902	3	D	■	16,0	16,0	65,0	130,0	3,0	9	□
JS720200D3R100.3Z9C-HXT	10067903	3	D	■	20,0	20,0	62,0	121,0	1,0	9	□
JS720200D3R200.3Z9C-HXT	10067904	3	D	■	20,0	20,0	62,0	121,0	2,0	9	□
JS720200D3R300.3Z9C-HXT	10067905	3	D	■	20,0	20,0	62,0	121,0	3,0	9	□
JS720250D3R100.3Z9C-HXT	10067906	3	D	■	25,0	25,0	78,0	146,0	1,0	9	□
JS720250D3R200.3Z9C-HXT	10067907	3	D	■	25,0	25,0	78,0	146,0	2,0	9	□
JS720250D3R300.3Z9C-HXT	10067908	3	D	■	25,0	25,0	78,0	146,0	3,0	9	□

■ Prodotto standard.

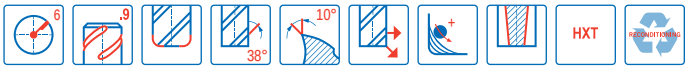
JS720

Alte prestazioni – Titanio – Spallamento – 6 Eliche – Safelock – Raggio di punta



D





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

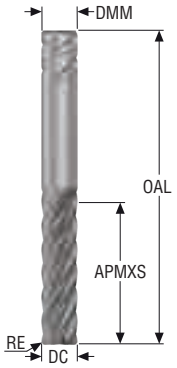
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm		
JS720060D2R050.9Z6-HXT	03060374	2	D	6,0	6,0	17,0	57,0	0,5	6	☐
JS720060D2R100.9Z6-HXT	03060375	2	D	6,0	6,0	17,0	57,0	1,0	6	☐
JS720080D2R050.9Z6-HXT	03060376	2	D	8,0	8,0	23,0	63,0	0,5	6	☐
JS720080D2R100.9Z6-HXT	03061296	2	D	8,0	8,0	23,0	63,0	1,0	6	☐
JS720100D2R050.9Z6-HXT	03060377	2	D	10,0	10,0	26,0	72,0	0,5	6	☐
JS720100D2R100.9Z6-HXT	03060379	2	D	10,0	10,0	26,0	72,0	1,0	6	☐
JS720100D2R200.9Z6-HXT	03060380	2	D	10,0	10,0	26,0	72,0	2,0	6	☐
JS720100D2R300.9Z6-HXT	03060381	2	D	10,0	10,0	26,0	72,0	3,0	6	☐
JS720120D2R050.9Z6-HXT	03060382	2	D	12,0	12,0	30,0	83,0	0,5	6	☐
JS720120D2R100.9Z6-HXT	03060384	2	D	12,0	12,0	30,0	83,0	1,0	6	☐
JS720120D2R200.9Z6-HXT	03060385	2	D	12,0	12,0	30,0	83,0	2,0	6	☐
JS720120D2R300.9Z6-HXT	03060386	2	D	12,0	12,0	30,0	83,0	3,0	6	☐
JS720160D2R050.9Z6-HXT	03060387	2	D	16,0	16,0	44,0	99,0	0,5	6	☐
JS720160D2R100.9Z6-HXT	03060389	2	D	16,0	16,0	44,0	99,0	1,0	6	☐
JS720160D2R200.9Z6-HXT	03060390	2	D	16,0	16,0	44,0	99,0	2,0	6	☐
JS720160D2R300.9Z6-HXT	03060391	2	D	16,0	16,0	44,0	99,0	3,0	6	☐
JS720160D2R400.9Z6-HXT	03060392	2	D	16,0	16,0	44,0	99,0	4,0	6	☐
JS720160D2R600.9Z6-HXT	03060393	2	D	16,0	16,0	44,0	99,0	6,0	6	☐
JS720200D2R050.9Z6-HXT	10228464	2	D	20,0	20,0	45,0	105,0	0,5	6	☐
JS720200D2R100.9Z6-HXT	10228465	2	D	20,0	20,0	45,0	105,0	1,0	6	☐
JS720200D2R200.9Z6-HXT	10228467	2	D	20,0	20,0	45,0	105,0	2,0	6	☐
JS720200D2R300.9Z6-HXT	10228468	2	D	20,0	20,0	45,0	105,0	3,0	6	☐
JS720250D2R050.9Z6-HXT	10228469	2	D	25,0	25,0	50,0	125,0	0,5	6	☐
JS720250D2R100.9Z6-HXT	10228470	2	D	25,0	25,0	50,0	125,0	1,0	6	☐
JS720250D2R200.9Z6-HXT	10228471	2	D	25,0	25,0	50,0	125,0	2,0	6	☐
JS720250D2R300.9Z6-HXT	10228472	2	D	25,0	25,0	50,0	125,0	3,0	6	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.

JS720

Alte prestazioni – Titanio – Spallamento – 6 Eliche – Safelock – Raggio di punta





D

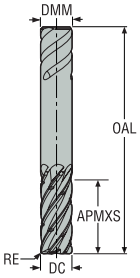
- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm		
JS720080D3R050.9Z6-HXT	10228473	3	D	8,0	8,0	32,0	80,0	0,5	6	☐
JS720080D3R100.9Z6-HXT	10228474	3	D	8,0	8,0	32,0	80,0	1,0	6	☐
JS720100D3R050.9Z6-HXT	10228475	3	D	10,0	10,0	40,0	89,0	0,5	6	☐
JS720100D3R100.9Z6-HXT	10228476	3	D	10,0	10,0	40,0	89,0	1,0	6	☐
JS720100D3R200.9Z6-HXT	10228477	3	D	10,0	10,0	40,0	89,0	2,0	6	☐
JS720120D3R050.9Z6-HXT	10228478	3	D	12,0	12,0	45,0	100,0	0,5	6	☐
JS720120D3R100.9Z6-HXT	10228479	3	D	12,0	12,0	45,0	100,0	1,0	6	☐
JS720120D3R200.9Z6-HXT	10228480	3	D	12,0	12,0	45,0	100,0	2,0	6	☐
JS720160D3R050.9Z6-HXT	10228481	3	D	16,0	16,0	65,0	130,0	0,5	6	☐
JS720160D3R100.9Z6-HXT	10228482	3	D	16,0	16,0	65,0	130,0	1,0	6	☐
JS720160D3R200.9Z6-HXT	10228483	3	D	16,0	16,0	65,0	130,0	2,0	6	☐
JS720160D3R300.9Z6-HXT	10228484	3	D	16,0	16,0	65,0	130,0	3,0	6	☐
JS720200D3R050.9Z6-HXT	03060394	3	D	20,0	20,0	62,0	121,0	0,5	6	☐
JS720200D3R100.9Z6-HXT	03060396	3	D	20,0	20,0	62,0	121,0	1,0	6	☐
JS720200D3R200.9Z6-HXT	03060397	3	D	20,0	20,0	62,0	121,0	2,0	6	☐
JS720200D3R300.9Z6-HXT	03060398	3	D	20,0	20,0	62,0	121,0	3,0	6	☐
JS720200D3R400.9Z6-HXT	03060399	3	D	20,0	20,0	62,0	121,0	4,0	6	☐
JS720200D3R500.9Z6-HXT	03060400	3	D	20,0	20,0	62,0	121,0	5,0	6	☐
JS720200D3R600.9Z6-HXT	03060401	3	D	20,0	20,0	62,0	121,0	6,0	6	☐
JS720250D3R050.9Z6-HXT	03060402	3	D	25,0	25,0	78,0	146,0	0,5	6	☐
JS720250D3R100.9Z6-HXT	03060403	3	D	25,0	25,0	78,0	146,0	1,0	6	☐
JS720250D3R200.9Z6-HXT	03060404	3	D	25,0	25,0	78,0	146,0	2,0	6	☐
JS720250D3R300.9Z6-HXT	03060405	3	D	25,0	25,0	78,0	146,0	3,0	6	☐
JS720250D3R400.9Z6-HXT	03060406	3	D	25,0	25,0	78,0	146,0	4,0	6	☐
JS720250D3R600.9Z6-HXT	03060407	3	D	25,0	25,0	78,0	146,0	6,0	6	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.

JS720

Alte prestazioni – Titanio – Spallamento – 6 Eliche – Safelock – Raggio di punta – Rompitruciolo



D





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Rompitruciolo
- Riaffilatura possibile

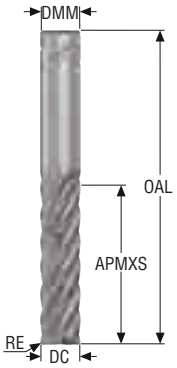
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm		
JS720080D2R050.9Z6C-HXT	10228527	2	D	■	8,0	8,0	23,0	63,0	0,5	6	□
JS720080D2R100.9Z6C-HXT	10228528	2	D	■	8,0	8,0	23,0	63,0	1,0	6	□
JS720100D2R050.9Z6C-HXT	03060378	2	D	■	10,0	10,0	26,0	72,0	0,5	6	□
JS720100D2R100.9Z6C-HXT	10228529	2	D	■	10,0	10,0	26,0	72,0	1,0	6	□
JS720120D2R050.9Z6C-HXT	03060383	2	D	■	12,0	12,0	30,0	83,0	0,5	6	□
JS720120D2R100.9Z6C-HXT	03298334	2	D	■	12,0	12,0	30,0	83,0	1,0	6	□
JS720120D2R200.9Z6C-HXT	03298335	2	D	■	12,0	12,0	30,0	83,0	2,0	6	□
JS720120D2R250.9Z6C-HXT	03298336	2	D	■	12,0	12,0	30,0	83,0	2,5	6	□
JS720120D2R300.9Z6C-HXT	03298337	2	D	■	12,0	12,0	30,0	83,0	3,0	6	□
JS720120D2R310.9Z6C-HXT	03298338	2	D	■	12,0	12,0	30,0	83,0	3,1	6	□
JS720160D2R050.9Z6C-HXT	03060388	2	D	■	16,0	16,0	44,0	99,0	0,5	6	□
JS720160D2R100.9Z6C-HXT	03298339	2	D	■	16,0	16,0	44,0	99,0	1,0	6	□
JS720160D2R200.9Z6C-HXT	03298340	2	D	■	16,0	16,0	44,0	99,0	2,0	6	□
JS720160D2R250.9Z6C-HXT	03298341	2	D	■	16,0	16,0	44,0	99,0	2,5	6	□
JS720160D2R300.9Z6C-HXT	03298342	2	D	■	16,0	16,0	44,0	99,0	3,0	6	□
JS720160D2R310.9Z6C-HXT	03298343	2	D	■	16,0	16,0	44,0	99,0	3,1	6	□
JS720160D2R400.9Z6C-HXT	03298344	2	D	■	16,0	16,0	44,0	99,0	4,0	6	□
JS720160D2R600.9Z6C-HXT	03298345	2	D	■	16,0	16,0	44,0	99,0	6,0	6	□

■ Prodotto standard.

JS720

Alte prestazioni – Titanio – Spallamento – 6 Eliche – Safelock – Raggio di punta – Rompitruciolo





D

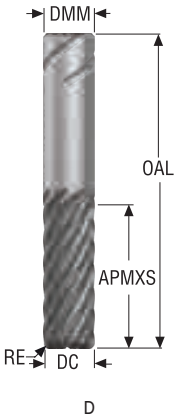
- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Rompitruciolo
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm		
JS720160D3R050.9Z6C-HXT	10228530	3	D	■	16,0	16,0	65,0	130,0	0,5	6	☐
JS720160D3R100.9Z6C-HXT	10228531	3	D	■	16,0	16,0	65,0	130,0	1,0	6	☐
JS720160D3R200.9Z6C-HXT	10228532	3	D	■	16,0	16,0	65,0	130,0	2,0	6	☐
JS720160D3R300.9Z6C-HXT	10228533	3	D	■	16,0	16,0	65,0	130,0	3,0	6	☐
JS720200D3R050.9Z6C-HXT	03060395	3	D	■	20,0	20,0	62,0	121,0	0,5	6	☐
JS720200D3R100.9Z6C-HXT	03298346	3	D	■	20,0	20,0	62,0	121,0	1,0	6	☐
JS720200D3R200.9Z6C-HXT	03298347	3	D	■	20,0	20,0	62,0	121,0	2,0	6	☐
JS720200D3R250.9Z6C-HXT	03298348	3	D	■	20,0	20,0	62,0	121,0	2,5	6	☐
JS720200D3R300.9Z6C-HXT	03298349	3	D	■	20,0	20,0	62,0	121,0	3,0	6	☐
JS720200D3R310.9Z6C-HXT	03298350	3	D	■	20,0	20,0	62,0	121,0	3,1	6	☐
JS720200D3R400.9Z6C-HXT	03298351	3	D	■	20,0	20,0	62,0	121,0	4,0	6	☐
JS720200D3R500.9Z6C-HXT	03298352	3	D	■	20,0	20,0	62,0	121,0	5,0	6	☐
JS720200D3R600.9Z6C-HXT	03298353	3	D	■	20,0	20,0	62,0	121,0	6,0	6	☐
JS720250D3R050.9Z6C-HXT	03066461	3	D	■	25,0	25,0	78,0	146,0	0,5	6	☐
JS720250D3R100.9Z6C-HXT	03298354	3	D	■	25,0	25,0	78,0	146,0	1,0	6	☐
JS720250D3R200.9Z6C-HXT	03298355	3	D	■	25,0	25,0	78,0	146,0	2,0	6	☐
JS720250D3R300.9Z6C-HXT	03298356	3	D	■	25,0	25,0	78,0	146,0	3,0	6	☐
JS720250D3R400.9Z6C-HXT	03298357	3	D	■	25,0	25,0	78,0	146,0	4,0	6	☐
JS720250D3R600.9Z6C-HXT	03298358	3	D	■	25,0	25,0	78,0	146,0	6,0	6	☐

■ Prodotto standard.

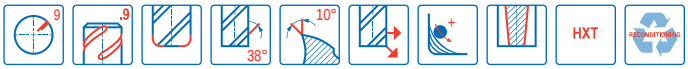
JS720

Alte prestazioni – Titanio – Spallamento – 9 Eliche – Safelock – Raggio di punta



D





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm		
JS720100D2R050.9Z9-HXT	10067909	2	D	10,0	10,0	26,0	72,0	0,5	9	☐
JS720100D2R100.9Z9-HXT	10067910	2	D	10,0	10,0	26,0	72,0	1,0	9	☐
JS720100D2R200.9Z9-HXT	10067911	2	D	10,0	10,0	26,0	72,0	2,0	9	☐
JS720120D2R050.9Z9-HXT	10067912	2	D	12,0	12,0	30,0	83,0	0,5	9	☐
JS720120D2R100.9Z9-HXT	10067913	2	D	12,0	12,0	30,0	83,0	1,0	9	☐
JS720120D2R200.9Z9-HXT	10067914	2	D	12,0	12,0	30,0	83,0	2,0	9	☐
JS720160D2R100.9Z9-HXT	10008295	2	D	16,0	16,0	44,0	99,0	1,0	9	☐
JS720160D2R200.9Z9-HXT	10008296	2	D	16,0	16,0	44,0	99,0	2,0	9	☐
JS720160D2R300.9Z9-HXT	10008297	2	D	16,0	16,0	44,0	99,0	3,0	9	☐
JS720200D2R100.9Z9-HXT	10228399	2	D	20,0	20,0	45,0	105,0	1,0	9	☐
JS720200D2R200.9Z9-HXT	10228400	2	D	20,0	20,0	45,0	105,0	2,0	9	☐
JS720200D2R300.9Z9-HXT	10228401	2	D	20,0	20,0	45,0	105,0	3,0	9	☐
JS720250D2R100.9Z9-HXT	10008298	2	D	25,0	25,0	50,0	125,0	1,0	9	☐
JS720250D2R200.9Z9-HXT	10008299	2	D	25,0	25,0	50,0	125,0	2,0	9	☐
JS720250D2R300.9Z9-HXT	10008300	2	D	25,0	25,0	50,0	125,0	3,0	9	☐
JS720100D3R050.9Z9-HXT	10067915	3	D	10,0	10,0	40,0	89,0	0,5	9	☐
JS720100D3R100.9Z9-HXT	10067916	3	D	10,0	10,0	40,0	89,0	1,0	9	☐
JS720100D3R200.9Z9-HXT	10067917	3	D	10,0	10,0	40,0	89,0	2,0	9	☐
JS720120D3R050.9Z9-HXT	10067918	3	D	12,0	12,0	45,0	100,0	0,5	9	☐
JS720120D3R100.9Z9-HXT	10067919	3	D	12,0	12,0	45,0	100,0	1,0	9	☐
JS720120D3R200.9Z9-HXT	10067921	3	D	12,0	12,0	45,0	100,0	2,0	9	☐
JS720160D3R100.9Z9-HXT	10008301	3	D	16,0	16,0	65,0	130,0	1,0	9	☐
JS720160D3R200.9Z9-HXT	10008302	3	D	16,0	16,0	65,0	130,0	2,0	9	☐
JS720160D3R300.9Z9-HXT	10008303	3	D	16,0	16,0	65,0	130,0	3,0	9	☐
JS720200D3R100.9Z9-HXT	10008304	3	D	20,0	20,0	62,0	121,0	1,0	9	☐
JS720200D3R200.9Z9-HXT	10008305	3	D	20,0	20,0	62,0	121,0	2,0	9	☐
JS720200D3R300.9Z9-HXT	10008306	3	D	20,0	20,0	62,0	121,0	3,0	9	☐
JS720250D3R100.9Z9-HXT	10008307	3	D	25,0	25,0	78,0	146,0	1,0	9	☐
JS720250D3R200.9Z9-HXT	10008308	3	D	25,0	25,0	78,0	146,0	2,0	9	☐
JS720250D3R300.9Z9-HXT	10008309	3	D	25,0	25,0	78,0	146,0	3,0	9	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.

JS720

Alte prestazioni – Titanio – Spallamento – 9 Eliche – Safelock – Raggio di punta – Rompitruciolo





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Rompitruciolo
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm		
JS720100D3R050.9Z9C-HXT	10067922	3	D	■	10,0	10,0	40,0	89,0	0,5	9	☐
JS720100D3R100.9Z9C-HXT	10067923	3	D	■	10,0	10,0	40,0	89,0	1,0	9	☐
JS720100D3R200.9Z9C-HXT	10067924	3	D	■	10,0	10,0	40,0	89,0	2,0	9	☐
JS720120D3R050.9Z9C-HXT	10067925	3	D	■	12,0	12,0	45,0	100,0	0,5	9	☐
JS720120D3R100.9Z9C-HXT	10067926	3	D	■	12,0	12,0	45,0	100,0	1,0	9	☐
JS720120D3R200.9Z9C-HXT	10067927	3	D	■	12,0	12,0	45,0	100,0	2,0	9	☐
JS720160D3R100.9Z9C-HXT	10067928	3	D	■	16,0	16,0	65,0	130,0	1,0	9	☐
JS720160D3R200.9Z9C-HXT	10067929	3	D	■	16,0	16,0	65,0	130,0	2,0	9	☐
JS720160D3R300.9Z9C-HXT	10067930	3	D	■	16,0	16,0	65,0	130,0	3,0	9	☐
JS720200D3R100.9Z9C-HXT	10067931	3	D	■	20,0	20,0	62,0	121,0	1,0	9	☐
JS720200D3R200.9Z9C-HXT	10067932	3	D	■	20,0	20,0	62,0	121,0	2,0	9	☐
JS720200D3R300.9Z9C-HXT	10067933	3	D	■	20,0	20,0	62,0	121,0	3,0	9	☐
JS720250D3R100.9Z9C-HXT	10067934	3	D	■	25,0	25,0	78,0	146,0	1,0	9	☐
JS720250D3R200.9Z9C-HXT	10067935	3	D	■	25,0	25,0	78,0	146,0	2,0	9	☐
JS720250D3R300.9Z9C-HXT	10067936	3	D	■	25,0	25,0	78,0	146,0	3,0	9	☐

■ Prodotto standard.

Parametri di taglio – JS720 Contornatura PCEDC =6

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
M1	E	0.400 *0,400*	1.1 *1,1*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	110 (85 — 140) *360 (280 — 450)*
M2	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	90 (70 — 110) *295 (230 — 360)*
M3	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	70 (55 — 99) *230 (190 — 320)*
M4	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*
M5	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	65 (50 — 83) *215 (170 — 270)*
S1	E	0.0500 *0,0500*	2.6 *2,6*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	43 (29 — 71) *140 (96 — 230)*
S2	E	0.0500 *0,0500*	2.6 *2,6*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	34 (23 — 57) *110 (76 — 180)*
S3	E	0.0500 *0,0500*	2.6 *2,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	30 (20 — 49) *100 (66 — 160)*
S11	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	105 (78 — 120) *345 (260 — 390)*
S12	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*
S13	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*

Parametri di taglio – JS720 Contornatura sgrossatura avanzata a_e/DC=0,07 PCEDC =6

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.9 *1,9*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	140 (110 — 180) *460 (370 — 590)*
M2	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	115 (91 — 150) *375 (300 — 490)*
M3	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	90 (72 — 120) *295 (240 — 390)*
M4	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*
M5	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	85 (65 — 100) *280 (220 — 320)*
S1	E	2.6 *2,6*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	41 (28 — 68) *135 (92 — 220)*
S2	E	2.6 *2,6*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	33 (22 — 54) *110 (73 — 170)*
S3	E	2.6 *2,6*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	29 (20 — 47) *95 (66 — 150)*
S11	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	135 (110 — 160) *445 (370 — 520)*
S12	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*
S13	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JS720 Contornatura sgrossatura avanzata a_e/DC=0,07 PCEDC =9

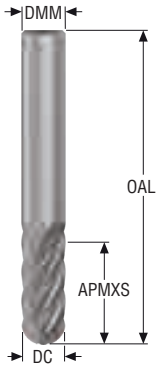
SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
M1	E	2.0 *2,0*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	125 (98 — 160) *410 (330 — 520)*
M2	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (82 — 130) *345 (270 — 420)*
M3	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	80 (64 — 110) *260 (210 — 360)*
M4	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*
M5	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	75 (59 — 96) *245 (200 — 310)*
S1	E	2.8 *2,8*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	37 (25 — 61) *120 (83 — 200)*
S2	E	2.8 *2,8*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	30 (20 — 49) *100 (66 — 160)*
S3	E	2.8 *2,8*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	26 (18 — 43) *85 (60 — 140)*
S11	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	120 (91 — 150) *395 (300 — 490)*
S12	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*
S13	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

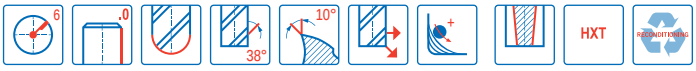
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS730

Alte prestazioni – Titanio – A testa sferica – 6 Eliche – Cilindrico



D





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Due taglienti al centro
- Riaffilatura possibile

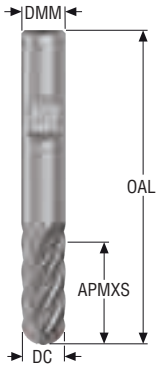
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
				mm	mm	mm	mm		
JS730060D2B.0Z6-HXT	03067605	2	D	6,0	6,0	17,0	57,0	6	■
JS730080D2B.0Z6-HXT	03067606	2	D	8,0	8,0	23,0	63,0	6	■
JS730100D2B.0Z6-HXT	03067607	2	D	10,0	10,0	26,0	72,0	6	■
JS730120D2B.0Z6-HXT	03067608	2	D	12,0	12,0	30,0	83,0	6	■
JS730160D2B.0Z6-HXT	03067609	2	D	16,0	16,0	44,0	99,0	6	■
JS730200D3B.0Z6-HXT	03067610	3	D	20,0	20,0	62,0	121,0	6	■
JS730250D3B.0Z6-HXT	03067611	3	D	25,0	25,0	78,0	146,0	6	■

■ Prodotto standard.

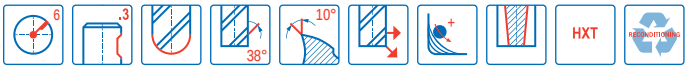
JS730

Alte prestazioni – Titanio – A testa sferica – 6 Eliche – Weldon





D



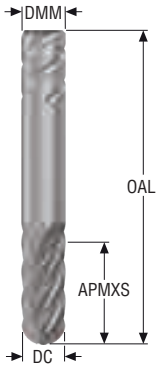
- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Due taglienti al centro
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
JS730060D2B.3Z6-HXT	03067778	2	D	6,0	6,0	17,0	57,0	6	☐
JS730080D2B.3Z6-HXT	03067779	2	D	8,0	8,0	23,0	63,0	6	☐
JS730100D2B.3Z6-HXT	03067780	2	D	10,0	10,0	26,0	72,0	6	☐
JS730120D2B.3Z6-HXT	03067781	2	D	12,0	12,0	30,0	83,0	6	☐
JS730160D2B.3Z6-HXT	03067782	2	D	16,0	16,0	44,0	99,0	6	☐
JS730200D3B.3Z6-HXT	03067783	3	D	20,0	20,0	62,0	121,0	6	☐
JS730250D3B.3Z6-HXT	03067784	3	D	25,0	25,0	78,0	146,0	6	☐

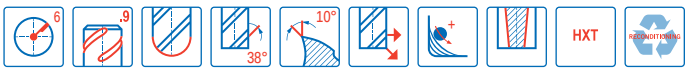
☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS730

Alte prestazioni – Titanio – A testa sferica 6 Eliche – Safelock



D





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Due taglienti al centro
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Safelock
				mm	mm	mm	mm		
JS730060D2B.9Z6-HXT	03067785	2	D	6,0	6,0	17,0	57,0	6	☐
JS730080D2B.9Z6-HXT	03067786	2	D	8,0	8,0	23,0	63,0	6	☐
JS730100D2B.9Z6-HXT	03067787	2	D	10,0	10,0	26,0	72,0	6	☐
JS730120D2B.9Z6-HXT	03067788	2	D	12,0	12,0	30,0	83,0	6	☐
JS730160D2B.9Z6-HXT	03067789	2	D	16,0	16,0	44,0	99,0	6	☐
JS730200D3B.9Z6-HXT	03067790	3	D	20,0	20,0	62,0	121,0	6	☐
JS730250D3B.9Z6-HXT	03067791	3	D	25,0	25,0	78,0	146,0	6	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.

Parametri di taglio – JS730 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
M1	E	0.100 *0,100*	1.8 *1,8*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	140 (89 — 150) *460 (300 — 490)*
M2	E	0.150 *0,150*	2.2 *2,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (70 — 120) *360 (230 — 390)*
M3	E	0.100 *0,100*	1.8 *1,8*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	85 (55 — 99) *280 (190 — 320)*
M4	E	0.100 *0,100*	1.8 *1,8*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	90 (57 — 100) *295 (190 — 320)*
M5	E	0.100 *0,100*	1.8 *1,8*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (47 — 85) *245 (160 — 270)*
S1	E	0.150 *0,150*	2.2 *2,2*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	43 (29 — 70) *140 (96 — 220)*
S2	E	0.150 *0,150*	2.2 *2,2*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	34 (23 — 57) *110 (76 — 180)*
S3	E	0.150 *0,150*	2.2 *2,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	30 (20 — 49) *100 (66 — 160)*
S11	E	0.300 *0,300*	1.2 *1,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	130 (79 — 130) *425 (260 — 420)*
S12	E	0.300 *0,300*	1.2 *1,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	100 (61 — 100) *330 (210 — 320)*
S13	E	0.300 *0,300*	1.2 *1,2*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	100 (62 — 100) *330 (210 — 320)*

Parametri di taglio – JS730 Contornatura sgrossatura avanzata a_e/DC=0,07

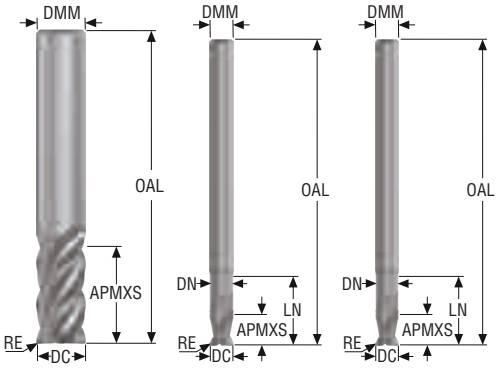
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	145 (93 — 150) *475 (310 — 490)*
M2	E	2.2 *2,2*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	125 (78 — 130) *410 (260 — 420)*
M3	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	90 (58 — 100) *295 (200 — 320)*
M4	E	1.9 *1,9*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	95 (59 — 100) *310 (200 — 320)*
M5	E	1.9 *1,9*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	80 (50 — 89) *260 (170 — 290)*
S1	E	2.2 *2,2*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	47 (32 — 79) *155 (110 — 250)*
S2	E	2.2 *2,2*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	38 (26 — 63) *125 (86 — 200)*
S3	E	2.2 *2,2*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	33 (23 — 55) *110 (76 — 180)*
S11	E	1.9 *1,9*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (94 — 150) *490 (310 — 490)*
S12	E	1.9 *1,9*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	115 (72 — 110) *375 (240 — 360)*
S13	E	1.9 *1,9*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	120 (74 — 120) *395 (250 — 390)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

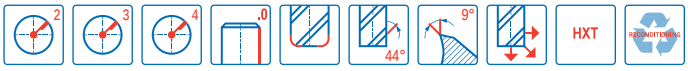
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JHP751

Alte prestazioni – Titanio – Spallamento – 2-4 Eliche – Cilindrico – Raggio di punta







- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

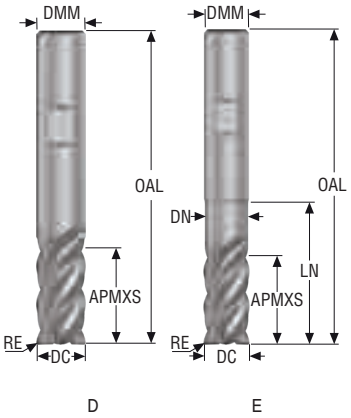
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JHP751080D1R040.0Z4	HXT	10105487	1	D	8,0	8,0	16,0	58,0	–	–	0,4	4	■
JHP751100D1R040.0Z4	HXT	10105548	1	D	10,0	10,0	20,0	66,0	–	–	0,4	4	■
JHP751100D1R150.0Z4	HXT	10105549	1	D	10,0	10,0	20,0	66,0	–	–	1,5	4	■
JHP751120D1R040.0Z4	HXT	10105550	1	D	12,0	12,0	24,0	75,0	–	–	0,4	4	■
JHP751120D1R150.0Z4	HXT	10105552	1	D	12,0	12,0	24,0	75,0	–	–	1,5	4	■
JHP751160D1R040.0Z4	HXT	10105581	1	D	16,0	16,0	32,0	92,0	–	–	0,4	4	■
JHP751160D1R150.0Z4	HXT	10105582	1	D	16,0	16,0	32,0	92,0	–	–	1,5	4	■
JHP751200D1R080.0Z4	HXT	10105583	1	D	20,0	20,0	40,0	104,0	–	–	0,8	4	■
JHP751020G2R020.0Z2	HXT	10105584	2	G	2,0	3,0	3,0	38,0	6,0	1,9	0,2	2	■
JHP751030G2R020.0Z2	HXT	10105585	2	E	3,0	3,0	4,5	38,0	9,0	2,8	0,2	2	■
JHP751040G2R020.0Z2	HXT	10105586	2	G	4,0	6,0	6,0	50,0	9,0	3,7	0,2	2	■
JHP751050G2R030.0Z2	HXT	10105587	2	G	5,0	6,0	7,5	50,0	9,0	4,6	0,3	2	■
JHP751060E2R030.0Z3	HXT	10105588	2	E	6,0	6,0	9,0	57,0	19,0	5,6	0,3	3	■
JHP751080E2R040.0Z4	HXT	10105589	2	E	8,0	8,0	16,0	63,0	24,0	7,4	0,4	4	■
JHP751100E2R040.0Z4	HXT	10105590	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,4	4	■
JHP751100E2R080.0Z4	HXT	10105591	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,8	4	■
JHP751100E2R200.0Z4	HXT	10105593	2	E	10,0	10,0	20,0	72,0	30,0	9,4	2,0	4	■
JHP751120E2R040.0Z4	HXT	10105594	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,4	4	■
JHP751120E2R080.0Z4	HXT	10105595	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,8	4	■
JHP751120E2R310.0Z4	HXT	10105596	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,1	4	■
JHP751140E2R080.0Z4	HXT	10105597	2	E	14,0	14,0	28,0	92,0	45,0	13,4	0,8	4	■
JHP751160E2R040.0Z4	HXT	10105598	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,4	4	■
JHP751160E2R080.0Z4	HXT	10105599	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,8	4	■
JHP751160E2R200.0Z4	HXT	10105600	2	E	16,0	16,0	32,0	104,0	52,0	15,4	2,0	4	■
JHP751200E2R080.0Z4	HXT	10105601	2	E	20,0	20,0	40,0	129,0	75,0	19,4	0,8	4	■

■ Prodotto standard.

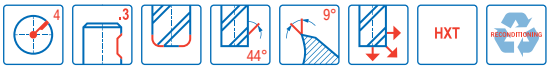
JHP751

Alte prestazioni – Titanio – Spallamento – 2-4 Eliche – Weldon – Raggio di punta





- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP751080D1R040.3Z4	HXT	10105739	1	D	8,0	8,0	16,0	58,0	–	–	0,4	4	■
JHP751100D1R040.3Z4	HXT	10105740	1	D	10,0	10,0	20,0	66,0	–	–	0,4	4	■
JHP751100D1R150.3Z4	HXT	10105742	1	D	10,0	10,0	20,0	66,0	–	–	1,5	4	■
JHP751120D1R040.3Z4	HXT	10105743	1	D	12,0	12,0	24,0	75,0	–	–	0,4	4	■
JHP751120D1R150.3Z4	HXT	10105744	1	D	12,0	12,0	24,0	75,0	–	–	1,5	4	■
JHP751160D1R040.3Z4	HXT	10105745	1	D	16,0	16,0	32,0	92,0	–	–	0,4	4	■
JHP751160D1R150.3Z4	HXT	10105746	1	D	16,0	16,0	32,0	92,0	–	–	1,5	4	■
JHP751200D1R080.3Z4	HXT	10105747	1	D	20,0	20,0	40,0	104,0	–	–	0,8	4	■
JHP751080E2R040.3Z4	HXT	10105748	2	E	8,0	8,0	16,0	63,0	24,0	7,4	0,4	4	■
JHP751100E2R040.3Z4	HXT	10105749	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,4	4	■
JHP751100E2R080.3Z4	HXT	10105750	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,8	4	■
JHP751100E2R200.3Z4	HXT	10105751	2	E	10,0	10,0	20,0	72,0	30,0	9,4	2,0	4	■
JHP751120E2R040.3Z4	HXT	10105752	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,4	4	■
JHP751120E2R080.3Z4	HXT	10105753	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,8	4	■
JHP751120E2R310.3Z4	HXT	10105754	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,1	4	■
JHP751140E2R080.3Z4	HXT	10105755	2	E	14,0	14,0	28,0	92,0	45,0	13,4	0,8	4	■
JHP751160E2R040.3Z4	HXT	10105756	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,4	4	■
JHP751160E2R080.3Z4	HXT	10105757	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,8	4	■
JHP751160E2R200.3Z4	HXT	10105758	2	E	16,0	16,0	32,0	104,0	52,0	15,4	2,0	4	■
JHP751200E2R080.3Z4	HXT	10105759	2	E	20,0	20,0	40,0	129,0	75,0	19,4	0,8	4	■

■ Prodotto standard.

Parametri di taglio – JHP751 Contornatura

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
S1	E/M/A	0.0600 *0,0600*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	48 (33 — 64) *155 (110 — 200)*
S2	E/M/A	0.0600 *0,0600*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	39 (26 — 51) *130 (86 — 160)*
S3	E/M/A	0.0400 *0,0400*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	33 (26 — 50) *110 (86 — 160)*
S11	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	145 (130 — 180) *475 (430 — 590)*
S12	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	110 (95 — 140) *360 (320 — 450)*
S13	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	90 (76 — 110) *295 (250 — 360)*

Parametri di taglio – JHP751 Scanalatura

SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
S1	E/M/A	0.44 *0,44*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	30 (20 — 39) *100 (66 — 120)*
S2	E/M/A	0.44 *0,44*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	24 (17 — 32) *80 (56 — 100)*
S3	E/M/A	0.34 *0,34*	0.0046 *0,00018*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.034 *0,0013*	0.040 *0,0016*	20 (15 — 29) *65 (50 — 95)*
S11	E/M/A	0.70 *0,70*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	90 (78 — 110) *295 (260 — 360)*
S12	E/M/A	0.70 *0,70*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	70 (60 — 89) *230 (200 — 290)*
S13	E/M/A	0.70 *0,70*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	55 (48 — 71) *180 (160 — 230)*

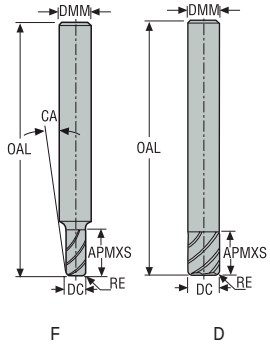
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

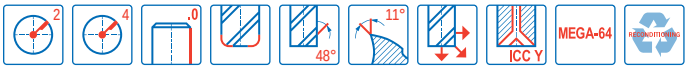
JHP760

Alte prestazioni – ISO-M – Spallamento – 2-4 Eliche – Cilindrico – Raggio di punta – ICC





- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Riaffilatura possibile se DC è ≥Ø6

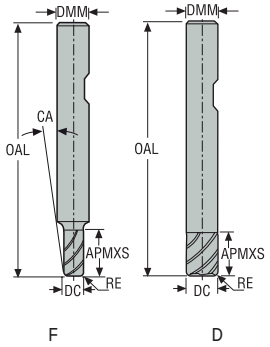


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm			
760040R020Z2.0A-MEGA-64	02734051	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0 °	2	■
760040R040Z2.0A-MEGA-64	02623413	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0 °	2	■
760050R020Z2.0A-MEGA-64	02734052	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0 °	2	■
760050R040Z2.0A-MEGA-64	02623435	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0 °	2	■
760060R020Z4.0A-MEGA-64	02734053	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	■
760060R040Z4.0A-MEGA-64	02623433	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	■
760080R040Z4.0A-MEGA-64	02623436	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	■
760080R100Z4.0A-MEGA-64	02623437	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	■
760100R040Z4.0A-MEGA-64	02623460	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	■
760100R100Z4.0A-MEGA-64	02623463	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	■
760100R150Z4.0A-MEGA-64	02623466	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	■
760120R040Z4.0A-MEGA-64	02623819	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	■
760120R100Z4.0A-MEGA-64	02623825	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	■
760120R150Z4.0A-MEGA-64	02623828	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	■
760120R310Z4.0A-MEGA-64	02623833	2	D	■	12,0	12,0	24,0	75,0	3,1	–	4	■
760200R040Z4.0A-MEGA-64	02734055	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	■
760200R080Z4.0A-MEGA-64	02623852	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	■
760L080R040Z4.0A-MEGA-64	02623438	3	D	■	8,0	8,0	28,0	65,0	0,4	–	4	■
760L100R040Z4.0A-MEGA-64	02623461	3	D	■	10,0	10,0	36,0	75,0	0,4	–	4	■
760L100R100Z4.0A-MEGA-64	02623464	3	D	■	10,0	10,0	36,0	75,0	1,0	–	4	■
760L100R150Z4.0A-MEGA-64	02623467	3	D	■	10,0	10,0	36,0	75,0	1,5	–	4	■
760L100R200Z4.0A-MEGA-64	02623472	3	D	■	10,0	10,0	36,0	75,0	2,0	–	4	■
760L100R310Z4.0A-MEGA-64	02623807	3	D	■	10,0	10,0	36,0	75,0	3,1	–	4	■
760L120R040Z4.0A-MEGA-64	02623821	3	D	■	12,0	12,0	42,0	90,0	0,4	–	4	■
760L120R100Z4.0A-MEGA-64	02623826	3	D	■	12,0	12,0	42,0	90,0	1,0	–	4	■
760L120R150Z4.0A-MEGA-64	02623829	3	D	■	12,0	12,0	42,0	90,0	1,5	–	4	■
760L120R400Z4.0A-MEGA-64	02623838	3	D	■	12,0	12,0	42,0	90,0	4,0	–	4	■
760L160R040Z4.0A-MEGA-64	02623840	3	D	■	16,0	16,0	50,0	100,0	0,4	–	4	■
760L160R100Z4.0A-MEGA-64	02623842	3	D	■	16,0	16,0	50,0	100,0	1,0	–	4	■
760L160R150Z4.0A-MEGA-64	02623844	3	D	■	16,0	16,0	50,0	100,0	1,5	–	4	■

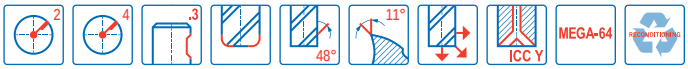
■ Prodotto standard.
ICC = Canale adduzione refrigerante interna

JHP760

Alte prestazioni – ISO-M – Spallamento – 2-4 Eliche – Weldon – Raggio di punta – ICC







- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Riaffilatura possibile se DC è ≥Ø6

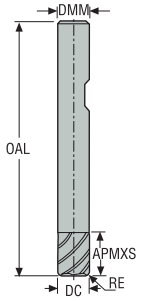
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Weldon
					mm	mm	mm	mm	mm			
760040R020Z2.0A-MEGA-64W	02734065	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0 °	2	□
760040R040Z2.0A-MEGA-64W	02669339	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0 °	2	□
760050R020Z2.0A-MEGA-64W	02734068	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0 °	2	□
760050R040Z2.0A-MEGA-64W	02669340	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0 °	2	□
760060R020Z4.0A-MEGA-64W	02734069	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	□
760060R040Z4.0A-MEGA-64W	02669341	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	□
760080R040Z4.0A-MEGA-64W	02669343	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	□
760080R100Z4.0A-MEGA-64W	02669344	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	□
760100R040Z4A-MEGA-64	02623442	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	■
760100R100Z4A-MEGA-64	02623462	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	■
760100R150Z4A-MEGA-64	02623465	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	■
760120R040Z4A-MEGA-64	02623817	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	■
760120R100Z4A-MEGA-64	02623824	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	■
760120R150Z4A-MEGA-64	02623827	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	■
760120R400Z4A-MEGA-64	02623835	2	D	■	12,0	12,0	24,0	75,0	4,0	–	4	■
760160R040Z4A-MEGA-64	02623839	2	D	■	16,0	16,0	40,0	90,0	0,4	–	4	■
760160R100Z4A-MEGA-64	02623841	2	D	■	16,0	16,0	40,0	90,0	1,0	–	4	■
760160R150Z4A-MEGA-64	02623843	2	D	■	16,0	16,0	40,0	90,0	1,5	–	4	■
760160R200Z4A-MEGA-64	02623845	2	D	■	16,0	16,0	40,0	90,0	2,0	–	4	■
760200R040Z4A-MEGA-64	02734054	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	■
760200R080Z4A-MEGA-64	02623851	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	■

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.
ICC = Canale adduzione refrigerante interna

JHP760

Alte prestazioni – ISO-M – Spallamento – 2-4 Eliche – Weldon – Raggio di punta – ICC





D

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
760L080R040Z4.0A-MEGA-64W	02720459	3	D	■	8,0	8,0	28,0	65,0	0,4	4	☐
760L100R040Z4.0A-MEGA-64W	02669345	3	D	■	10,0	10,0	36,0	75,0	0,4	4	☐
760L100R100Z4.0A-MEGA-64W	02669346	3	D	■	10,0	10,0	36,0	75,0	1,0	4	☐
760L100R150Z4.0A-MEGA-64W	02669347	3	D	■	10,0	10,0	36,0	75,0	1,5	4	☐
760L100R200Z4.0A-MEGA-64W	02669348	3	D	■	10,0	10,0	36,0	75,0	2,0	4	☐
760L120R040Z4.0A-MEGA-64W	02669350	3	D	■	12,0	12,0	42,0	90,0	0,4	4	☐
760L120R100Z4.0A-MEGA-64W	02669351	3	D	■	12,0	12,0	42,0	90,0	1,0	4	☐
760L120R150Z4.0A-MEGA-64W	02669352	3	D	■	12,0	12,0	42,0	90,0	1,5	4	☐
760L160R040Z4.0A-MEGA-64W	02669356	3	D	■	16,0	16,0	50,0	100,0	0,4	4	☐
760L160R100Z4.0A-MEGA-64W	02669357	3	D	■	16,0	16,0	50,0	100,0	1,0	4	☐
760L160R150Z4.0A-MEGA-64W	02669358	3	D	■	16,0	16,0	50,0	100,0	1,5	4	☐

☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.
ICC = Canale adduzione refrigerante interna

Parametri di taglio – JHP760 Contornatura

SMG		a_e/DC	a_p/DC	f_z									v_c
				4	5	6	8	10	12	16	20	25	
M1	E	0.300 *0,300*	1.5 *1,5*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	120 (97 — 130) *395 (320 — 420)*
M2	E	0.300 *0,300*	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	100 (81 — 110) *330 (270 — 360)*
M3	E	0.300 *0,300*	1.4 *1,4*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	75 (58 — 91) *245 (200 — 290)*
M4	E	0.300 *0,300*	1.4 *1,4*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	60 (45 — 70) *195 (150 — 220)*
M5	E	0.300 *0,300*	1.4 *1,4*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	48 (37 — 59) *155 (130 — 190)*

Parametri di taglio – JHP760 Scanalatura

SMG		a_p/DC	f_z									v_c
			4	5	6	8	10	12	16	20	25	
M1	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	110 (92 — 130) *360 (310 — 420)*
M2	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	90 (74 — 100) *295 (250 — 320)*
M3	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	70 (54 — 85) *230 (180 — 270)*
M4	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	50 (40 — 63) *165 (140 — 200)*
M5	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	43 (34 — 53) *140 (120 — 170)*

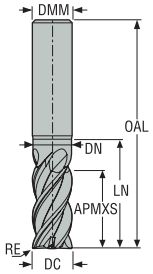
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JHP770

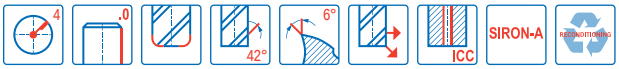
Alte prestazioni – Titanio – Spallamento – 4-5 Eliche – Cilindrico – Raggio di punta – ICC





E

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

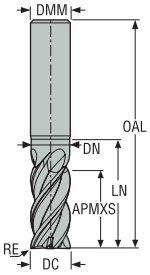


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.0Z4A-SIRA	02760645	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP770080E2R040.0Z4A-SIRA	02760653	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP770080E2R050.0Z4A-SIRA	02823416	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	■
JHP770100E2R040.0Z4A-SIRA	02760654	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP770100E2R050.0Z4A-SIRA	02823417	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	■
JHP770120E2R040.0Z4A-SIRA	02760656	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP770120E2R050.0Z4A-SIRA	02823419	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	■
JHP770120E2R100.0Z4A-SIRA	02823420	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	■
JHP770120E2R250.0Z4A-SIRA	02760659	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	■
JHP770140E2R050.0Z4A-SIRA	02823421	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	■
JHP770160E2R040.0Z4A-SIRA	02760661	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP770160E2R050.0Z4A-SIRA	02823422	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	■
JHP770160E2R080.0Z4A-SIRA	02760662	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP770160E2R100.0Z4A-SIRA	02823423	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	■
JHP770160E2R250.0Z4A-SIRA	02760663	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	■
JHP770160E2R310.0Z4A-SIRA	02760664	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	■
JHP770160E2R400.0Z4A-SIRA	02760665	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	■
JHP770200E2R050.0Z4A-SIRA	02823424	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	■
JHP770200E2R100.0Z4A-SIRA	02823425	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	■
JHP770200E2R250.0Z4A-SIRA	02760668	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	■
JHP770200E2R310.0Z4A-SIRA	02760669	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	■
JHP770200E2R400.0Z4A-SIRA	02760670	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	■

■ Prodotto standard.
Nota: Se il raggio di punta è >15% di DC → a_p=-30%, f_z=-20%
ICC = Canale adduzione refrigerante interna

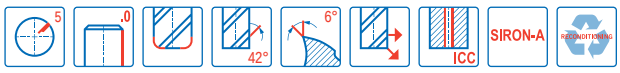
JHP770

Alte prestazioni – Titanio – Spallamento – 4-5 Eliche – Cilindrico – Raggio di punta – ICC



E





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

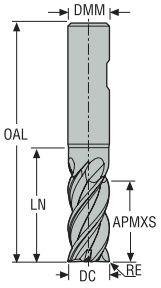
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JHP770160E2R050.0Z5A-SIRA	02810129	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	■
JHP770160E2R100.0Z5A-SIRA	02810130	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	■
JHP770160E2R250.0Z5A-SIRA	02810131	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	■
JHP770160E2R310.0Z5A-SIRA	02810132	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	■
JHP770160E2R400.0Z5A-SIRA	02810133	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	■
JHP770200E2R050.0Z5A-SIRA	02810134	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	■
JHP770200E2R100.0Z5A-SIRA	02810135	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	■
JHP770200E2R250.0Z5A-SIRA	02810136	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	■
JHP770200E2R310.0Z5A-SIRA	02810137	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	■
JHP770200E2R400.0Z5A-SIRA	02810138	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	■
JHP770250E2R050.0Z5A-SIRA	02810139	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	■

■ Prodotto standard.
Nota: Se il raggio di punta è >15% di DC → a_p=-30%, f_z=-20%
ICC = Canale adduzione refrigerante interna

JHP770

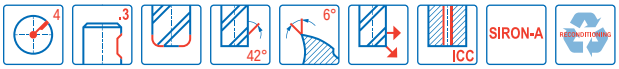
Alte prestazioni – Titanio – Spallamento – 4-5 Eliche – Weldon – Raggio di punta – ICC





E

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

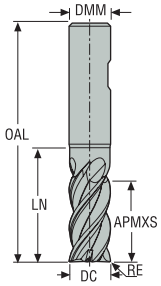


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.3Z4A-SIRA	02760796	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP770080E2R040.3Z4A-SIRA	02760799	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	□
JHP770080E2R050.3Z4A-SIRA	02823428	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	■
JHP770100E2R040.3Z4A-SIRA	02760801	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	□
JHP770100E2R050.3Z4A-SIRA	02823429	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	■
JHP770120E2R040.3Z4A-SIRA	02760803	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	□
JHP770120E2R050.3Z4A-SIRA	02823431	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	■
JHP770120E2R100.3Z4A-SIRA	02823432	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	■
JHP770120E2R250.3Z4A-SIRA	02760805	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	□
JHP770140E2R050.3Z4A-SIRA	02823433	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	■
JHP770160E2R040.3Z4A-SIRA	02760807	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	□
JHP770160E2R050.3Z4A-SIRA	02823434	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	■
JHP770160E2R080.3Z4A-SIRA	02760809	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	□
JHP770160E2R100.3Z4A-SIRA	02823435	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	■
JHP770160E2R250.3Z4A-SIRA	02760810	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	■
JHP770160E2R310.3Z4A-SIRA	02760811	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	□
JHP770160E2R400.3Z4A-SIRA	02760817	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	□
JHP770200E2R050.3Z4A-SIRA	02823436	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	■
JHP770200E2R100.3Z4A-SIRA	02823437	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	■
JHP770200E2R250.3Z4A-SIRA	02760823	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	□
JHP770200E2R310.3Z4A-SIRA	02760824	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	□
JHP770200E2R400.3Z4A-SIRA	02760825	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	□

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.
Nota: Se il raggio di punta è >15% di DC → a_p=-30%, f_z=-20%
ICC = Canale adduzione refrigerante interna

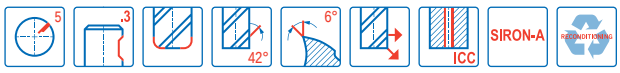
JHP770

Alte prestazioni – Titanio – Spallamento – 4-5 Eliche – Weldon – Raggio di punta – ICC



E





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

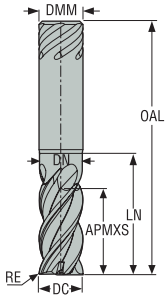
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP770160E2R050.3Z5A-SIRA	02810143	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	■
JHP770160E2R100.3Z5A-SIRA	02810144	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	■
JHP770160E2R250.3Z5A-SIRA	02810145	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	□
JHP770160E2R310.3Z5A-SIRA	02810146	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	■
JHP770160E2R400.3Z5A-SIRA	02810147	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	□
JHP770200E2R050.3Z5A-SIRA	02810148	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	■
JHP770200E2R100.3Z5A-SIRA	02810149	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	■
JHP770200E2R250.3Z5A-SIRA	02810150	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	□
JHP770200E2R310.3Z5A-SIRA	02810151	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	■
JHP770200E2R400.3Z5A-SIRA	02810152	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	■
JHP770250E2R050.3Z5A-SIRA	02810153	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	■
JHP770250E2R100.3Z5A-SIRA	02810154	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	1,0	5	■

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.
Nota: Se il raggio di punta è >15% di DC → a_p=-30%, f_z=-20%
ICC = Canale adduzione refrigerante interna

JHP770

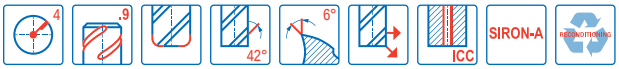
Alte prestazioni – Titanio – Spallamento – 4-5 Eliche – Safelock – Raggio di punta – ICC





E

- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

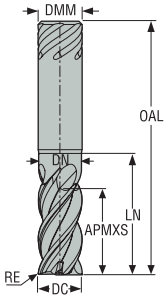


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.9Z4A-SIRA	02927936	2	E	■	6,0	6,0	12,0	60,0	18,0	6,0	0,3	4	☐
JHP770080E2R040.9Z4A-SIRA	02927937	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,4	4	☐
JHP770080E2R050.9Z4A-SIRA	02927938	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,5	4	☐
JHP770100E2R040.9Z4A-SIRA	02927939	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,4	4	☐
JHP770100E2R050.9Z4A-SIRA	02927940	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,5	4	☐
JHP770120E2R040.9Z4A-SIRA	02927943	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,4	4	☐
JHP770120E2R050.9Z4A-SIRA	02927944	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,5	4	☐
JHP770120E2R100.9Z4A-SIRA	02927946	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	1,0	4	☐
JHP770120E2R250.9Z4A-SIRA	02927947	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	2,5	4	☐
JHP770140E2R050.9Z4A-SIRA	02927950	2	E	■	14,0	14,0	28,0	95,0	42,0	13,0	0,5	4	☐
JHP770160E2R040.9Z4A-SIRA	02927948	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,4	4	☐
JHP770160E2R050.9Z4A-SIRA	02927978	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	4	☐
JHP770160E2R080.9Z4A-SIRA	02927951	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,8	4	☐
JHP770160E2R100.9Z4A-SIRA	02927952	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	4	☐
JHP770160E2R250.9Z4A-SIRA	02927954	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	4	☐
JHP770160E2R310.9Z4A-SIRA	02927956	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	4	☐
JHP770160E2R400.9Z4A-SIRA	02927958	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	4,0	4	☐
JHP770200E2R050.9Z4A-SIRA	02927960	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	4	☐
JHP770200E2R100.9Z4A-SIRA	02927962	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	4	☐
JHP770200E2R250.9Z4A-SIRA	02927964	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	4	☐
JHP770200E2R310.9Z4A-SIRA	02927966	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	4	☐
JHP770200E2R400.9Z4A-SIRA	02927968	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	4	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.
Nota: Se il raggio di punta è >15% di DC → a_p=-30%, f_z=-20%

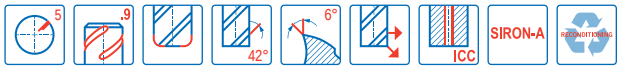
JHP770

Alte prestazioni – Titanio – Spallamento – 4-5 Eliche – Safelock – Raggio di punta – ICC



E





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JHP770160E2R050.9Z5A-SIRA	02927949	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	5	☐
JHP770160E2R100.9Z5A-SIRA	02927953	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	5	☐
JHP770160E2R250.9Z5A-SIRA	02927955	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	5	☐
JHP770160E2R310.9Z5A-SIRA	02927957	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	5	☐
JHP770160E2R400.9Z5A-SIRA	02927959	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	4,0	5	☐
JHP770200E2R050.9Z5A-SIRA	02927961	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	5	☐
JHP770200E2R100.9Z5A-SIRA	02927963	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	5	☐
JHP770200E2R250.9Z5A-SIRA	02927965	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	5	☐
JHP770200E2R310.9Z5A-SIRA	02927967	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	5	☐
JHP770200E2R400.9Z5A-SIRA	02927969	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	5	☐
JHP770250E2R050.9Z5A-SIRA	02927971	2	E	■	25,0	25,0	50,0	130,0	65,0	24,0	0,5	5	☐

☐ Safelock disponibile. Il tempo di consegna è di 6 giorni.
Nota: Se il raggio di punta è >15% di DC → a_p=-30%, f_z=-20%

Parametri di taglio – JHP770 Contornatura

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	14	16	20	25	
S11	E	0.400 *0,400*	1.8 *1,6*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	120 (110 — 130) *395 (370 — 420)*
S12	E	0.400 *0,400*	1.8 *1,6*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	90 (80 — 100) *295 (270 — 320)*
S13	E	0.400 *0,400*	1.8 *1,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	75 (64 — 81) *245 (210 — 260)*

Parametri di taglio – JHP770 Scanalatura

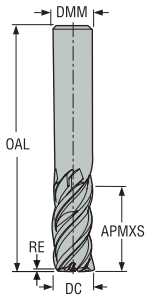
SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S11	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	105 (94 — 120) *345 (310 — 390)*
S12	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	80 (72 — 92) *260 (240 — 300)*
S13	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	65 (56 — 71) *215 (190 — 230)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JHP780

Alte prestazioni – Superlega – Spallamento – 4-Eliche – Cilindrico – Raggio di punta – ICC



D





- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile

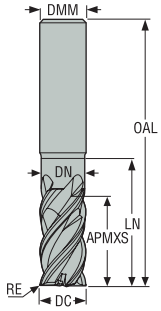
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm		
JHP780060D1R030.0Z4A-M64	03134984	1	D	■	6,0	6,0	7,5	47,0	0,3	4	■
JHP780060D1R080.0Z4A-M64	03134985	1	D	■	6,0	6,0	7,5	47,0	0,8	4	■
JHP780080D1R040.0Z4A-M64	03134986	1	D	■	8,0	8,0	10,0	50,0	0,4	4	■
JHP780080D1R080.0Z4A-M64	03134987	1	D	■	8,0	8,0	10,0	50,0	0,8	4	■
JHP780100D1R040.0Z4A-M64	03134988	1	D	■	10,0	10,0	12,5	57,0	0,4	4	■
JHP780100D1R080.0Z4A-M64	03134989	1	D	■	10,0	10,0	12,5	57,0	0,8	4	■

■ Prodotto standard.

JHP780

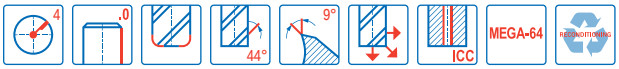
Alte prestazioni – Superlega – Spallamento – 4-Eliche – Cilindrico – Raggio di punta – ICC





E

- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile

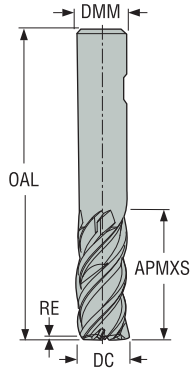


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JHP780060E2R030.0Z4A-M64	03134992	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780060E2R030.0Z4-M64	02760834	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780080E2R040.0Z4A-M64	03134993	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780080E2R040.0Z4-M64	02760842	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780100E2R040.0Z4A-M64	03134994	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R040.0Z4-M64	02760846	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R080.0Z4A-M64	03134995	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780100E2R080.0Z4-M64	02760847	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780120E2R040.0Z4A-M64	03134996	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R040.0Z4-M64	02760848	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R080.0Z4A-M64	03134997	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R080.0Z4-M64	02760849	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R150.0Z4-M64	02760850	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	■
JHP780120E2R250.0Z4-M64	02760851	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	■
JHP780140E2R040.0Z4-M64	02760852	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	■
JHP780160E2R040.0Z4A-M64	03135000	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R040.0Z4-M64	02760853	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R080.0Z4A-M64	03135001	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R080.0Z4-M64	02760861	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R310.0Z4-M64	02760862	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	■
JHP780160E2R400.0Z4-M64	02760863	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	■
JHP780200E2R040.0Z4-M64	02760865	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	■
JHP780200E2R080.0Z4-M64	02760866	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,8	4	■
JHP780200E2R310.0Z4-M64	02760867	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	■
JHP780200E2R400.0Z4-M64	02760868	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	■
JHP780250E2R080.0Z4-M64	02760870	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	■

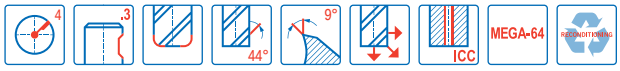
■ Prodotto standard.

JHP780

Alte prestazioni – Superlega – Spallamento – 4-Eliche – Weldon – Raggio di punta – ICC



D





- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile

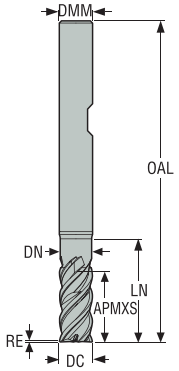
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JHP780060D1R030.3Z4A-M64	03135445	1	D	■	6,0	6,0	7,5	47,0	0,3	4	■
JHP780060D1R080.3Z4A-M64	03135446	1	D	■	6,0	6,0	7,5	47,0	0,8	4	■
JHP780080D1R040.3Z4A-M64	03135447	1	D	■	8,0	8,0	10,0	50,0	0,4	4	■
JHP780080D1R080.3Z4A-M64	03135449	1	D	■	8,0	8,0	10,0	50,0	0,8	4	■
JHP780100D1R040.3Z4A-M64	03135450	1	D	■	10,0	10,0	12,5	57,0	0,4	4	■
JHP780100D1R080.3Z4A-M64	03135451	1	D	■	10,0	10,0	12,5	57,0	0,8	4	■

■ Prodotto standard.

JHP780

Alte prestazioni – Superlega – Spallamento – 4-Eliche – Weldon – Raggio di punta – ICC





E

- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP780060E2R030.3Z4-M64	02760878	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780060E2R030.3Z4A-M64	03135454	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780080E2R040.3Z4-M64	02760879	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780080E2R040.3Z4A-M64	03135455	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780100E2R040.3Z4-M64	02760880	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R040.3Z4A-M64	03135456	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R080.3Z4-M64	02760881	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780100E2R080.3Z4A-M64	03135457	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780120E2R040.3Z4-M64	02760883	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R040.3Z4A-M64	03134998	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R080.3Z4-M64	02760885	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R080.3Z4A-M64	03134999	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R150.3Z4-M64	02760887	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	■
JHP780120E2R250.3Z4-M64	02766989	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	■
JHP780140E2R040.3Z4-M64	02760888	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	■
JHP780160E2R040.3Z4-M64	02760889	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R040.3Z4A-M64	03135002	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R080.3Z4-M64	02760890	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R080.3Z4A-M64	03135003	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R400.3Z4-M64	02760893	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	■
JHP780200E2R040.3Z4-M64	02760894	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	■
JHP780200E2R080.3Z4-M64	02760896	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,8	4	■
JHP780200E2R310.3Z4-M64	02760897	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	■
JHP780200E2R400.3Z4-M64	02760898	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	■
JHP780250E2R080.3Z4-M64	02760901	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	■

■ Prodotto standard.

Parametri di taglio – JHP780 Contornatura

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	14	16	20	25	
S1	E	0.300 *0,300*	1.0 *1,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	50 (45 — 59) *165 (150 — 190)*
S2	E	0.300 *0,300*	1.0 *1,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	42 (36 — 47) *140 (120 — 150)*
S3	E	0.300 *0,300*	0.80 *0,80*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	28 (23 — 33) *90 (76 — 100)*

Parametri di taglio – JHP780 Scanalatura

SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S1	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	43 (38 — 49) *140 (130 — 160)*
S2	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	35 (30 — 40) *115 (99 — 130)*
S3	E	0.60 *0,60*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	26 (21 — 30) *85 (69 — 98)*

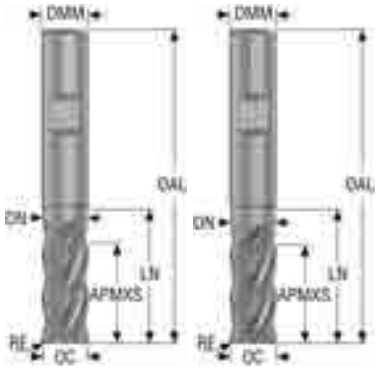
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

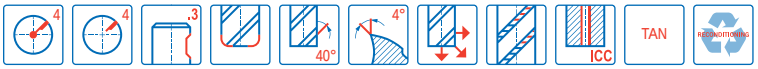
JHP794

Alte prestazioni – ISO-M – Spallamento – 4 Eliche – Weldon – Raggio di punta





E E



- Tolleranze:
- DMM= h6
- DC= h12
- RE= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø8

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
						mm	mm	mm	mm	mm	mm	mm		
JHP794060E2R020.3Z4	TAN	10072338	2	E	–	6,0	6,0	13,0	57,0	18,5	2,0	0,2	4	■
JHP794060E2R020.3Z4A	TAN	10072339	2	E	■	6,0	6,0	13,0	57,0	18,5	5,5	0,2	4	■
JHP794080E2R020.3Z4	TAN	10072340	2	E	–	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	■
JHP794080E2R020.3Z4A	TAN	10072341	2	E	■	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	■
JHP794100E2R035.3Z4	TAN	10072342	2	E	–	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	■
JHP794100E2R035.3Z4A	TAN	10072343	2	E	■	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	■
JHP794120E2R035.3Z4	TAN	10072344	2	E	–	12,0	12,0	26,0	83,0	35,5	11,4	0,35	4	■
JHP794120E2R035.3Z4A	TAN	10072345	2	E	■	12,0	12,0	26,0	92,0	35,5	11,4	0,35	4	■
JHP794160E2R040.3Z4	TAN	10072346	2	E	–	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	■
JHP794160E2R040.3Z4A	TAN	10072347	2	E	■	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	■
JHP794200E2R040.3Z4	TAN	10072348	2	E	–	20,0	20,0	38,0	104,0	51,5	19,0	0,4	4	■
JHP794200E2R040.3Z4A	TAN	10072349	2	E	■	20,0	20,0	38,0	104,0	51,5	19,0	0,4	4	■
JHP794250E2R040.3Z4	TAN	10072350	2	E	–	25,0	25,0	45,0	121,0	62,5	23,8	0,4	4	■
JHP794250E2R040.3Z4A	TAN	10072351	2	E	■	25,0	25,0	45,0	121,0	62,5	23,8	0,4	4	■

■ Prodotto standard.

Parametri di taglio – JHP794 Contornatura

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.3 *1,3*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	90 (61 — 120) *295 (210 — 390)*
M2	E	1.3 *1,3*	0.030 *0,0012*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	75 (50 — 99) *245 (170 — 320)*
M3	E	1.3 *1,3*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	60 (40 — 78) *195 (140 — 250)*
M4	E	1.3 *1,3*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	45 (31 — 60) *150 (110 — 190)*
M5	E	1.3 *1,3*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	38 (26 — 50) *125 (86 — 160)*

Parametri di taglio – JHP794 Scanalatura

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	75 (50 — 99) *245 (170 — 320)*
M2	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	60 (40 — 79) *195 (140 — 250)*
M3	E	0.60 *0,60*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	47 (32 — 62) *155 (110 — 200)*
M4	E	0.60 *0,60*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	36 (24 — 47) *120 (79 — 150)*
M5	E	0.60 *0,60*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	30 (20 — 39) *100 (66 — 120)*

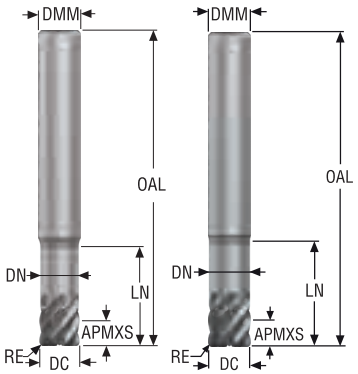
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JCG790

Alte prestazioni – Spallamento – Superlega – 5-6 Eliche – Cilindrico – Raggio di punta







- Tolleranze:
- DMM= h5
- DC= -0,02/-0,1 mm
- RE= ±0,05 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	DN	LN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JCG790060E2R050.0Z5	10010512	2	E	6,0	6,0	6,0	59,0	5,7	15,0	0,5	5	■
JCG790080E2R050.0Z5	10010513	2	E	8,0	8,0	6,0	67,0	7,6	20,0	0,5	5	■
JCG790094G2R100.0Z6	10010514	2	G	9,4	10,0	6,0	75,0	9,0	23,5	1,0	6	■
JCG790100E2R100.0Z6	10010515	2	E	10,0	10,0	6,0	75,0	9,5	25,0	1,0	6	■
JCG790114G2R150.0Z6	10010516	2	G	11,4	12,0	6,0	82,0	10,9	28,5	1,5	6	■
JCG790120E2R150.0Z6	10010517	2	E	12,0	12,0	6,0	82,0	11,4	30,0	1,5	6	■
JCG790160E2R200.0Z6	10010518	2	E	16,0	16,0	8,0	93,0	15,2	40,0	2,0	6	■
JCG790200E2R300.0Z6	10010519	2	E	20,0	20,0	8,0	103,0	19,0	50,0	3,0	6	■
JCG790250E2R400.0Z6	10010520	2	E	25,0	25,0	8,0	108,0	23,8	50,0	4,0	6	■

■ Prodotto standard.

Parametri di taglio – JCG790 Contornatura sgrossatura

SMG		a_e/DC	APMXS	f_z							v_c
				6	8	10	12	16	20	25	
S1	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420 — 1300) *2725 (1400 — 4200)*
S2	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	670 (340 — 1100) *2200 (1200 — 3600)*
S3	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	570 (290 — 950) *1875 (960 — 3100)*

Parametri di taglio – JCG790 Scanalatura

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
S1	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420 — 1300) *2725 (1400 — 4200)*
S2	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	670 (340 — 1100) *2200 (1200 — 3600)*
S3	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	570 (290 — 950) *1875 (960 — 3100)*

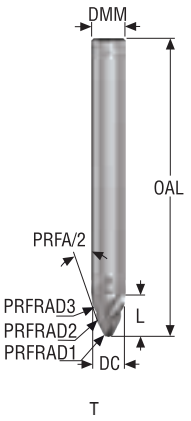
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

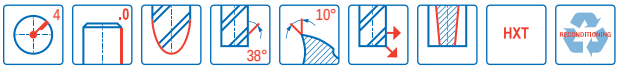
JH724

Alta velocità – ISO– M e ISO– S – Forma conica – 4 Eliche – Cilindrico





T



- Tolleranze:
- DMM=h5
- PRFRAD1= ±0.03 mm
- Tolleranza di forma PRFRAD2= 0.02 mm
- Riaffilatura possibile se PRFRAD è ≥1,5

Codice di ordinazione	Qualità	Codice prodotto	Indice di lung-hezza	Forma utensile	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm			
JH724100T2R2R030.0Z4	HXT	10106106	2	T	10,0	10,0	12,3	89,0	2,0	30,0	5,0	20,0	4	■
JH724100T2R2R050.0Z4	HXT	10106107	2	T	10,0	10,0	12,5	89,0	2,0	50,0	5,0	20,0	4	■
JH724100T2R3R100.0Z4	HXT	10106108	2	T	10,0	10,0	10,7	89,0	3,0	100,0	5,0	20,0	4	■
JH724100T2R3R250.0Z4	HXT	10106109	2	T	10,0	10,0	10,8	89,0	3,0	250,0	5,0	20,0	4	■

■ Prodotto standard.

Parametri di taglio – JH724 Copiatura finitura

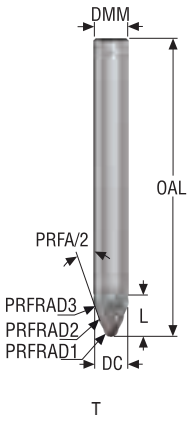
SMG		a_e/DC	f_z	v_c
			10	
P12	E	0,010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310- 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	65 (55 - 75) *215 (180 - 245)*
S11	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310 - 475)*
S12	E	0.010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
S13	E	0.010 *0.010*	0,05 *0.0022*	95 (80 - 100) *310 (260 - 320)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH726

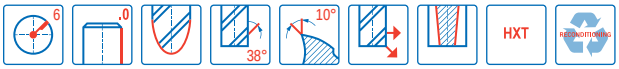
Alta velocità – ISO– M e ISO– S – Forma conica – 6 Eliche – Cilindrico





T

- Tolleranze:
- DMM=h5
- PRFRAD1= ±0.03 mm
- Tolleranza di forma PRFRAD2= 0.02 mm
- Riaffilatura possibile se PRFRAD è ≥1,5



Codice di ordinazione	Qualità	Codice prodotto	Indice di lung-hezza	Forma utensile	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm			
JH726100T2R2R030.0Z6	HXT	10106110	2	T	10,0	10,0	10,8	89,0	2,0	30,0	5,0	20,0	6	■
JH726100T2R2R050.0Z6	HXT	10106111	2	T	10,0	10,0	10,7	89,0	2,0	50,0	5,0	20,0	6	■
JH726100T2R3R100.0Z6	HXT	10106112	2	T	10,0	10,0	12,3	89,0	3,0	100,0	5,0	20,0	6	■
JH726100T2R3R250.0Z6	HXT	10106113	2	T	10,0	10,0	12,5	89,0	3,0	250,0	5,0	20,0	6	■

■ Prodotto standard.

Parametri di taglio – JH726 Copiatura finitura

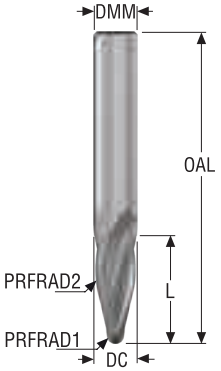
SMG		a_e/DC	f_z	v_c
			10	
P12	E	0,010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310- 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	65 (55 - 75) *215 (180 - 245)*
S11	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310 - 475)*
S12	E	0.010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
S13	E	0.010 *0.010*	0,05 *0.0022*	95 (80 - 100) *310 (260 - 320)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

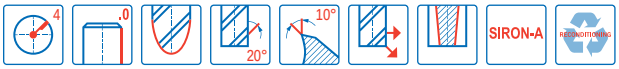
JH734

Alta velocità – ISO– M e ISO– S – Forma a goccia – 4 Eliche – Cilindrico





X



- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm		
JH734060X2R1R95.0Z4	SIRA	10044783	2	X	6,0	6,0	20,8	62,0	1,0	95,0	4	■
JH734080X2R1R90.0Z4	SIRA	10044784	2	X	8,0	8,0	24,5	68,0	1,0	90,0	4	■
JH734100X2R2R85.0Z4	SIRA	10044785	2	X	10,0	10,0	24,7	72,0	2,0	85,0	4	■
JH734120X2R2R80.0Z4	SIRA	10044786	2	X	12,0	12,0	27,3	83,0	2,0	80,0	4	■
JH734160X2R3R75.0Z4	SIRA	10044787	2	X	16,0	16,0	30,1	92,0	3,0	75,0	4	■

■ Prodotto standard.

Parametri di taglio – JH734 Copiatura finitura

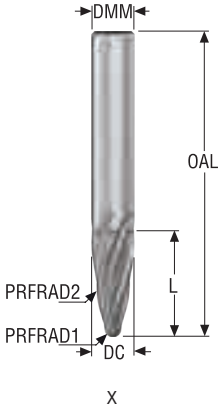
SMG		a_e/DC	f_z					v_c
			6	8	10	12	16	
P8	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

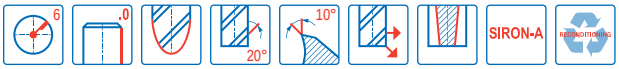
JH736

Alta velocità – ISO– M e ISO– S – Forma a goccia – 6 Eliche – Cilindrico





- Tolleranze:
- DMM= h5
- PRFRAD1= ±0.03mm
- Tolleranza di forma PRFRAD2= 0.02mm
- Riaffilatura possibile



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm		
JH736100X2R2R85.0Z6	SIRA	10044834	2	X	10,0	10,0	24,7	72,0	2,0	85,0	6	■
JH736120X2R2R80.0Z6	SIRA	10044835	2	X	12,0	12,0	27,3	83,0	2,0	80,0	6	■
JH736160X2R3R75.0Z6	SIRA	10044836	2	X	16,0	16,0	30,1	92,0	3,0	75,0	6	■

■ Prodotto standard.

Parametri di taglio – JH736 Copiatura finitura

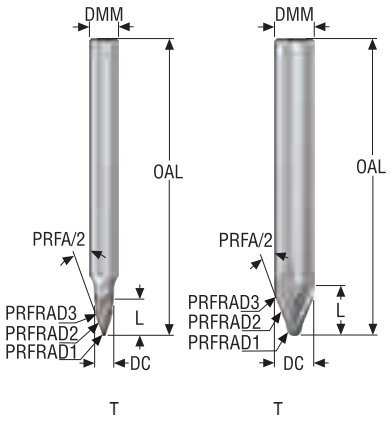
SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

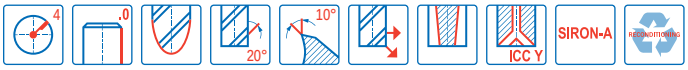
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH744

Alta velocità – ISO– M e ISO– S – Forma conica – 4 Eliche – Cilindrico







- Tolleranze:
- DMM= h5
- PRFRAD1= ±0.03mm
- Tolleranza di forma PRFRAD2= 0.02mm
- Riaffilatura possibile se PRFRAD1 è ≥1,5

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Cilindrico
						mm	mm	mm	mm	mm	mm	mm			
JH744100T1R1.5R250.0Z4	SIRA	10044920	1	T	–	10,0	10,0	5,4	72,0	1,5	250,0	2,0	65,0	4	■
JH744120T1R3R250.0Z4	SIRA	10044921	1	T	–	12,0	12,0	10,5	89,0	3,0	250,0	6,0	32,5	4	■
JH744160T1R4R500.0Z4	SIRA	10044922	1	T	–	16,0	16,0	14,6	108,0	4,0	500,0	8,0	27,5	4	■
JH744040T2R0.5R250.0Z4	SIRA	10044923	2	T	–	4,0	6,0	7,6	62,0	0,5	250,0	3,0	17,5	4	■
JH744060T2R1R250.0Z4	SIRA	10044924	2	T	–	6,0	6,0	9,6	62,0	1,0	250,0	3,0	17,5	4	■
JH744080T2R1.5R250.0Z4	SIRA	10044925	2	T	–	8,0	8,0	10,7	68,0	1,5	250,0	4,0	20,0	4	■
JH744100T2R2R250.0Z4	SIRA	10044926	2	T	–	10,0	10,0	12,7	75,0	2,0	250,0	5,0	20,0	4	■
JH744120T2R3R250.0Z4	SIRA	10044927	2	T	–	12,0	12,0	13,7	89,0	3,0	250,0	6,0	20,0	4	■
JH744160T2R4R500.0Z4	SIRA	10044928	2	T	–	16,0	16,0	17,6	108,0	4,0	500,0	8,0	20,0	4	■
JH744160T2R2R1000.0Z4	SIRA	10044929	2	T	–	16,0	16,0	31,3	108,0	2,0	1000,0	5,0	12,5	4	■
JH744160T2R4R1000.0Z4	SIRA	10044930	2	T	–	16,0	16,0	24,1	108,0	4,0	1000,0	5,0	12,5	4	■
JH744160T4R4R1000.0Z4A	SIRA	10044931	4	T	■	16,0	16,0	24,1	150,0	4,0	1000,0	5,0	12,5	4	■

Parametri di taglio – JH744 Copiatura finitura

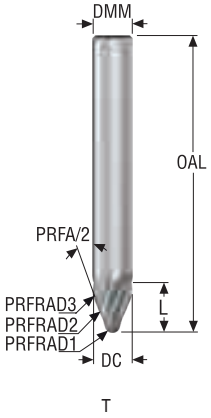
SMG		a_e/DC	f_z						v_c
			4	6	8	10	12	16	
P8	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH746

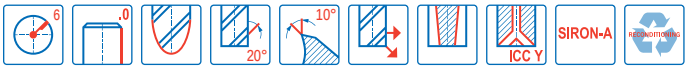
Alta velocità – ISO– M e ISO– S – Forma conica – 6 Eliche – Cilindrico





T

- Tolleranze:
- DMM= h5
- PRFRAD1= ±0.03mm
- Tolleranza di forma PRFRAD2= 0.02mm
- Riaffilatura possibile



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Cilindrico
						mm	mm	mm	mm	mm	mm	mm			
JH746100T2R2R250.0Z6	SIRA	10044958	2	T	–	10,0	10,0	12,7	75,0	2,0	250,0	5,0	20,0	6	■
JH746120T2R3R250.0Z6	SIRA	10044959	2	T	–	12,0	12,0	13,7	89,0	3,0	250,0	6,0	20,0	6	■
JH746160T2R4R500.0Z6	SIRA	10044960	2	T	–	16,0	16,0	17,6	108,0	4,0	500,0	8,0	20,0	6	■
JH746160T4R4R500.0Z6A	SIRA	10044961	4	T	■	16,0	16,0	17,6	150,0	4,0	500,0	8,0	20,0	6	■

■ **Prodotto standard.**

Parametri di taglio – JH746 Copiatura finitura

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JH746 Copiatura sgrossatura

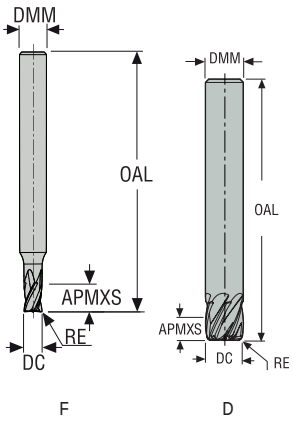
SMG		a_e/DC	f_z			v_c
			10	12	16	
P12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	95 (80 - 100) *310 (270 - 320)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

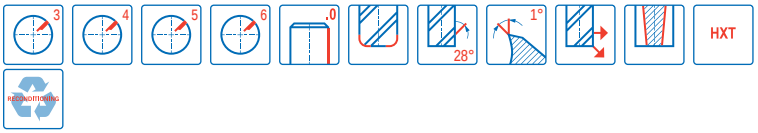
JH770

Alta velocità – CrCo/Titanio – Spallamento – 3-4-5-6 Eliche – Cilindrico – Raggio di punta





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JH770030F2R020.0Z3-HXT	03320783	2	F	3,0	6,0	5,0	58,0	0,2	3	■
JH770040F2R020.0Z4-HXT	03320784	2	F	4,0	6,0	6,0	58,0	0,2	4	■
JH770050F2R020.0Z4-HXT	10000170	2	F	5,0	6,0	7,0	58,0	0,2	4	■
JH770060D2R050.0Z4-HXT	03127351	2	D	6,0	6,0	8,0	50,0	0,5	4	■
JH770080D2R050.0Z4-HXT	03127352	2	D	8,0	8,0	10,0	58,0	0,5	4	■
JH770080D2R050.0Z5-HXT	03127354	2	D	8,0	8,0	10,0	58,0	0,5	5	■
JH770080D2R100.0Z4-HXT	03127353	2	D	8,0	8,0	10,0	58,0	1,0	4	■
JH770080D2R100.0Z5-HXT	03127355	2	D	8,0	8,0	10,0	58,0	1,0	5	■
JH770080D2R100.0Z6-HXT	03127356	2	D	8,0	8,0	10,0	58,0	1,0	6	■
JH770100D2R100.0Z5-HXT	03127357	2	D	10,0	10,0	12,0	66,0	1,0	5	■
JH770100D2R100.0Z6-HXT	03127358	2	D	10,0	10,0	12,0	66,0	1,0	6	■

■ **Prodotto standard.**

Parametri di taglio – JH770 Contornatura sgrossatura PCEDC 3 e 4

SMG		a_e/DC	a_p/DC	f_z				v_c
				3	4	6	8	
S2	E	0.750 *0,750*	0.12 *0,12*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	50 (42 — 62) *165 (140 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.0075 *0,00030*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	65 (53 — 91) *215 (180 — 290)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.0075 *0,00030*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	50 (41 — 70) *165 (140 — 220)*

Parametri di taglio – JH770 Contornatura sgrossatura PCEDC 6

SMG		a_e/DC	a_p/DC	f_z		v_c
				8	10	
S2	E	0.750 *0,750*	0.12 *0,12*	0.050 *0,0020*	0.060 *0,0024*	55 (43 — 64) *180 (150 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	65 (54 — 93) *215 (180 — 300)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	50 (42 — 71) *165 (140 — 230)*

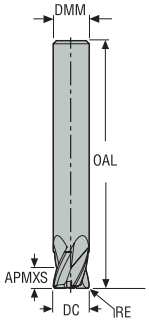
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH740

Alta velocità – CrCo/Titanio – Finitrice torica – 4-5 Eliche – Cilindrico – Raggio di punta





D

- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JH740060D2R025.0Z4-HXT	03127359	2	D	6,0	6,0	6,0	50,0	0,25	4	■
JH740060D2R050.0Z4-HXT	03127360	2	D	6,0	6,0	6,0	50,0	0,5	4	■
JH740080D2R025.0Z4-HXT	03127361	2	D	8,0	8,0	8,0	58,0	0,25	4	■
JH740080D2R050.0Z4-HXT	03127362	2	D	8,0	8,0	8,0	58,0	0,5	4	■
JH740100D2R025.0Z5-HXT	03127363	2	D	10,0	10,0	10,0	66,0	0,25	5	■
JH740100D2R050.0Z5-HXT	03127364	2	D	10,0	10,0	10,0	66,0	0,5	5	■

■ **Prodotto standard.**

Parametri di taglio – JH740 Finitura frontale PCEDC 4

SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	50 (40 — 59) *165 (140 — 190)*
S11	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	65 (52 — 77) *215 (180 — 250)*
S12	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	50 (40 — 59) *165 (140 — 190)*

Parametri di taglio – JH740 Finitura frontale PCEDC 5

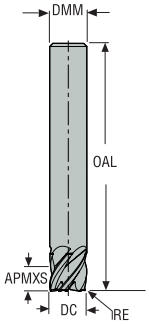
SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130 — 190)*
S11	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	65 (51 — 75) *215 (170 — 240)*
S12	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130 — 190)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH710

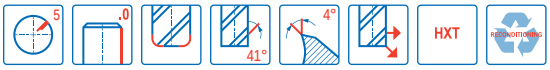
Alta velocità – CrCo/Titanio – Spallamento – 5 Eliche – Cilindrico – Raggio di punta





D

- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JH710060D2R025.0Z5-HXT	03127365	2	D	6,0	6,0	6,0	57,0	0,25	5	■
JH710060D2R050.0Z5-HXT	03127366	2	D	6,0	6,0	6,0	57,0	0,5	5	■
JH710080D2R025.0Z5-HXT	03127367	2	D	8,0	8,0	8,0	63,0	0,25	5	■
JH710080D2R050.0Z5-HXT	03127368	2	D	8,0	8,0	8,0	63,0	0,5	5	■
JH710080D2R100.0Z5-HXT	03127369	2	D	8,0	8,0	8,0	63,0	1,0	5	■

■ **Prodotto standard.**

Parametri di taglio – JH710 Contornatura finitura

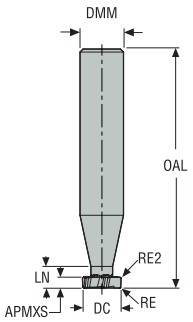
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S1	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S2	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S3	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S11	E	0.00800 *0,00800*	0.65 *0,65*	0.036 *0,0014*	0.046 *0,0018*	180 (160 — 200) *590 (530 — 650)*
S12	E	0.00800 *0,00800*	0.65 *0,65*	0.036 *0,0014*	0.046 *0,0018*	135 (120 — 150) *445 (400 — 490)*
S13	E	0.00800 *0,00800*	0.65 *0,65*	0.032 *0,0013*	0.040 *0,0016*	105 (92 — 120) *345 (310 — 390)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH790

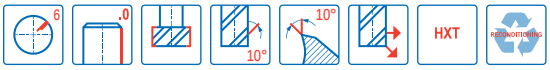
Alta velocità – CrCo/Titanio – Fresa a T – 6 Eliche – Cilindrico





G

- Tolleranze:
- DMM=h5
- DC= ±0,02 mm
- RE= ±0,02 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	RE	RE2	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JH790095G2R025.0Z6-HXT	03127370	2	G	9,5	10,0	2,0	66,0	5,0	0,25	0,25	6	■
JH790095G2R050.0Z6-HXT	03127371	2	G	9,5	10,0	2,0	66,0	5,0	0,5	0,5	6	■
JH790095G3R025.0Z6-HXT	03127372	3	G	9,5	10,0	2,54	66,0	5,0	0,25	0,25	6	■
JH790095G3R050.0Z6-HXT	03127373	3	G	9,5	10,0	2,54	66,0	5,0	0,5	0,5	6	■

■ **Prodotto standard.**

Parametri di taglio – JH790 (T) Contornatura sgrossatura

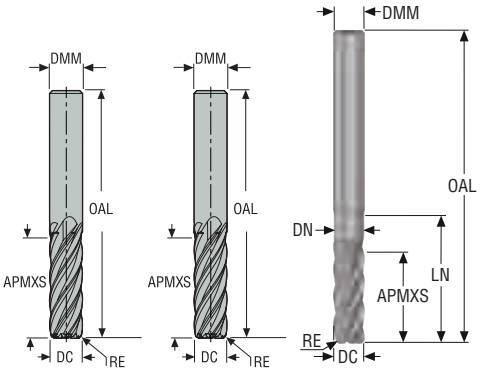
SMG		a_e/DC	a_p/DC	f_z	v_c
				9.5	
S2	E	0.189 *0,189*	0.19 *0,19*	0.030 *0,0012*	39 (31 — 50) *130 (110 — 160)*
S11	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	85 (66 — 100) *280 (220 — 320)*
S12	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	65 (51 — 80) *215 (170 — 260)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH730

Alta velocità – CrCo/Titanio – Spallamento – 5-6-7 Eliche – Cilindrico – Raggio di punta





- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	DN	LN	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JH730060E2R050.0Z5-HXT	10217826	2	E	6,0	6,0	19,0	5,7	25,0	65,0	0,5	5	■
JH730060E2R100.0Z5-HXT	10217827	2	E	6,0	6,0	19,0	5,7	25,0	65,0	1,0	5	■
JH730060E2R150.0Z5-HXT	10217828	2	E	6,0	6,0	19,0	5,7	25,0	65,0	1,5	5	■
JH730075F2R050.0Z6-HXT	10217829	2	F	7,5	8,0	24,0	–	–	63,0	0,5	6	■
JH730075F2R100.0Z6-HXT	10217830	2	F	7,5	8,0	24,0	–	–	63,0	1,0	6	■
JH730075F2R150.0Z6-HXT	10217831	2	F	7,5	8,0	24,0	–	–	63,0	1,5	6	■
JH730080D2R050.0Z6-HXT	03127375	2	D	8,0	8,0	25,0	–	–	63,0	0,5	6	■
JH730080D2R100.0Z6-HXT	03127377	2	D	8,0	8,0	25,0	–	–	63,0	1,0	6	■
JH730080D2R150.0Z6-HXT	03127378	2	D	8,0	8,0	25,0	–	–	63,0	1,5	6	■
JH730080D2R200.0Z6-HXT	03127379	2	D	8,0	8,0	25,0	–	–	63,0	2,0	6	■
JH730100D2R100.0Z7-HXT	03127380	2	D	10,0	10,0	31,0	–	–	72,0	1,0	7	■
JH730100D2R250.0Z7-HXT	03127381	2	D	10,0	10,0	31,0	–	–	72,0	2,5	7	■

■ **Prodotto standard.**

Parametri di taglio – JH730 Contornatura finitura

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	7.5	8	10	
S2	E	0,065 *0.065*	1,3 *1.3*	0,015 *0.00060*	0,019 *0.00075*	0,020 *0.00080*	0,025 *0.0010*	80 (63 — 94) *260 (210 — 300)*
S11	E	0,065 *0.065*	1,3 *1.3*	0,012 *0.00048*	0,015 *0.00060*	0,017 *0.00065*	0,020 *0.00080*	135 (110 — 160) *445 (370 — 520)*
S12	E	0,065 *0.065*	1,3 *1.3*	0,012 *0.00048*	0,015 *0.00060*	0,017 *0.00065*	0,020 *0.00080*	105 (84 — 120) *345 (280 — 390)*

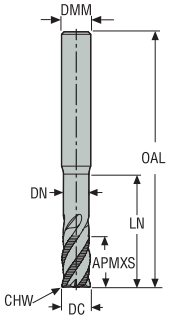
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JHP994

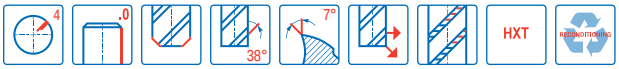
Alte prestazioni – CrCo/Titanio – Spallamento – 4 Eliche – Cilindrico – Smusso





E

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW=0/-0,1 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JHP994060E3C.0Z4-HXT	03127382	3	E	6,0	6,0	14,0	63,0	24,0	5,6	0,2	4	■
JHP994080E3C.0Z4-HXT	03127383	3	E	8,0	8,0	18,0	69,0	32,0	7,4	0,2	4	■
JHP994100E3C.0Z4-HXT	03127384	3	E	10,0	10,0	22,0	88,0	40,0	9,4	0,2	4	■

■ **Prodotto standard.**

Parametri di taglio – JHP994 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z			v_c
				6	8	10	
S2	E	0.0480 *0,0480*	2.0 *2,0*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	55 (40 — 69) *180 (140 — 220)*
S11	E	0.450 *0,450*	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	50 (39 — 77) *165 (130 — 250)*
S12	E	0.450 *0,450*	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	40 (30 — 59) *130 (99 — 190)*

Parametri di taglio – JHP994 Scanalatura

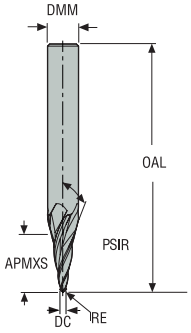
SMG		a_p/DC	f_z			v_c
			6	8	10	
S2	E	2.0 *2,0*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	33 (24 — 41) *110 (79 — 130)*
S11	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	42 (32 — 63) *140 (110 — 200)*
S12	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	33 (25 — 48) *110 (83 — 150)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH780

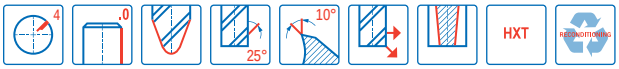
Alta velocità – CrCo/Titanio – Frese sferico-coniche – 4 Eliche – Cilindrico





N

- Tolleranze:
- DMM=h5
- DC= ±0,04 mm
- RE= ±0,01 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PSIR	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm		
JH780018N2R100.0Z4-HXT	03127386	2	N	1,827	8,0	23,5	63,0	1,0	5,1838	4	■
JH780028N2R150.0Z4-HXT	03127387	2	N	2,803	8,0	23,5	63,0	1,5	3,8915	4	■
JH780038N2R200.0Z4-HXT	03127388	2	N	3,823	8,0	23,5	63,0	2,0	2,5972	4	■
JH780049N2R250.0Z4-HXT	03127389	2	N	4,888	8,0	23,5	63,0	2,5	1,3003	4	■

■ **Prodotto standard.**

Parametri di taglio – JH780 Contornatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				1.8	2.8	3.8	4.9	
S2	E	0.0510 *0,0510*	4.2 *4,2*	0.0080 *0,00032*	0.012 *0,00048*	0.017 *0,00065*	0.022 *0,00085*	70 (54 — 86) *230 (180 — 280)*
S12	E	0.0510 *0,0510*	4.2 *4,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.013 *0,00050*	0.016 *0,00065*	95 (76 — 110) *310 (250 — 360)*

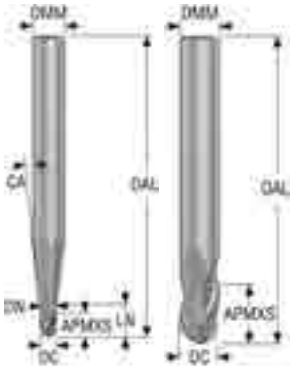
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

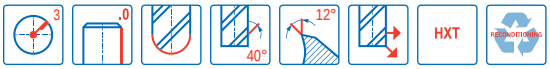
JHB720

Alta velocità – Titanio – A testa sferica – 3 Eliche – Cilindrico





G D



- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm			
JHB720020G2B.0Z3	HXT	10072323	2	G	2,0	6,0	3,0	60,0	6,0	1,9	7,0	3	■
JHB720030G2B.0Z3	HXT	10072324	2	G	3,0	6,0	4,5	60,0	6,5	2,8	5,0	3	■
JHB720035G2B.0Z3	HXT	10072325	2	G	3,5	6,0	5,0	65,0	7,0	3,2	3,5	3	■
JHB720040G2B.0Z3	HXT	10072326	2	G	4,0	6,0	6,0	65,0	8,0	3,7	3,0	3	■
JHB720060D2B.0Z3	HXT	10072327	2	D	6,0	6,0	9,0	75,0	–	–	–	3	■
JHB720080D2B.0Z3	HXT	10072328	2	D	8,0	8,0	12,0	75,0	–	–	–	3	■
JHB720100D2B.0Z3	HXT	10072329	2	D	10,0	10,0	15,0	80,0	–	–	–	3	■
JHB720120D2B.0Z3	HXT	10072330	2	D	12,0	12,0	18,0	90,0	–	–	–	3	■
JHB720160D2B.0Z3	HXT	10072331	2	D	16,0	16,0	24,0	100,0	–	–	–	3	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JHB720 Contornatura

SMG		a_e/DC	a_p/DC	f_z									v_c
				2	3	3.5	4	6	8	10	12	16	
M1	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	85 (62 — 110) *280 (210 — 360)*
M2	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	70 (51 — 90) *230 (170 — 290)*
M3	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	65 (46 — 84) *215 (160 — 270)*
M4	E	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	50 (35 — 65) *165 (120 — 210)*
M5	E	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	42 (29 — 54) *140 (96 — 170)*
N1	E/M/A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	500 (400 — 600) *1650 (1400 — 1900)*
N3	E/M/A	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	335 (270 — 400) *1100 (890 — 1300)*
N11	E/M/A	0.300 *0,300*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	300 (260 — 340) *980 (860 — 1100)*
S1	E	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	43 (29 — 57) *140 (96 — 180)*
S2	E	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	35 (24 — 46) *115 (79 — 150)*
S3	E	0.100 *0,100*	1.2 *1,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	30 (21 — 39) *100 (69 — 120)*
S11	E	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79 — 100) *295 (260 — 320)*
S12	E	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.300 *0,300*	1.2 *1,2*	0.0085 *0,00034*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*
TS1	A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (400 — 600) *1650 (1400 — 1900)*
TP1	M	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (400 — 600) *1650 (1400 — 1900)*

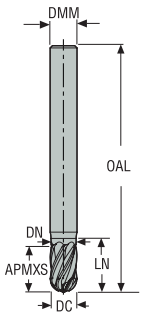
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH721

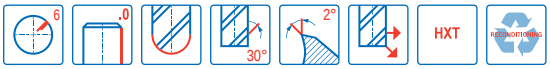
Alta velocità – CrCo/Titanio – A testa sferica – 6 Eliche – Cilindrico





E

- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm		
JH721060E2B.0Z6-HXT	03127390	2	E	6,0	6,0	10,0	57,0	12,0	5,6	6	■
JH721080E2B.0Z6-HXT	03127391	2	E	8,0	8,0	13,0	58,0	16,0	7,4	6	■

■ Prodotto standard.

Parametri di taglio – JH721 Copiatura finitura

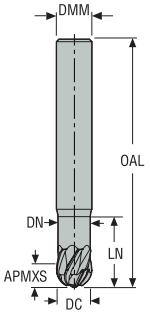
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	120 (110 — 140) *395 (370 — 450)*
S11	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	210 (140 — 230) *690 (460 — 750)*
S12	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	160 (110 — 180) *520 (370 — 590)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH722

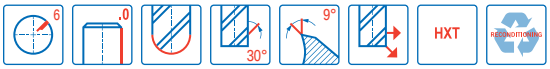
Alta velocità – CrCo/Titanio – A testa sferica – 6 Eliche – Cilindrico





E

- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,01 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm		
JH722100E2B.0Z6-HXT	03127392	2	E	10,0	10,0	10,0	72,0	20,0	9,4	6	■

■ Prodotto standard.

Parametri di taglio – JH722 Copiatura finitura

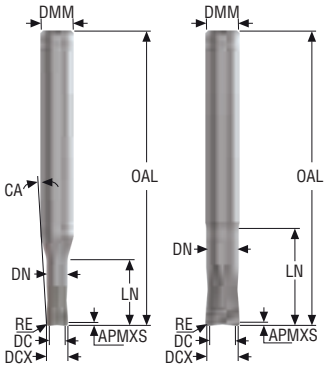
SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.0500 *0,0500*	0.15 *0,15*	0.065 *0,0026*	125 (110 — 150) *410 (370 — 490)*
S11	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	210 (190 — 230) *690 (630 — 750)*
S12	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	160 (150 — 180) *520 (500 — 590)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

SHF712

Elevato avanzamento – ISO– S – 2 Eliche – Cilindrico – Raggio di punta







- Tolleranze:
- Run-out= <0,005 mm
- DMM = h5
- DC G- Forma = 0/-0,01 mm
- DC E- Forma = 0,005/-0,015 mm
- RE = ±0,005 mm

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DCX	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm	mm			
SHF712040G2R050.0Z2	HXT	10106493	2	G	3,0	4,0	6,0	0,5	55,0	12,0	3,8	0,5	3,9 °	2	■
SHF712060E2R050.0Z2	HXT	10106494	2	E	5,0	6,0	6,0	0,5	55,0	18,0	5,7	0,5	0,0 °	2	■
SHF712030G3R050.0Z2	HXT	10106495	3	G	2,0	3,0	6,0	0,5	55,0	12,0	2,85	0,5	5,65 °	2	■
SHF712040G3R050.0Z2	HXT	10106496	3	G	3,0	4,0	6,0	0,5	55,0	16,0	3,8	0,5	3,07 °	2	■
SHF712060E3R050.0Z2	HXT	10106497	3	E	5,0	6,0	6,0	0,5	55,0	25,0	5,7	0,5	0,0 °	2	■
SHF712030G4R050.0Z2	HXT	10106498	4	G	2,0	3,0	6,0	0,5	55,0	16,0	2,85	0,5	4,47 °	2	■

■ Prodotto standard.

Parametri di taglio – SHF712 Contornatura

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3	4	6	
S2	E	0,30 *0.30*	0,050 *0.050*	0,055 *0.0022*	0,075 *0.0030*	0,11 *0.0044*	65 (51 — 76) *215 (170 — 240)*
S12	E	0,30 *0.30*	0,050 *0.050*	0,085 *0.0034*	0,12 *0.0048*	0,17 *0.0065*	170 (150 — 190) *560 (500 — 620)*

Parametri di taglio – SHF712 Scanalatura

SMG		a_p/DCX	f_z			v_c
			3	4	6	
S2	E	0,050 *0.050*	0,046 *0.0018*	0,060 *0.0024*	0,090 *0.0036*	50 (41 — 60) *165 (140 — 190)*
S12	E	0,050 *0.050*	0,046 *0.0018*	0,060 *0.0024*	0,090 *0.0036*	145 (130 — 160) *475 (430 — 520)*

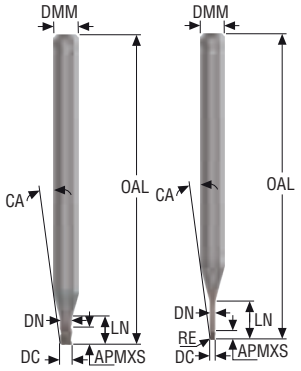
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

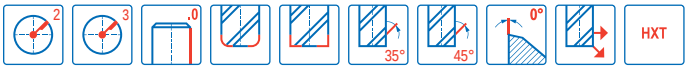
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

SME714/716

Miniaturizzato – ISO– S – Spallamento – 2-3 Eliche – Cilindrico – Spigolo vivo o raggio di punta







- Tolleranze:
- Run-out= <0,005 mm
- DMM = h5
- DC = 0/-0,01 mm
- RE = ±0,005 mm

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	DN	LN	RE	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm			
SME714020G1S.0Z3	HXT	10107349	1	G	2,0	4	2,0	50	1,9	4,0	–	6,86 °	3	■
SME716020G1S.0Z3	HXT	10107360	1	G	2,0	6	2,0	50	1,9	4,0	–	9,42 °	3	■
SME714020G3R010.0Z3	HXT	10107350	3	G	2,0	4	2,5	50	1,9	8,0	0,1	4,68 °	3	■
SME716020G3R010.0Z3	HXT	10107361	3	G	2,0	6	2,5	50	1,9	8,0	0,1	7,14 °	3	■
SME716010G4R010.0Z3	HXT	10107362	4	G	1,0	6	1,2	50	0,95	6,0	0,1	9,03 °	3	■
SME716015G4R010.0Z3	HXT	10107363	4	G	1,5	6	1,8	50	1,4	10,0	0,1	6,79 °	3	■
SME714010G4R010.0Z3	HXT	10107351	4	G	2,0	4	1,2	50	0,95	6,0	0,1	7,13 °	3	■
SME714015G4R010.0Z3	HXT	10107352	4	G	2,0	4	1,8	50	1,4	10,0	0,1	4,72 °	3	■
SME714020G4R010.0Z3	HXT	10107353	4	G	2,0	4	2,5	50	1,9	12,0	0,1	3,53 °	3	■
SME716020G4R010.0Z3	HXT	10107364	4	G	2,0	6	2,5	50	1,9	12,0	0,1	5,72 °	3	■
SME714015G5R010.0Z3	HXT	10107354	5	G	1,5	4	1,8	50	1,4	12,0	0,1	3,38 °	3	■
SME716015G5R010.0Z3	HXT	10107365	5	G	1,5	6	1,8	50	1,4	12,0	0,1	6,15 °	3	■
SME714020G5R010.0Z3	HXT	10107355	5	G	2,0	4	2,5	50	1,9	16,0	0,1	2,83 °	3	■
SME716020G5R010.0Z3	HXT	10107366	5	G	2,0	6	2,5	50	1,9	16,0	0,1	4,77 °	3	■
SME714005G6R005.0Z2	HXT	10107356	6	G	0,5	4	0,6	50	0,45	5,0	0,05	8,31 °	2	■
SME716005G6R005.0Z2	HXT	10107367	6	G	0,5	6	0,6	50	0,45	5,0	0,05	9,93 °	2	■
SME714010G6R010.0Z3	HXT	10107357	6	G	1,0	4	1,2	50	0,95	12,0	0,1	4,77 °	3	■
SME716010G6R010.0Z3	HXT	10107368	6	G	1,0	6	1,6	50	0,95	12,0	0,1	6,56 °	3	■
SME714015G6R010.0Z3	HXT	10107358	6	G	1,5	4	1,8	50	1,4	16,0	0,1	3,38 °	3	■
SME716015G6R010.0Z3	HXT	10107369	6	G	1,5	6	1,8	50	1,4	16,0	0,1	5,16 °	3	■
SME714010G7R010.0Z3	HXT	10107359	7	G	1,0	4	1,2	50	0,95	16,0	0,1	3,9 °	3	■
SME716010G7R010.0Z3	HXT	10107370	7	G	1,0	6	1,2	50	0,95	16,0	0,1	5,55 °	3	■

■ Prodotto standard.

Parametri di taglio – SME714 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				0.5	1	1.5	2	
S2	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	60 (31 — 120) *195 (110 — 390)*
S12	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	65 (33 — 130) *215 (110 — 420)*

Parametri di taglio – SME714 Scanalatura

SMG		a_p/DC	f_z				v_c
			0.5	1	1.5	2	
S2	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	41 (21 — 82) *135 (69 — 260)*
S12	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	45 (23 — 89) *150 (76 — 290)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – SME716 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				0.5	1	1.5	2	
S2	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	60 (31 — 120) *195 (110 — 390)*
S12	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	65 (33 — 130) *215 (110 — 420)*

Parametri di taglio – SME716 Scanalatura

SMG		a_p/DC	f_z				v_c
			0.5	1	1.5	2	
S2	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	41 (21 — 82) *135 (69 — 260)*
S12	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	45 (23 — 89) *150 (76 — 290)*

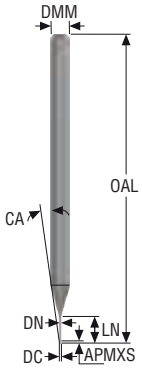
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

SMB713/714/716

Miniaturizzato – ISO– S – A testa sferica – 2 Eliche – Cilindrico





G



- Tolleranze:
- Run-out= <0,005 mm
- DMM = h5
- DC = 0/-0,01 mm
- RE = ±0,005 mm

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	DN	LN	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm			
SMB714020G2B.0Z2	HXT	10109582	2	G	2,0	4	2,0	50	1,9	6,0	6,13 °	2	■
SMB716020G2B.0Z2	HXT	10109596	2	G	2,0	6	2,0	50	1,9	6,0	8,72 °	2	■
SMB714030G2B.0Z2	HXT	10109583	2	G	3,0	4	3,0	50	2,85	9,0	2,85 °	2	■
SMB716030G2B.0Z2	HXT	10109597	2	G	3,0	6	3,0	50	2,85	9,0	6,22 °	2	■
SMB714030G3B.0Z2	HXT	10109584	3	G	3,0	4	3,0	50	2,85	12,0	2,2 °	2	■
SMB716030G3B.0Z2	HXT	10109598	3	G	3,0	6	3,0	50	2,85	12,0	5,11 °	2	■
SMB714015G4B.0Z2	HXT	10109585	4	G	1,5	4	1,5	50	1,4	9,0	5,29 °	2	■
SMB716015G4B.0Z2	HXT	10109599	4	G	1,5	6	1,5	50	1,4	9,0	7,44 °	2	■
SMB714020G4B.0Z2	HXT	10109586	4	G	2,0	4	2,0	50	1,9	10,0	4,3 °	2	■
SMB716020G4B.0Z2	HXT	10109600	4	G	2,0	6	2,0	50	1,9	10,0	6,69 °	2	■
SMB714005G5B.0Z2	HXT	10109587	5	G	0,5	4	0,5	50	0,45	4,0	9,23 °	2	■
SMB716005G5B.0Z2	HXT	10109601	5	G	0,5	6	0,5	50	0,45	4,0	10,73 °	2	■
SMB714010G5B.0Z2	HXT	10109588	5	G	1,0	4	1,0	50	0,95	10,0	5,5 °	2	■
SMB716010G5B.0Z2	HXT	10109602	5	G	1,0	6	1,0	50	0,95	10,0	7,37 °	2	■
SMB714015G5B.0Z2	HXT	10109589	5	G	1,5	4	1,5	50	1,4	12,0	4,41 °	2	■
SMB716015G5B.0Z2	HXT	10109603	5	G	1,5	6	1,5	50	1,4	12,0	6,35 °	2	■
SMB714020G5B.0Z2	HXT	10109590	5	G	2,0	4	2,0	50	1,9	16,0	2,96 °	2	■
SMB716020G5B.0Z2	HXT	10109604	5	G	2,0	6	2,0	50	1,9	16,0	4,96 °	2	■
SMB713003G6B.0Z2	HXT	10109581	6	G	0,3	3	0,3	50	0,28	4,0	8,24 °	2	■
SMB714005G6B.0Z2	HXT	10109591	6	G	0,5	4	0,5	50	0,45	6,0	7,8 °	2	■
SMB716005G6B.0Z2	HXT	10109605	6	G	0,5	6	0,5	50	0,45	6,0	9,46 °	2	■
SMB714010G6B.0Z2	HXT	10109592	6	G	1,0	4	1,0	50	0,95	12,0	4,97 °	2	■
SMB716010G6B.0Z2	HXT	10109606	6	G	1,0	6	1,0	50	0,95	12,0	6,69 °	2	■
SMB714015G6B.0Z2	HXT	10109593	6	G	1,5	4	1,5	50	1,4	16,0	3,49 °	2	■
SMB716015G6B.0Z2	HXT	10109607	6	G	1,5	6	1,5	55	1,4	16,0	5,31 °	2	■
SMB714005G7B.0Z2	HXT	10109594	7	G	0,5	4	0,5	50	0,45	9,0	6,33 °	2	■
SMB716005G7B.0Z2	HXT	10109608	7	G	0,5	6	0,5	50	0,45	9,0	8,03 °	2	■
SMB714010G7B.0Z2	HXT	10109595	7	G	1,0	4	1,0	50	0,95	16,0	3,98 °	2	■
SMB716010G7B.0Z2	HXT	10109609	7	G	1,0	6	1,0	55	0,95	16,0	5,64 °	2	■

■ Prodotto standard.

Parametri di taglio – SMB713 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z	v_c
				0.3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0020 *0.000080*	47 (26 — 64) *155 (86 — 200)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0020 *0.000080*	47 (26 — 64) *155 (86 — 200)*

Parametri di taglio – SMB714 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	1	1.5	2	3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*

Parametri di taglio – SMB716 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	1	1.5	2	3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi



MATERIALI NON FERROSI

Seco offre una gamma completa di frese a spallamento retto in metallo duro integrale ad alte prestazioni, frese a testa sferica e frese integrali per finitura che aumentano la produttività per materiali non ferrosi.

- JS412 e JS413 per tipo con tagliente affilato.
- JS452, JS453, JHP490, JH40, JH421, JM403, JM404, JM406, JH410 e JH440 per tipo con raggio.
- JH450, JH460, SMB413, SMB414, SMB416, JM413 e JM416 per tipo a testa sferica.

Selezione utensile non ferrosi

						
						
Nome		JS412	JS413	JS452	JS453	JHP490
Pag.		338	341	344	349	354
Famiglia		SOLID²	SOLID²	SOLID²	SOLID²	HPM
Tipo di fresa						
Attacco	Cilindrico	■	■	■	■	■
	Weldon	■	■	□	□	■
	Safelock					□
Numero di eliche		2	3	2	3	2-3
Adduz. refrig. interna						■
	Metrico	2-20	2-20	2-20	2-20	10-25
	Pollici					
Lunghezze disponibili		2	2,3	2,3	2,3	2,3,4
Operazione						
						
SMG						
N1		●	●	●	●	●
N2		●	●	●	●	●
N3			●	●	●	●
N11						
TS1		●	●	●	●	
TP1		●	●	●	●	

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

Selezione utensile non ferrosi

					
Nome		JH40	JH421	JH410	JH440
Pag.		358	361	365	367
Famiglia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Tipo di fresa					
Attacco	Cilindrico	■	■	■	■
	Weldon				
	Safelock				
Numero di eliche		2	2-3	1	2
Adduz. refrig. interna			■		
	Metrico	2-20	2-25	2-17	6-8
	Pollici				
Lunghezze disponibili		1,2	2,3	2,3	2
Operazione					
					
SMG					
N1		●	●	●	●
N2					●
N3					●
N11		●	●	●	●
TS1		●	●	●	●
TP1			●		●

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

Selezione utensile non ferrosi

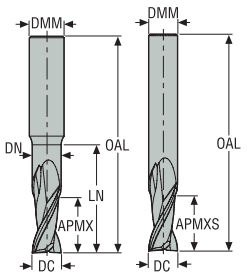
						
Nome		JH450	JH460	SMB413/414/416	JM403/404/406	JM413/416
Pag.		369	371	377	375	377
Famiglia		HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Tipo di fresa						
Attacco	Cilindrico	■	■	■	■	■
	Weldon					
	Safelock					
Numero di eliche		2	2	2	1	2
Adduz. refrig. interna						
	Metrico	2-20	3-12	0,5-2	0,5-2	0,5-2
	Pollici					
Lunghezze disponibili		2,3	2	2,3,5	1,2,5	2,3,5
Operazione						
						
						
SMG						
N1		●	●	●	●	●
N2		●		●	●	●
N3		●		●	●	●
N11		●	●			●
TS1		●	●	●		●
TP1		●	●	●		●

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

JS412

Uso generico – Alluminio – Spallamento – 2 Eliche – Cilindrico – Spigolo vivo





G D

- Tolleranze:
- DMM= h5
- DC= e8
- Riaffilatura possibile se DC è ≥Ø6

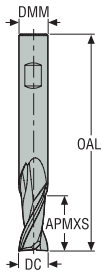


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	DN	LN	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm		
JS412020G2SZ2.0	02881760	2	G	2,0	6,0	4,0	57,0	1,9	7,0	2	■
JS412030G2SZ2.0	02881761	2	G	3,0	6,0	6,0	57,0	2,8	10,0	2	■
JS412040G2SZ2.0	02881762	2	G	4,0	6,0	8,0	57,0	3,8	14,0	2	■
JS412050G2SZ2.0	02881763	2	G	5,0	6,0	10,0	57,0	4,7	17,0	2	■
JS412060D2SZ2.0	02881764	2	D	6,0	6,0	12,0	57,0	–	–	2	■
JS412080D2SZ2.0	02881765	2	D	8,0	8,0	16,0	63,0	–	–	2	■
JS412100D2SZ2.0	02881766	2	D	10,0	10,0	20,0	75,0	–	–	2	■
JS412120D2SZ2.0	02881767	2	D	12,0	12,0	24,0	88,0	–	–	2	■
JS412160D2SZ2.0	02881769	2	D	16,0	16,0	32,0	100,0	–	–	2	■
JS412200D2SZ2.0	02881770	2	D	20,0	20,0	40,0	124,0	–	–	2	■

■ Prodotto standard.

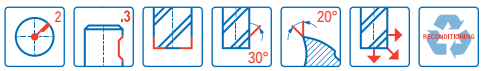
JS412

Uso generico – Alluminio – Spallamento – 2 Eliche – Weldon – Spigolo vivo



D





- Tolleranze:
- DMM= h5
- DC= e8
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
JS412060D2SZ2.3	02881771	2	D	6,0	6,0	12,0	57,0	2	■
JS412080D2SZ2.3	02881772	2	D	8,0	8,0	16,0	63,0	2	■
JS412100D2SZ2.3	02881773	2	D	10,0	10,0	20,0	75,0	2	■
JS412120D2SZ2.3	02881774	2	D	12,0	12,0	24,0	88,0	2	■
JS412160D2SZ2.3	02881776	2	D	16,0	16,0	32,0	100,0	2	■
JS412200D2SZ2.3	02881777	2	D	20,0	20,0	40,0	124,0	2	■

■ Prodotto standard.

Parametri di taglio – JS412 Contornatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	590 (470 — 700) *1925 (1600 — 2200)*
N2	E/M/A	0.300 *0,300*	1.4 *1,4*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	475 (360 — 590) *1550 (1200 — 1900)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	600 (480 — 710) *1975 (1600 — 2300)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	500 (380 — 630) *1650 (1300 — 2000)*

Parametri di taglio – JS412 Scanalatura

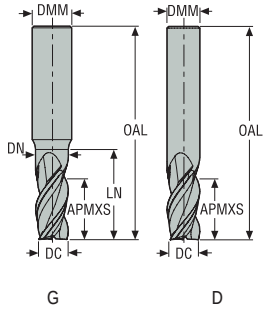
SMG		a_p/DC	f_z									v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100 — 1600)*
TS1	A	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
TP1	A	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	420 (320 — 520) *1375 (1100 — 1700)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

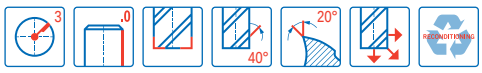
JS413

Uso generico – Alluminio – Spallamento – 3 Eliche – Cilindrico – Spigolo vivo



G D





- Tolleranze:
- DMM= h5
- DC= e8
- Riaffilatura possibile se DC è ≥Ø6

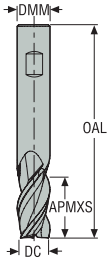
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	DN	LN	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm		
JS413020G2SZ3.0	02881797	2	G	2,0	6,0	4,0	57,0	1,9	7,0	3	■
JS413030G2SZ3.0	02881798	2	G	3,0	6,0	6,0	57,0	2,8	10,0	3	■
JS413040G2SZ3.0	02881799	2	G	4,0	6,0	8,0	57,0	3,8	14,0	3	■
JS413050G2SZ3.0	02881800	2	G	5,0	6,0	10,0	57,0	4,7	17,0	3	■
JS413060D2SZ3.0	02881801	2	D	6,0	6,0	12,0	57,0	–	–	3	■
JS413080D2SZ3.0	02881802	2	D	8,0	8,0	16,0	63,0	–	–	3	■
JS413100D2SZ3.0	02881803	2	D	10,0	10,0	20,0	72,0	–	–	3	■
JS413120D2SZ3.0	02881804	2	D	12,0	12,0	24,0	88,0	–	–	3	■
JS413160D2SZ3.0	02881806	2	D	16,0	16,0	32,0	100,0	–	–	3	■
JS413200D2SZ3.0	02881807	2	D	20,0	20,0	40,0	124,0	–	–	3	■
JS413060D3SZ3.0	02881815	3	D	6,0	6,0	24,0	70,0	–	–	3	■
JS413080D3SZ3.0	02881816	3	D	8,0	8,0	32,0	85,0	–	–	3	■
JS413100D3SZ3.0	02881817	3	D	10,0	10,0	40,0	100,0	–	–	3	■
JS413120D3SZ3.0	02881818	3	D	12,0	12,0	50,0	115,0	–	–	3	■
JS413160D3SZ3.0	02881820	3	D	16,0	16,0	55,0	125,0	–	–	3	■
JS413200D3SZ3.0	02881821	3	D	20,0	20,0	75,0	150,0	–	–	3	■

■ Prodotto standard.

JS413

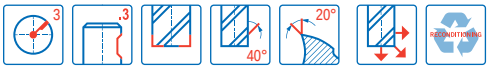
Uso generico – Alluminio – Spallamento – 3 Eliche – Weldon – Spigolo vivo





D

- Tolleranze:
- DMM= h5
- DC= e8
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
JS413060D2SZ3.3	02881808	2	D	6,0	6,0	12,0	57,0	3	■
JS413080D2SZ3.3	02881809	2	D	8,0	8,0	16,0	63,0	3	■
JS413100D2SZ3.3	02881810	2	D	10,0	10,0	20,0	72,0	3	■
JS413120D2SZ3.3	02881811	2	D	12,0	12,0	24,0	88,0	3	■
JS413160D2SZ3.3	02881813	2	D	16,0	16,0	32,0	100,0	3	■
JS413200D2SZ3.3	02881814	2	D	20,0	20,0	40,0	124,0	3	■
JS413060D3SZ3.3	02881955	3	D	6,0	6,0	24,0	70,0	3	□
JS413080D3SZ3.3	02881956	3	D	8,0	8,0	32,0	85,0	3	□
JS413100D3SZ3.3	02881957	3	D	10,0	10,0	40,0	100,0	3	□
JS413120D3SZ3.3	02881958	3	D	12,0	12,0	50,0	115,0	3	□
JS413160D3SZ3.3	02881960	3	D	16,0	16,0	55,0	125,0	3	□
JS413200D3SZ3.3	02881961	3	D	20,0	20,0	75,0	150,0	3	□

. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

Parametri di taglio – JS413 Contornatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	600 (480 — 710) *1975 (1600 — 2300)*
N2	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	470 (360 — 580) *1550 (1200 — 1900)*
N3	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	315 (240 — 390) *1025 (790 — 1200)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	610 (500 — 730) *2000 (1700 — 2300)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	330 (250 — 410) *1075 (830 — 1300)*

Parametri di taglio – JS413 Scanalatura

SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (400 — 600) *1650 (1400 — 1900)*
N2	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	400 (300 — 490) *1300 (990 — 1600)*
N3	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	265 (200 — 330) *870 (660 — 1000)*
TS1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.19 *0,0075*	500 (400 — 600) *1650 (1400 — 1900)*
TP1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.19 *0,0075*	270 (210 — 330) *890 (690 — 1000)*

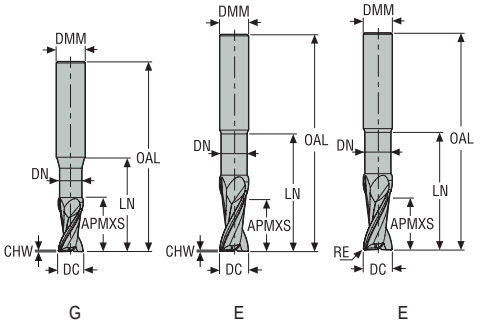
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS452

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta o smusso





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02
- CHW= +0,04 mm
- Riaffilatura possibile se DC è ≥Ø6

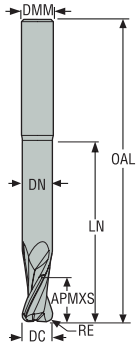


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm		
JS452020G2CZ2.0-HEMI	02881848	2	G	2,0	6,0	4,0	57,0	8,0	1,9	0,1	–	2	■
JS452030G2CZ2.0-HEMI	02881849	2	G	3,0	6,0	6,0	57,0	10,0	2,8	0,1	–	2	■
JS452040G2CZ2.0-HEMI	02881850	2	G	4,0	6,0	8,0	57,0	14,0	3,8	0,1	–	2	■
JS452050G2CZ2.0-HEMI	02881851	2	G	5,0	6,0	8,0	57,0	17,0	4,7	0,1	–	2	■
JS452060E2CZ2.0-HEMI	02881852	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	–	2	■
JS452060E2R050Z2.0-HEMI	02881853	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	0,5	2	■
JS452060E2R100Z2.0-HEMI	02881854	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	1,0	2	■
JS452080E2CZ2.0-HEMI	02881778	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	–	2	■
JS452080E2R050Z2.0-HEMI	02881855	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	0,5	2	■
JS452080E2R100Z2.0-HEMI	02881779	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	1,0	2	■
JS452100E2CZ2.0-HEMI	02881856	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,1	–	2	■
JS452100E2R050Z2.0-HEMI	02881857	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	0,5	2	■
JS452100E2R100Z2.0-HEMI	02881858	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	1,0	2	■
JS452120E2CZ2.0-HEMI	02881859	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	–	2	■
JS452120E2R050Z2.0-HEMI	02881860	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	0,5	2	■
JS452120E2R100Z2.0-HEMI	02881861	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	1,0	2	■
JS452120E2R200Z2.0-HEMI	02881780	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	2,0	2	■
JS452140E2CZ2.0-HEMI	02881862	2	E	14,0	14,0	28,0	88,0	41,0	13,3	0,1	–	2	■
JS452160E2CZ2.0-HEMI	02881863	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	–	2	■
JS452160E2R050Z2.0-HEMI	02881864	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	0,5	2	■
JS452160E2R100Z2.0-HEMI	02881782	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	2	■
JS452160E2R200Z2.0-HEMI	02881783	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	2	■
JS452200E2CZ2.0-HEMI	02881865	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	2	■
JS452200E2R050Z2.0-HEMI	02881866	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	2	■
JS452200E2R100Z2.0-HEMI	02881768	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	2	■

■ Prodotto standard.

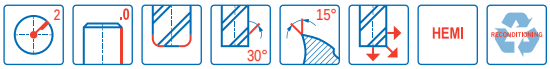
JS452

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta



E





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile

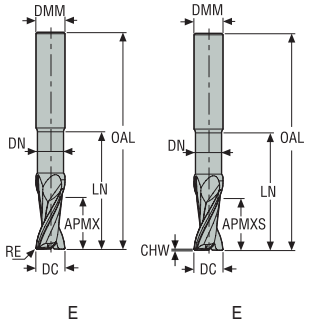
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
JS452080E3R020.0Z2-HEMI	03003413	3	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	■
JS452100E3R050.0Z2-HEMI	03003415	3	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	■
JS452120E3R050.0Z2-HEMI	03003419	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	■
JS452160E3R050.0Z2-HEMI	03003426	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	■
JS452200E3R050.0Z2-HEMI	03003433	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	■

■ Prodotto standard.

JS452

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Weldon – Raggio di punta o smusso





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02
- CHW= +0,04 mm
- Riaffilatura possibile

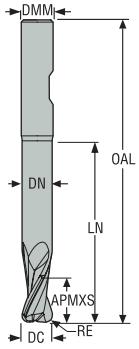


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JS452060E2CZ2.3-HEMI	02881867	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	–	2	☐
JS452060E2R050Z2.3-HEMI	02881868	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	0,5	2	☐
JS452060E2R100Z2.3-HEMI	02881869	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	1,0	2	☐
JS452080E2CZ2.3-HEMI	02881947	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	–	2	☐
JS452080E2R050Z2.3-HEMI	02881870	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	0,5	2	☐
JS452080E2R100Z2.3-HEMI	02922247	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	1,0	2	☐
JS452100E2CZ2.3-HEMI	02881871	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,1	–	2	☐
JS452100E2R050Z2.3-HEMI	02881872	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	0,5	2	☐
JS452100E2R100Z2.3-HEMI	02881873	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	1,0	2	☐
JS452120E2CZ2.3-HEMI	02881874	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	–	2	☐
JS452120E2R050Z2.3-HEMI	02881875	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	0,5	2	☐
JS452120E2R100Z2.3-HEMI	02881876	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	1,0	2	☐
JS452120E2R200Z2.3-HEMI	02881948	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	2,0	2	☐
JS452140E2CZ2.3-HEMI	02881877	2	E	14,0	14,0	28,0	88,0	41,0	13,3	0,1	–	2	☐
JS452160E2CZ2.3-HEMI	02881878	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	–	2	☐
JS452160E2R050Z2.3-HEMI	02881879	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	0,5	2	☐
JS452160E2R100Z2.3-HEMI	02881949	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	2	☐
JS452160E2R200Z2.3-HEMI	02881950	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	2	☐
JS452200E2CZ2.3-HEMI	02881880	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	2	☐
JS452200E2R050Z2.3-HEMI	02881881	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	2	☐
JS452200E2R100Z2.3-HEMI	02881953	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	2	☐

☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

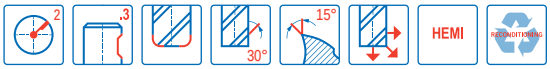
JS452

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Weldon – Raggio di punta



E





- Tolleranze:
- DMM= h5
- DC= e7
- RE= ±0,02
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS452080E3R020.3Z2-HEMI	03003447	3	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	☐
JS452100E3R050.3Z2-HEMI	03003449	3	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	☐
JS452120E3R050.3Z2-HEMI	03003453	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	☐
JS452160E3R050.3Z2-HEMI	03003460	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	☐
JS452200E3R050.3Z2-HEMI	03003467	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	☐

☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

Parametri di taglio – JS452 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 670) *1825 (1500 — 2100)*
N2	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	485 (370 — 600) *1600 (1300 — 1900)*
N3	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	325 (250 — 400) *1075 (830 — 1300)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 670) *1825 (1500 — 2100)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	450 (340 — 560) *1475 (1200 — 1800)*

Parametri di taglio – JS452 Scanalatura

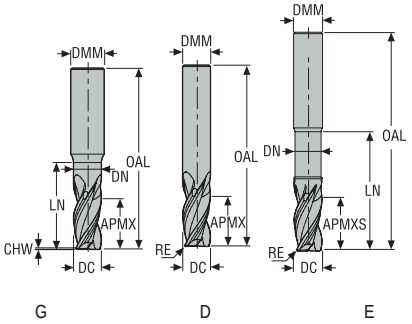
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100 — 1600)*
N3	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	265 (210 — 330) *870 (690 — 1000)*
TS1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
TP1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	400 (310 — 500) *1300 (1100 — 1600)*

Nota: Se il raggio di punta è >15% di DC quindi a_p= -30%, f_z= -20%
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JS453

Alte prestazioni – Alluminio – Spallamento – 3 Eliche – Cilindrico – Raggio di punta o smusso







- Tolleranze:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Riaffilatura possibile se DC è ≥Ø6

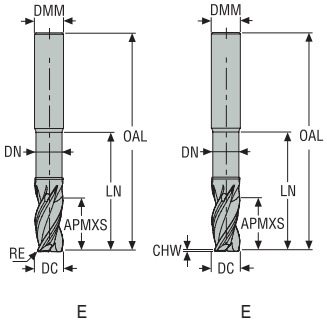
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453020G2CZ3.0-HEMI	02881896	2	G	2,0	6,0	4,0	57,0	7,0	1,9	0,1	–	3	■
JS453030G2CZ3.0-HEMI	02881897	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,1	–	3	■
JS453040G2CZ3.0-HEMI	02881898	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,1	–	3	■
JS453050G2CZ3.0-HEMI	02881899	2	G	5,0	6,0	10,0	57,0	14,0	4,75	0,1	–	3	■
JS453060D2CZ3.0-HEMI	02881900	2	D	6,0	6,0	12,0	57,0	–	–	0,1	–	3	■
JS453060D2R050Z3.0-HEMI	02881901	2	D	6,0	6,0	12,0	57,0	–	–	–	0,5	3	■
JS453080D2CZ3.0-HEMI	02881812	2	D	8,0	8,0	16,0	63,0	–	–	0,1	–	3	■
JS453080D2R050Z3.0-HEMI	02881902	2	D	8,0	8,0	16,0	63,0	–	–	–	0,5	3	■
JS453100D2CZ3.0-HEMI	02881903	2	D	10,0	10,0	20,0	72,0	–	–	0,1	–	3	■
JS453100D2R050Z3.0-HEMI	02881904	2	D	10,0	10,0	20,0	72,0	–	–	–	0,5	3	■
JS453120D2CZ3.0-HEMI	02881905	2	D	12,0	12,0	24,0	88,0	–	–	0,1	–	3	■
JS453120D2R050Z3.0-HEMI	02881906	2	D	12,0	12,0	24,0	88,0	–	–	–	0,5	3	■
JS453120E2R300.0Z3-HEMI	02905280	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	3,0	3	■
JS453140D2CZ3.0-HEMI	02881907	2	D	14,0	14,0	28,0	88,0	–	–	0,1	–	3	■
JS453160D2CZ3.0-HEMI	02881908	2	D	16,0	16,0	32,0	100,0	–	–	0,1	–	3	■
JS453160D2R050Z3.0-HEMI	02881909	2	D	16,0	16,0	32,0	100,0	–	–	–	0,5	3	■
JS453160E2R100.0Z3-HEMI	02905281	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	3	■
JS453160E2R200.0Z3-HEMI	02905282	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	3	■
JS453160E2R250.0Z3-HEMI	02905283	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,5	3	■
JS453160E2R300.0Z3-HEMI	02905284	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	3,0	3	■
JS453160E2R400.0Z3-HEMI	02905285	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	4,0	3	■
JS453200E2C.0Z3-HEMI	02905286	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	3	■
JS453200E2R050.0Z3-HEMI	02905287	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	3	■
JS453200E2R100.0Z3-HEMI	02905288	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	3	■
JS453200E2R200.0Z3-HEMI	02905289	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	2,0	3	■
JS453200E2R300.0Z3-HEMI	02905291	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	3,0	3	■

■ Prodotto standard.

JS453

Alte prestazioni – Alluminio – Spallamento – 3 Eliche – Cilindrico – Raggio di punta o smusso





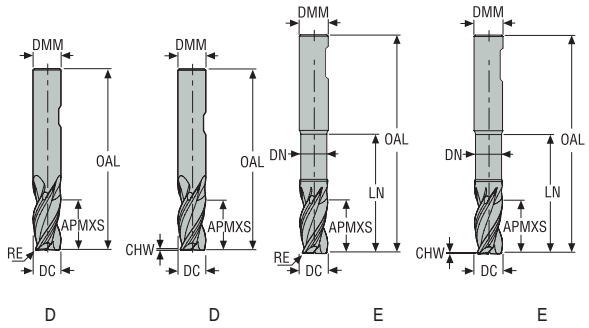
- Tolleranze:
- DMM= h5
- DC = e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Riaffilatura possibile



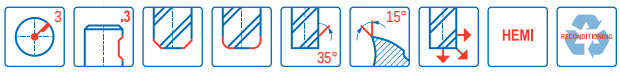
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453120E3R300.0Z3-HEMI	02905294	3	E	12,0	12,0	24,0	110,0	54,0	11,4	–	3,0	3	■
JS453160E3R100.0Z3-HEMI	02905295	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	1,0	3	■
JS453160E3R200.0Z3-HEMI	02905296	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	2,0	3	■
JS453160E3R300.0Z3-HEMI	02905298	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	3,0	3	■
JS453160E3R400.0Z3-HEMI	02905299	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	4,0	3	■
JS453200E3C.0Z3-HEMI	02905300	3	E	20,0	20,0	36,0	150,0	90,0	19,0	0,1	–	3	■
JS453200E3R050.0Z3-HEMI	02905301	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	0,5	3	■
JS453200E3R100.0Z3-HEMI	02905302	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	1,0	3	■
JS453200E3R200.0Z3-HEMI	02905303	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	2,0	3	■
JS453200E3R300.0Z3-HEMI	02905305	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	3,0	3	■

JS453

Alte prestazioni – Alluminio – Spallamento – 3 Eliche – Weldon – Raggio di punta o smusso







- Tolleranze:
- DMM=h5
- DC=e7
- RE=±0,02 mm
- CHW= ±0,02 mm
- Riaffilatura possibile

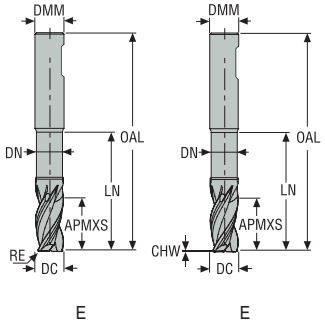
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453060D2CZ3.3-HEMI	02881910	2	D	6,0	6,0	12,0	57,0	–	–	0,1	–	3	☐
JS453060D2R050Z3.3-HEMI	02881911	2	D	6,0	6,0	12,0	57,0	–	–	–	0,5	3	☐
JS453080D2CZ3.3-HEMI	02881964	2	D	8,0	8,0	16,0	63,0	–	–	0,1	–	3	☐
JS453080D2R050Z3.3-HEMI	02881954	2	D	8,0	8,0	16,0	63,0	–	–	–	0,5	3	☐
JS453100D2CZ3.3-HEMI	02881913	2	D	10,0	10,0	20,0	72,0	–	–	0,1	–	3	☐
JS453100D2R050Z3.3-HEMI	02881914	2	D	10,0	10,0	20,0	72,0	–	–	–	0,5	3	☐
JS453120D2CZ3.3-HEMI	02881915	2	D	12,0	12,0	24,0	88,0	–	–	0,1	–	3	☐
JS453120D2R050Z3.3-HEMI	02881916	2	D	12,0	12,0	24,0	88,0	–	–	–	0,5	3	☐
JS453120E2R300.3Z3-HEMI	02905308	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	3,0	3	☐
JS453140D2CZ3.3-HEMI	02881917	2	D	14,0	14,0	28,0	88,0	–	–	0,1	–	3	☐
JS453160D2CZ3.3-HEMI	02881918	2	D	16,0	16,0	32,0	100,0	–	–	0,1	–	3	☐
JS453160D2R050Z3.3-HEMI	02881919	2	D	16,0	16,0	32,0	100,0	–	–	–	0,5	3	☐
JS453160E2R100.3Z3-HEMI	02905309	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	3	☐
JS453160E2R200.3Z3-HEMI	02905310	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	3	☐
JS453160E2R250.3Z3-HEMI	02905311	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,5	3	☐
JS453160E2R300.3Z3-HEMI	02905312	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	3,0	3	☐
JS453160E2R400.3Z3-HEMI	02905313	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	4,0	3	☐
JS453200E2C.3Z3-HEMI	02905314	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	3	☐
JS453200E2R050.3Z3-HEMI	02905315	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	3	☐
JS453200E2R100.3Z3-HEMI	02905316	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	3	☐
JS453200E2R200.3Z3-HEMI	02905317	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	2,0	3	☐
JS453200E2R300.3Z3-HEMI	02905319	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	3,0	3	☐

☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

JS453

Alte prestazioni – Alluminio – Spallamento – 3 Eliche – Weldon – Raggio di punta o smusso





- Tolleranze:
- DMM= h5
- DC = e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453120E3R300.3Z3-HEMI	02905322	3	E	12,0	12,0	24,0	110,0	54,0	11,4	–	3,0	3	☐
JS453160E3R100.3Z3-HEMI	02905323	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	1,0	3	☐
JS453160E3R200.3Z3-HEMI	02905324	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	2,0	3	☐
JS453160E3R300.3Z3-HEMI	02905326	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	3,0	3	☐
JS453160E3R400.3Z3-HEMI	02905327	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	4,0	3	☐
JS453200E3C.3Z3-HEMI	02905328	3	E	20,0	20,0	36,0	150,0	90,0	19,0	0,1	–	3	☐
JS453200E3R050.3Z3-HEMI	02905329	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	0,5	3	☐
JS453200E3R100.3Z3-HEMI	02905330	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	1,0	3	☐
JS453200E3R200.3Z3-HEMI	02905331	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	2,0	3	☐
JS453200E3R300.3Z3-HEMI	02905333	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	3,0	3	☐

☐ Weldon disponibile. Il tempo di consegna è di 3 giorni.

Parametri di taglio – JS453 Contornatura

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 660) *1825 (1500 — 2100)*
N2	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	480 (370 — 600) *1575 (1300 — 1900)*
N3	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	320 (250 — 400) *1050 (830 — 1300)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 660) *1825 (1500 — 2100)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	445 (340 — 550) *1450 (1200 — 1800)*

Parametri di taglio – JS453 Scanalatura

SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	400 (300 — 490) *1300 (990 — 1600)*
N3	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	265 (200 — 330) *870 (660 — 1000)*
TS1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
TP1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	400 (300 — 500) *1300 (990 — 1600)*

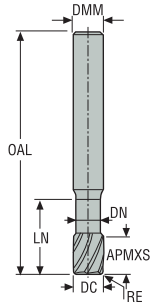
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JHP490

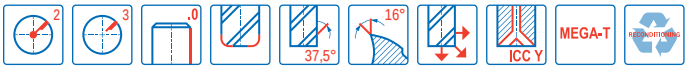
Alte prestazioni – Alluminio – Spallamento – 2-3 Eliche – Cilindrico – Raggio di punta – ICC





E

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Riaffilatura possibile

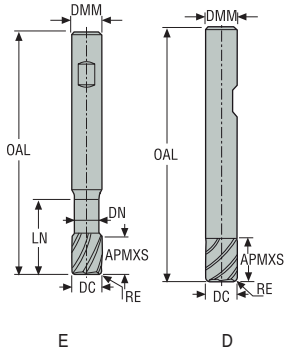


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
490V100R050Z2.0A-MEGA-T	02623870	2	E	■	10,0	10,0	12,0	65,0	20,0	9,0	0,5	2	■
490V120R200Z2.0A-MEGA-T	02623883	2	E	■	12,0	12,0	14,0	75,0	24,0	11,0	2,0	2	■
490V160R050Z3.0A-MEGA-T	02623889	2	E	■	16,0	16,0	18,0	85,0	32,0	14,5	0,5	3	■
490V200R050Z3.0A-MEGA-T	02623908	2	E	■	20,0	20,0	22,0	100,0	40,0	18,0	0,5	3	■
490V250R050Z3.0A-MEGA-T	02623926	2	E	■	25,0	25,0	27,0	125,0	50,0	23,0	0,5	3	■
490VL100R100Z2.0A-MEGA-T	02623876	3	E	■	10,0	10,0	22,0	85,0	42,0	9,0	1,0	2	■
490VL120R050Z3.0A-MEGA-T	02623880	3	E	■	12,0	12,0	14,0	95,0	40,0	11,0	0,5	3	■
490VL120R100Z2.0A-MEGA-T	02623886	3	E	■	12,0	12,0	26,0	95,0	50,0	11,0	1,0	2	■
490VL160R050Z3.0A-MEGA-T	02623891	3	E	■	16,0	16,0	18,0	95,0	45,0	14,5	0,5	3	■
490VL200R200Z3.0A-MEGA-T	02623916	3	E	■	20,0	20,0	42,0	125,0	65,0	18,0	2,0	3	■
490VXL250R050Z3.0A-MEGA-T	02623927	4	E	■	25,0	25,0	50,0	125,0	75,0	23,0	0,5	3	■

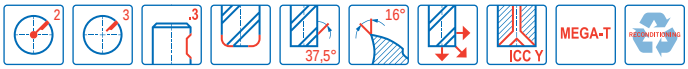
■ Prodotto standard.
ICC = Canale adduzione refrigerante interna

JHP490

Alte prestazioni – Alluminio – Spallamento – 2-3 Eliche – Weldon – Raggio di punta – ICC







- Tolleranze:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Riaffilatura possibile

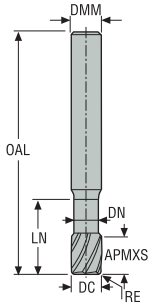
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
490V120R200Z2.0A-MEGA-TW	02669371	2	E	■	12,0	12,0	14,0	75,0	24,0	11,0	2,0	2	□
490V160R050Z3A-MEGA-T	02623888	2	E	■	16,0	16,0	18,0	85,0	32,0	14,5	0,5	3	■
490160R200Z3A-MEGA-T	02623898	2	D	■	16,0	16,0	34,0	95,0	–	–	2,0	3	■
490V200R050Z3A-MEGA-T	02623907	2	E	■	20,0	20,0	22,0	100,0	40,0	18,0	0,5	3	■
490V250R050Z3A-MEGA-T	02623925	2	E	■	25,0	25,0	27,0	125,0	50,0	23,0	0,5	3	■
490VL100R100Z2.0A-MEGA-TW	02669368	3	E	■	10,0	10,0	22,0	85,0	42,0	9,0	1,0	2	□
490VL120R050Z3.0A-MEGA-TW	02669374	3	E	■	12,0	12,0	14,0	95,0	40,0	11,0	0,5	3	□
490VL120R100Z2.0A-MEGA-TW	02669375	3	E	■	12,0	12,0	26,0	95,0	50,0	11,0	1,0	2	□
490VL160R050Z3.0A-MEGA-TW	02669382	3	E	■	16,0	16,0	18,0	95,0	45,0	14,5	0,5	3	□
490VL200R200Z3.0A-MEGA-TW	02669388	3	E	■	20,0	20,0	42,0	125,0	65,0	18,0	2,0	3	□
490VXL250R050Z3.0A-MEGA-TW	02669397	4	E	■	25,0	25,0	50,0	125,0	75,0	23,0	0,5	3	□

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.
ICC = Canale adduzione refrigerante interna

JHP490

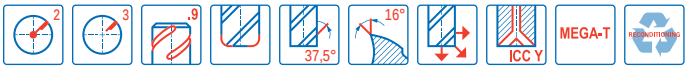
Alte prestazioni – Alluminio – Spallamento – 2-3 Eliche – Safelock – Raggio di punta – ICC





E

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
490V100R050Z2.9A-MEGA-T	02927984	2	E	■	10,0	10,0	12,0	65,0	20,0	9,0	0,5	2	☐
490V120R200Z2.9A-MEGA-T	02927988	2	E	■	12,0	12,0	14,0	75,0	24,0	11,0	2,0	2	☐
490V160R050Z3.9A-MEGA-T	02927990	2	E	■	16,0	16,0	18,0	85,0	32,0	14,0	0,5	3	☐
490V200R050Z3.9A-MEGA-T	02927992	2	E	■	20,0	20,0	22,0	100,0	40,0	18,0	0,5	3	☐
490V250R050Z3.9A-MEGA-T	02927993	2	E	■	25,0	25,0	27,0	125,0	50,0	23,0	0,5	3	☐
490VL100R100Z2.9A-MEGA-T	02927994	3	E	■	10,0	10,0	22,0	85,0	42,0	9,0	1,0	2	☐
490VL120R050Z3.9A-MEGA-T	02927995	3	E	■	12,0	12,0	14,0	95,0	40,0	11,0	0,5	3	☐
490VL120R100Z2.9A-MEGA-T	02927996	3	E	■	12,0	12,0	26,0	95,0	50,0	11,0	1,0	2	☐
490VL160R050Z3.9A-MEGA-T	02927997	3	E	■	16,0	16,0	18,0	95,0	32,0	14,0	0,5	3	☐
490VL200R200Z3.9A-MEGA-T	02927998	3	E	■	20,0	20,0	42,0	125,0	65,0	18,0	2,0	3	☐
490VXL250R050Z3.9A-MEGA-T	02927999	4	E	■	25,0	25,0	50,0	125,0	75,0	23,0	0,5	3	☐

☐ Safelock disponibile. Soggetto a modifiche, fare riferimento al listino prezzi corrente.
ICC = Canale adduzione refrigerante interna

Parametri di taglio – JHP490 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
N1	E/M/A	0.500 *0,500*	1.1 *1,0*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	0.38 *0,015*	700 (550 — 860) *2325 (1900 — 2800)*
N2	E/M/A	0.500 *0,500*	1.1 *1,0*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	0.38 *0,015*	455 (350 — 550) *1500 (1200 — 1800)*
N3	E/M/A	0.500 *0,500*	1.1 *1,0*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	0.38 *0,015*	540 (440 — 650) *1775 (1500 — 2100)*

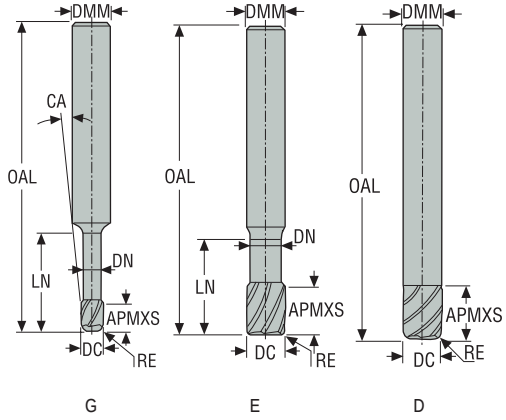
Parametri di taglio – JHP490 Scanalatura

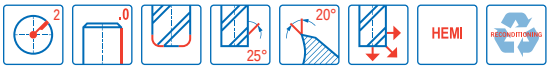
SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
N1	E/M/A	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.38 *0,015*	650 (500 — 790) *2125 (1700 — 2500)*
N2	E/M/A	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.38 *0,015*	420 (330 — 510) *1375 (1100 — 1600)*
N3	E/M/A	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.38 *0,015*	500 (400 — 590) *1650 (1400 — 1900)*

JH40

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta







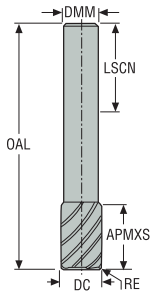
- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,1 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
40K060-HEMI	00022089	1	D	6,0	6,0	13,0	50,0	–	–	0,1	–	2	■
40K080-HEMI	00022090	1	D	8,0	8,0	13,0	50,0	–	–	0,1	–	2	■
40K100-HEMI	00022091	1	D	10,0	10,0	16,0	50,0	–	–	0,1	–	2	■
40K120-HEMI	00022092	1	D	12,0	12,0	16,0	65,0	–	–	0,1	–	2	■
40020-HEMI	00022093	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,1	3,5	2	■
40030-HEMI	00022094	2	E	3,0	3,0	4,0	40,0	8,0	2,9	0,1	–	2	■
40040-HEMI	00022095	2	E	4,0	4,0	5,0	50,0	12,0	3,8	0,1	–	2	■
40050-HEMI	00022120	2	E	5,0	5,0	8,0	50,0	14,0	4,8	0,1	–	2	■
40060-HEMI	00022250	2	E	6,0	6,0	8,0	65,0	18,0	5,7	0,1	–	2	■
40080-HEMI	00022580	2	E	8,0	8,0	10,0	70,0	22,0	7,7	0,1	–	2	■
40100-HEMI	00022663	2	E	10,0	10,0	14,0	80,0	28,0	9,7	0,1	–	2	■
40120-HEMI	00022667	2	E	12,0	12,0	16,0	90,0	35,0	11,5	0,1	–	2	■
40160-HEMI	00022668	2	E	16,0	16,0	20,0	90,0	40,0	15,5	0,1	–	2	■
40200-HEMI	00022701	2	E	20,0	20,0	25,0	100,0	50,0	19,5	0,1	–	2	■

■ Prodotto standard.

JH40

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta



P





- Tolleranze:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,1 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LSCN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm		
40020-RS	02479642	2	P	2,0	1,9	3,0	40,0	28,0	0,1	2	■
40030-RS	02479643	2	P	3,0	2,9	4,0	60,0	28,0	0,1	2	■
40040-RS	02479644	2	P	4,0	3,8	5,0	60,0	28,0	0,1	2	■
40050-RS	02479645	2	P	5,0	4,8	8,0	70,0	28,0	0,1	2	■
40060-RS	02479646	2	P	6,0	5,8	8,0	65,0	36,0	0,1	2	■
40080-RS	02479647	2	P	8,0	7,8	10,0	70,0	36,0	0,1	2	■
40100-RS	02479648	2	P	10,0	9,7	14,0	100,0	40,0	0,1	2	■
40120-RS	02479649	2	P	12,0	11,7	16,0	90,0	45,0	0,1	2	■
40L060-RS	02479650	3	P	6,0	5,8	8,0	100,0	36,0	0,1	2	■
40L080-RS	02479651	3	P	8,0	7,8	10,0	100,0	36,0	0,1	2	■
40L120-RS	02479652	3	P	12,0	11,7	16,0	125,0	45,0	0,1	2	■
40L160-RS	02479653	3	P	16,0	15,7	20,0	125,0	48,0	0,1	2	■
40L200-RS	02479654	3	P	20,0	19,7	25,0	125,0	50,0	0,1	2	■

■ Prodotto standard.

Parametri di taglio – JH40 Contornatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.2 *1,2*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	730 (610 — 840) *2400 (2100 — 2700)*
N11	E/M/A	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	425 (320 — 520) *1400 (1100 — 1700)*
TS1	A	0.400 *0,400*	1.2 *1,2*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	730 (610 — 840) *2400 (2100 — 2700)*

Parametri di taglio – JH40 Scanalatura

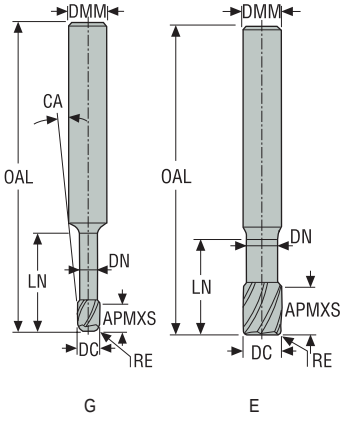
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.60 *0,60*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.25 *0,010*	600 (510 — 700) *1975 (1700 — 2200)*
N11	E/M/A	0.40 *0,40*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100 — 1600)*
TS1	A	1.0 *1,0*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.25 *0,010*	600 (510 — 700) *1975 (1700 — 2200)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

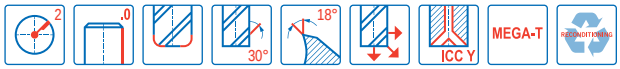
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH421

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta – ICC







- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø6

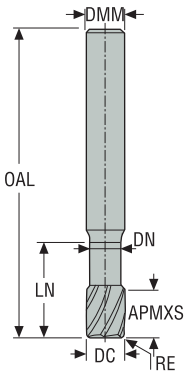
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm			
421020R020Z2-MEGA-T	02434927	2	G	–	2,0	3,0	3,0	40,0	8,0	1,8	0,2	3,0	2	■
421030R020Z2-MEGA-T	02434939	2	E	–	3,0	3,0	4,0	40,0	12,0	2,7	0,2	–	2	■
421040R020Z2-MEGA-T	02434940	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,2	3,0	2	■
421040R030Z2-MEGA-T	02434941	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,3	3,0	2	■
421050R100Z2-MEGA-T	02434942	2	G	–	5,0	6,0	6,0	50,0	18,0	4,5	1,0	1,5	2	■
421060R025Z2-MEGA-T	02434946	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,25	–	2	■
421060R050Z2-MEGA-T	02434947	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,5	–	2	■
421060R100Z2-MEGA-T	02434958	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	1,0	–	2	■
421080R030Z2-MEGA-T	02434960	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,3	–	2	■
421080R060Z2-MEGA-T	02434964	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,6	–	2	■
421080R100Z2-MEGA-T	02434967	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	1,0	–	2	■
421100R030Z2-MEGA-T	02434968	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,3	–	2	■
421100R080Z2-MEGA-T	02434970	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,8	–	2	■
421100R150Z2-MEGA-T	02434971	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	1,5	–	2	■
421100R250Z2-MEGA-T	02438614	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	2,5	–	2	■
421100R310Z2-MEGA-T	02438683	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	3,1	–	2	■
421120R030Z2-MEGA-T	02434983	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,3	–	2	■
421120R050Z2-MEGA-T	02434986	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,5	–	2	■
421120R100Z2-MEGA-T	02434988	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,0	–	2	■
421120R150Z2-MEGA-T	02434989	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,5	–	2	■
421120R200Z2-MEGA-T	02434990	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,0	–	2	■
421120R250Z2AMEGA-T	02435008	2	E	■	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	■
421120R250Z2-MEGA-T	02435007	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	■
421120R310Z2-MEGA-T	02435009	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	3,1	–	2	■

■ Prodotto standard.
ICC = Canale adduzione refrigerante interna

JH421

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta – ICC





E

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Riaffilatura possibile

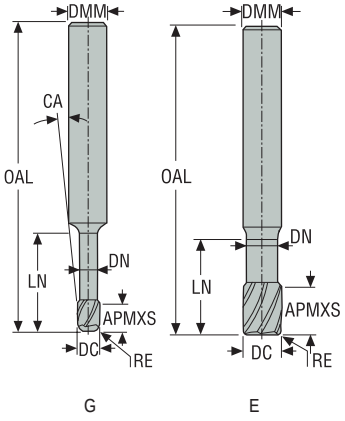


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
421160R050Z2-MEGA-T	02435010	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	0,5	2	■
421160R200Z2-MEGA-T	02435014	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,0	2	■
421160R250Z2AMEGA-T	02435020	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	■
421160R250Z2-MEGA-T	02435012	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	■
421160R310Z2-MEGA-T	02435036	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	3,1	2	■
421160R400Z2AMEGA-T	02438684	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	■
421160R400Z2-MEGA-T	02435039	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	■
421200R160Z2-MEGA-T	02435042	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	1,6	2	■
421200R200Z2-MEGA-T	02435044	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,0	2	■
421200R250Z2AMEGA-T	02438685	2	E	■	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	■
421200R250Z2-MEGA-T	02435046	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	■
421200R310Z2-MEGA-T	02435049	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	3,1	2	■
421200R400Z2-MEGA-T	02435051	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	4,0	2	■
421200R500Z2-MEGA-T	02435055	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	5,0	2	■

■ Prodotto standard.
ICC = Canale adduzione refrigerante interna

JH421

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta – ICC







- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm			
421L080R020Z2-MEGA-T	02435068	3	E	–	8,0	8,0	6,0	75,0	40,0	7,2	0,2	–	2	■
421L100R050Z2-MEGA-T	02435070	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	0,5	–	2	■
421L100R250Z2-MEGA-T	02435074	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	2,5	–	2	■
421L100R310Z2-MEGA-T	02438690	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	3,1	–	2	■
421L120R050Z2-MEGA-T	02435340	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	0,5	–	2	■
421L120R100Z2-MEGA-T	02435343	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	1,0	–	2	■
421L120R200Z2-MEGA-T	02435373	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,0	–	2	■
421L120R250Z2-MEGA-T	02435374	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,5	–	2	■
421L120R310Z2-MEGA-T	02438692	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	3,1	–	2	■
421L160R050Z2-MEGA-T	02435375	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	0,5	–	2	■
421L160R100Z2-MEGA-T	02435380	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	1,0	–	2	■
421L160R200Z2-MEGA-T	02435381	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,0	–	2	■
421L160R250Z2AMEGA-T	02435383	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	2,5	–	2	■
421L160R250Z2-MEGA-T	02435382	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,5	–	2	■
421L160R310Z2-MEGA-T	02435384	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	3,1	–	2	■
421L160R400Z2AMEGA-T	02435386	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	4,0	–	2	■
421L200R050Z2-MEGA-T	02435387	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	0,5	–	2	■
421L200R200Z2-MEGA-T	02435391	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	2,0	–	2	■
421L200R310Z2-MEGA-T	02435398	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	3,1	–	2	■
421L200R500Z2-MEGA-T	02435401	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	5,0	–	2	■

■ Prodotto standard.
ICC = Canale adduzione refrigerante interna

Parametri di taglio – JH421 Contornatura

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.400	1.0	0.030	0.044	0.060	0.075	0.090	0.12	0.15	0.18	0.20	0.22	0.25	0.28	620 (520 — 720)
		0,400	*1,0*	*0,0012*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0048*	*0,0060*	*0,0070*	*0,0080*	*0,0085*	*0,010*	*0,011*	*2025 (1800 — 2300)*
N11	E/M/A	0.400	1.0	0.020	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.13	0.15	0.17	0.19	410 (310 — 510)
		0,400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*0,0075*	*1350 (1100 — 1600)*
TS1	A	0.400	1.0	0.030	0.044	0.060	0.075	0.090	0.12	0.15	0.18	0.20	0.22	0.25	0.28	620 (520 — 720)
		0,400	*1,0*	*0,0012*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0048*	*0,0060*	*0,0070*	*0,0080*	*0,0085*	*0,010*	*0,011*	*2025 (1800 — 2300)*
TP1	M	0.400	1.0	0.024	0.036	0.048	0.060	0.070	0.095	0.12	0.14	0.16	0.18	0.20	0.24	410 (310 — 500)
		0,400	*1,0*	*0,00095*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0055*	*0,0065*	*0,0070*	*0,0080*	*0,0095*	*1350 (1100 — 1600)*

Parametri di taglio – JH421 Scanalatura

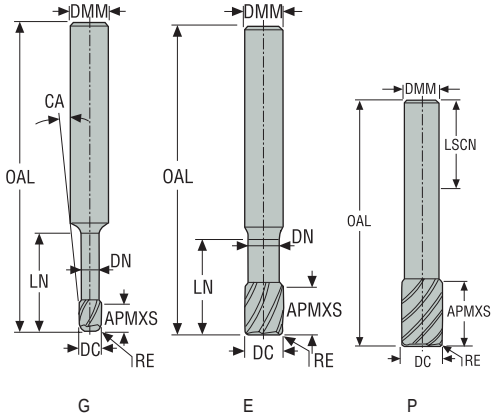
SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.50	0.014	0.022	0.028	0.036	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.18	610 (510 — 700)
		0,50	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0070*	*2000 (1700 — 2200)*
N11	E/M/A	0.50	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.080	0.10	405 (310 — 500)
		0,50	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0032*	*0,0040*	*1325 (1100 — 1600)*
TS1	A	0.50	0.014	0.022	0.028	0.036	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.18	610 (510 — 700)
		0,50	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0070*	*2000 (1700 — 2200)*
TP1	M	0.50	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	405 (310 — 500)
		0,50	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*1325 (1100 — 1600)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

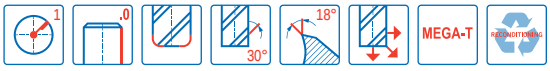
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH410

Alte prestazioni – Alluminio – Spallamento – 1 Elica – Cilindrico – Raggio di punta







- Tolleranze:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	LSCN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm			
410020R050-MEGA-T	02451548	2	G	2,0	6,0	3,0	50,0	6,0	36,0	1,7	0,5	12,0	1	■
410030R050-MEGA-T	02451578	2	G	3,0	6,0	4,0	50,0	8,0	36,0	2,7	0,5	7,5	1	■
410ML030R050-MEGA-T	02451580	2	G	3,0	6,0	4,0	60,0	15,0	36,0	2,7	0,5	5,0	1	■
410040R050-MEGA-T	02451581	2	G	4,0	6,0	5,0	60,0	8,0	36,0	3,6	0,5	5,5	1	■
410ML040R050-MEGA-T	02451585	2	G	4,0	6,0	5,0	60,0	15,0	36,0	3,6	0,5	3,5	1	■
410050R050-MEGA-T	02451586	2	G	5,0	6,0	7,0	65,0	11,0	36,0	4,5	0,5	2,5	1	■
410ML050R050-MEGA-T	02451589	2	G	5,0	6,0	7,0	65,0	18,0	36,0	4,5	0,5	1,5	1	■
410TL050R050-MEGA-T	02451587	2	G	5,0	6,0	7,0	65,0	26,0	36,0	4,5	0,5	1,5	1	■
410060R050-MEGA-T	02451591	2	E	6,0	6,0	8,0	70,0	11,0	36,0	5,3	0,5	–	1	■
410ML060R050-MEGA-T	02451593	2	E	6,0	6,0	8,0	70,0	18,0	36,0	5,3	0,5	–	1	■
410TL060R050-MEGA-T	02451592	2	E	6,0	6,0	8,0	70,0	31,0	36,0	5,3	0,5	–	1	■
410070RSR050-MEGA-T	02451594	2	P	7,0	6,0	9,0	65,0	–	36,0	–	0,5	–	1	■
410090RSR050-MEGA-T	02451596	2	P	9,0	8,0	11,0	65,0	–	36,0	–	0,5	–	1	■
410110RSR050-MEGA-T	02451598	2	P	11,0	10,0	13,0	70,0	–	40,0	–	0,5	–	1	■
410130RSR100-MEGA-T	02451600	2	P	13,0	12,0	15,0	70,0	–	45,0	–	1,0	–	1	■
410150RSR100-MEGA-T	02451603	2	P	15,0	14,0	17,0	80,0	–	45,0	–	1,0	–	1	■
410170RSR100-MEGA-T	02451605	2	P	17,0	16,0	19,0	80,0	–	48,0	–	1,0	–	1	■
410L070RSR200-MEGA-T	02451595	3	P	7,0	6,0	9,0	85,0	–	36,0	–	2,0	–	1	■
410L090RSR200-MEGA-T	02451597	3	P	9,0	8,0	11,0	85,0	–	36,0	–	2,0	–	1	■
410L110RSR200-MEGA-T	02451599	3	P	11,0	10,0	13,0	90,0	–	40,0	–	2,0	–	1	■
410L130RSR200-MEGA-T	02451601	3	P	13,0	12,0	15,0	90,0	–	45,0	–	2,0	–	1	■
410L150RSR200-MEGA-T	02451604	3	P	15,0	14,0	17,0	110,0	–	45,0	–	2,0	–	1	■
410L170RSR200-MEGA-T	02451606	3	P	17,0	16,0	19,0	110,0	–	48,0	–	2,0	–	1	■

■ Prodotto standard.

Parametri di taglio – JH410 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	7	9	11	13	15	17	
N1	E/M/A	0.410 *0,410*	1.0 *1,0*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	0.32 *0,013*	0.40 *0,016*	0.46 *0,018*	0.50 *0,020*	0.55 *0,022*	710 (600 — 820) *2325 (2000 — 2600)*
N11	E/M/A	0.318 *0,318*	0.65 *0,65*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	495 (380 — 610) *1625 (1300 — 2000)*
TS1	A	0.410 *0,410*	1.0 *1,0*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	0.32 *0,013*	0.40 *0,016*	0.46 *0,018*	0.50 *0,020*	0.55 *0,022*	710 (600 — 820) *2325 (2000 — 2600)*

Parametri di taglio – JH410 Scanalatura

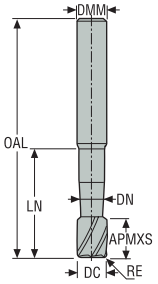
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	7	9	11	13	15	17	
N1	E/M/A	0.75 *0,75*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	0.25 *0,010*	0.30 *0,012*	0.36 *0,014*	0.40 *0,016*	0.46 *0,018*	630 (530 — 730) *2075 (1800 — 2300)*
N11	E/M/A	0.36 *0,36*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	420 (320 — 520) *1375 (1100 — 1700)*
TS1	A	1.0 *1,0*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	0.25 *0,010*	0.30 *0,012*	0.36 *0,014*	0.40 *0,016*	0.46 *0,018*	630 (530 — 730) *2075 (1800 — 2300)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

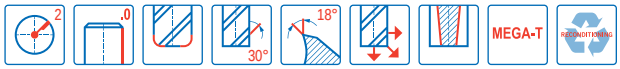
JH440

Alta velocità – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta



E





- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
440060-MEGA-T	00022702	2	E	6,0	6,0	8,0	60,0	30,0	5,4	1,5	2	■
440080-MEGA-T	00022865	2	E	8,0	8,0	10,0	60,0	30,0	7,2	2,0	2	■

Parametri di taglio – JH440 Copiatura sgrossatura

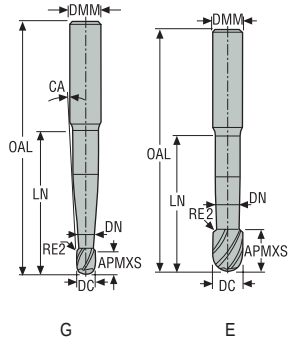
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
N1	E/M/A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
N2	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	510 (390 — 640) *1675 (1300 — 2000)*
N3	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	340 (260 — 420) *1125 (860 — 1300)*
N11	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	255 (130 — 370) *840 (430 — 1200)*
TS1	A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
TP1	A	0.300 *0,300*	0.60 *0,60*	0.060 *0,0024*	0.080 *0,0032*	510 (380 — 630) *1675 (1300 — 2000)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH450

Alta velocità – Alluminio – A testa sferica – 2 Eliche – Cilindrico







- Tolleranze:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE2	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
450020-MEGA-T	00022977	2	G	2,0	3,0	1,75	40,0	10,0	1,8	1,0	3,0	2	■
450030-MEGA-T	00022978	2	E	3,0	3,0	2,5	40,0	12,0	2,7	2,0	–	2	■
450040-MEGA-T	00022979	2	G	4,0	6,0	3,5	50,0	21,0	3,6	2,0	3,0	2	■
450050-MEGA-T	00022980	2	G	5,0	6,0	4,5	50,0	22,5	4,5	2,0	2,0	2	■
450060-MEGA-T	00023020	2	E	6,0	6,0	5,5	55,0	25,0	5,4	2,0	–	2	■
450080-MEGA-T	00023032	2	E	8,0	8,0	7,0	65,0	30,0	7,2	2,0	–	2	■
450100-MEGA-T	00023040	2	E	10,0	10,0	8,5	75,0	35,0	9,0	3,0	–	2	■
450120-MEGA-T	00029842	2	E	12,0	12,0	10,5	75,0	40,0	11,0	3,0	–	2	■
450160-MEGA-T	00023050	2	E	16,0	16,0	14,0	90,0	50,0	14,5	4,0	–	2	■
450200-MEGA-T	00023053	2	E	20,0	20,0	17,0	100,0	50,0	18,0	4,0	–	2	■
450L100-MEGA-T	00023056	3	G	10,0	12,0	8,5	125,0	50,0	9,0	3,0	1,5	2	■
450L120-MEGA-T	00023091	3	E	12,0	12,0	10,5	150,0	60,0	11,0	3,0	–	2	■
450L160-MEGA-T	00023095	3	E	16,0	16,0	14,0	150,0	70,0	14,5	4,0	–	2	■

■ Prodotto standard.

Parametri di taglio – JH450 Copiatura sgrossatura

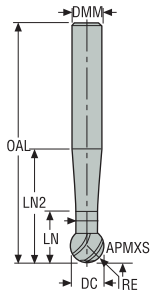
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	690 (670 — 930) *2275 (2200 — 3000)*
N2	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	470 (410 — 680) *1550 (1400 — 2200)*
N3	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	315 (280 — 450) *1025 (920 — 1400)*
N11	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.38 *0,015*	470 (420 — 680) *1550 (1400 — 2200)*
TS1	A	0.500 *0,500*	0.50 *0,50*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	700 (630 — 860) *2300 (2100 — 2800)*
TP1	M	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.38 *0,015*	470 (410 — 680) *1550 (1400 — 2200)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

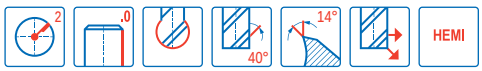
JH460

Alta velocità – Alluminio – A testa sferica – 2 Eliche – Cilindrico



E





- Tolleranze:
- DMM=h5
- DC=-0,02/-0,06 mm
- RE= ±0.02 mm
- SA=250°

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm		
460030-HEMI	00040372	2	E	3,0	3,0	2,3	60,0	4,8	9,9	1,5	1,5	2	■
460040-HEMI	00040373	2	E	4,0	4,0	3,1	60,0	5,6	12,1	2,0	2,0	2	■
460050-HEMI	00040376	2	E	5,0	5,0	3,9	70,0	6,4	14,4	2,5	2,5	2	■
460060-HEMI	00040377	2	E	6,0	6,0	4,7	80,0	9,7	19,1	3,0	3,0	2	■
460080-HEMI	00040378	2	E	8,0	8,0	6,2	85,0	11,2	23,6	4,0	4,0	2	■
460100-HEMI	00040379	2	E	10,0	10,0	7,8	100,0	15,6	30,8	5,0	5,0	2	■
460120-HEMI	00040380	2	E	12,0	12,0	9,4	125,0	17,2	35,3	6,0	6,0	2	■

■ Prodotto standard.

Parametri di taglio – JH460 Copiatura sgrossatura

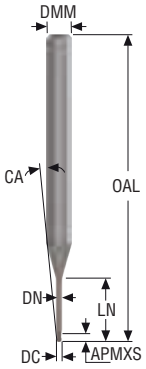
SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
N1	E/M/A	0.500 *0,500*	0.20 *0,20*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	590 (500 — 680) *1925 (1700 — 2200)*
N11	E/M/A	0.300 *0,300*	0.20 *0,20*	0.046 *0,0018*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	610 (510 — 700) *2000 (1700 — 2200)*
S11	E/M/A	0.300 *0,300*	0.20 *0,20*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	120 (110 — 130) *395 (370 — 420)*
S12	E/M/A	0.300 *0,300*	0.20 *0,20*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	90 (82 — 100) *295 (270 — 320)*
S13	E/M/A	0.300 *0,300*	0.20 *0,20*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	75 (65 — 81) *245 (220 — 260)*
TS1	A	0.500 *0,500*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.13 *0,0050*	0.15 *0,0060*	0.20 *0,0080*	0.25 *0,010*	0.30 *0,012*	620 (520 — 720) *2025 (1800 — 2300)*
TP1	M	0.300 *0,300*	0.20 *0,20*	0.046 *0,0018*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	405 (360 — 450) *1325 (1200 — 1400)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

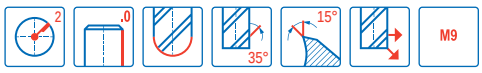
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

SMB413/414/416

Miniaturizzato – Alluminio – A testa sferica – 2 Eliche – Cilindrico



G





- Tolleranze:
- Run-out= <0,005 mm
- DMM = h5
- DC = 0/-0,01 mm
- RE = ±0,005 mm

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	DN	LN	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm			
SMB414020G4B.0Z2	–	10109385	4	G	2,0	4	2,0	50	1,9	12,0	3,75 °	2	■
SMB414020G4B.0Z2	M9	10109139	4	G	2,0	4	2,0	50	1,9	12,0	3,75 °	2	■
SMB414030G4B.0Z2	–	10109386	4	G	3,0	4	3,0	50	2,85	16,0	1,68 °	2	■
SMB414030G4B.0Z2	M9	10109140	4	G	3,0	4	3,0	50	2,85	16,0	1,68 °	2	■
SMB413025G5B.0Z2	–	10109133	5	G	2,5	3	2,5	50	2,4	20,0	0,71 °	2	■
SMB413025G5B.0Z2	M9	10109136	5	G	2,5	3	2,5	50	2,4	20,0	0,71 °	2	■
SMB414025G5B.0Z2	–	10109387	5	G	2,5	4	2,5	50	2,4	20,0	1,94 °	2	■
SMB414025G5B.0Z2	M9	10109141	5	G	2,5	4	2,5	50	2,4	20,0	1,94 °	2	■
SMB416025G5B.0Z2	–	10109390	5	G	2,5	6	2,5	55	2,4	20,0	3,87 °	2	■
SMB416025G5B.0Z2	M9	10109145	5	G	2,5	6	1,0	55	0,95	20,0	3,87 °	2	■
SMB414010G6B.0Z2	–	10109381	6	G	1,0	4	1,0	50	0,95	10,0	5,5 °	2	■
SMB414010G6B.0Z2	M9	10109142	6	G	1,0	4	1,0	50	0,95	10,0	5,5 °	2	■
SMB413015G6B.0Z2	–	10109134	6	G	1,5	3	1,5	50	1,4	20,0	1,9 °	2	■
SMB413015G6B.0Z2	M9	10109137	6	G	1,5	3	1,5	50	1,4	20,0	1,9 °	2	■
SMB414015G6B.0Z2	–	10109388	6	G	1,5	4	2,5	55	2,4	20,0	2,92 °	2	■
SMB414015G6B.0Z2	M9	10109143	6	G	1,5	4	1,5	55	1,4	20,0	2,92 °	2	■
SMB416015G6B.0Z2	–	10109391	6	G	1,5	6	1,5	55	1,4	20,0	4,56 °	2	■
SMB416015G6B.0Z2	M9	10109146	6	G	1,5	6	1,5	55	1,4	20,0	4,56 °	2	■
SMB413010G7B.0Z2	–	10109135	7	G	1,0	3	1,0	50	0,95	18,0	2,63 °	2	■
SMB413010G7B.0Z2	M9	10109138	7	G	1,0	3	1,0	50	0,95	18,0	2,63 °	2	■
SMB414010G7B.0Z2	–	10109389	7	G	1,0	4	1,0	50	0,95	18,0	3,64 °	2	■
SMB414010G7B.0Z2	M9	10109144	7	G	1,0	4	1,0	50	0,95	18,0	3,64 °	2	■
SMB416010G7B.0Z2	–	10109392	7	G	1,0	6	1,0	55	0,95	18,0	5,23 °	2	■
SMB416010G7B.0Z2	M9	10109147	7	G	1,0	6	1,0	55	0,95	18,0	5,23 °	2	■

■ Prodotto standard.

Parametri di taglio – SMB413 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z			v_c
				1	1.5	2.5	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*

Parametri di taglio – SMB414 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				1	1.5	2	2.5	3	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*

Parametri di taglio – SMB416 Copiatura sgrossatura

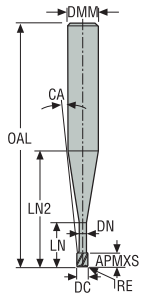
SMG		a_e/DC	a_p/DC	f_z			v_c
				1	1.5	2.5	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

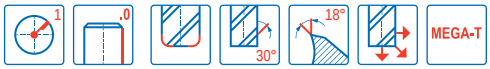
JM403/JM404/JM406

Miniaturizzato – Alluminio – Spallamento – 1 Elica – Cilindrico – Raggio di punta



G





- Tolleranze:
- Run-out=<0,005 mm
- DMM= h5
- DC= < Ø0,6= -0,005/-0,013 mm
- DC= ≥ Ø0,6= -0,005/-0,015 mm
- RE= ±0,01 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm			
403ML005R005-MEGA-T	02568434	2	G	0,5	3,0	0,5	40,0	1,5	6,7	0,45	0,05	11,0	1	■
403ML008R005-MEGA-T	02568450	2	G	0,8	3,0	0,8	40,0	2,5	7,1	0,75	0,05	9,0	1	■
403ML010R010-MEGA-T	02568456	2	G	1,0	3,0	1,0	40,0	4,0	8,3	0,95	0,1	7,5	1	■
406ML015R010-MEGA-T	02568478	5	G	1,5	6,0	1,5	50,0	5,0	14,0	1,4	0,1	9,5	1	■
404ML020R010-MEGA-T	02577246	5	G	2,0	4,0	2,0	40,0	6,0	10,4	1,9	0,1	6,0	1	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a αη (lαη, rif.)*

Parametri di taglio – JM403/JM404/406 Contornatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	0.8	1	1.5	2	
N1	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	365 (310 — 420) *1200 (1100 — 1300)*
N2	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	235 (200 — 270) *770 (660 — 880)*
N3	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	155 (140 — 180) *510 (460 — 590)*

Parametri di taglio – JM403/JM404/406 Scanalatura

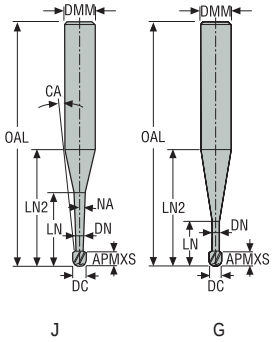
SMG		a_p/DC	f_z					v_c
			0.5	0.8	1	1.5	2	
N1	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	315 (270 — 360) *1025 (890 — 1100)*
N2	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	200 (170 — 230) *660 (560 — 750)*
N3	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	135 (120 — 150) *445 (400 — 490)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

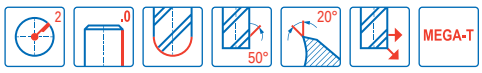
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JM413/JM416

Miniaturizzato – Alluminio – A testa sferica – 2 Elica – Cilindrico







- Tolleranze:
- Run-out=<0,005 mm
- DMM=h5
- DC= < Ø 0,6= -0,005/-0,013 mm
- DC= ≥ Ø 0,6= -0,005/-0,015 mm
- RE= ±0,005 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	NA°	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm				
413ML005TN-MEGA-T	02568709	2	J	0,5	3,0	0,375	40,0	1,5	6,6	0,45	0,25	0,9	11,5	2	■
413L005-MEGA-T	02568711	3	G	0,5	3,0	0,375	40,0	2,5	7,7	0,45	0,25	0,0	10,0	2	■
413L008-MEGA-T	02568727	3	G	0,8	3,0	0,6	40,0	4,0	8,6	0,75	0,4	0,0	8,0	2	■
413L010-MEGA-T	02568736	3	G	1,0	3,0	0,75	40,0	5,0	9,3	0,95	0,5	0,0	7,0	2	■
416L015-MEGA-T	02568772	3	G	1,5	6,0	1,125	50,0	7,5	16,5	1,4	0,75	0,0	8,5	2	■
416L020-MEGA-T	02568779	3	G	2,0	6,0	1,5	50,0	10,0	18,1	1,9	1,0	0,0	7,0	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JM413/416 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				0,5	0.8	1	1.5	2	
N1	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*
N2	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	245 (240 — 320) *800 (790 — 1000)*
N3	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	165 (160 — 210) *540 (530 — 680)*
N11	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	320 (300 — 430) *1050 (990 — 1400)*
TS1	A	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*
TP1	A	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi



DURO

Seco offre una gamma completa di frese a spallamento retto in metallo duro integrale ad alte prestazioni, frese a testa sferica e frese integrali per finitura che aumentano la produttività per acciaio temprato.

- JHP170, JHF181, JH120, JH130, JH930, JH142, JME142 e JME144 per tipo con raggio.
- JH112, JH150, JH160 e JMB112 per tipo a testa sferica.

Selezione utensile duri

							
Nome		JHP170	JHF181	JH120	JH130	JH930	JH142
Pag.		382	385	388	390	143, 392	203, 395
Famiglia		HPM	HFM	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Tipo di fresa							
Attacco	Cilindrico	■	■	■	■	■	■
	Weldon	■					
Numero di eliche		3-4	3-4-5	4	5-6, 8	5-6, 8	2-4-5-6
Adduz. refrig. interna			■				
	Metrico	2-20	1-10	2-16	6-20	6-20	2-12
	Pollici						
Lunghezze disponibili		2	1,2,3,4	2	2	2	2,3,6
Operazione							
							
							
SMG							
H3		●	●	●	●	●	●
H5		●	●	●	●	●	●
H7		●	●	●	●	●	●
H8		●	●	●	●	●	●
H11		●	●	●	●	●	
H12		●	●	●	●	●	
H21		●	●	●	●	●	●
H31		●	●	●	●	●	●

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

Selezione utensile duri

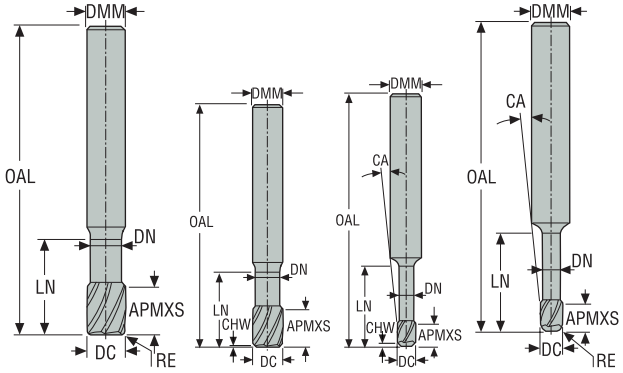
							
Nome		JH112	JH150	JH160	JME142	JME144	JMB112
Pag.		208, 398	401	403	405	410	412
Famiglia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Tipo di fresa							
Attacco	Cilindrico	■	■	■	■	■	■
	Weldon						
Numero di eliche		2	4	4	2	4	2
Adduz. refrig. interna							
	Metrico	2-12	6-12	3-12	0,2-3,0	1,0-3,0	0,2-3,0
	Pollici						
Lunghezze disponibili		1,2,3,4,5,6	2	2	1,2,3,4,5,6	2,3,4	1,2,3,4,5,6
Operazione							
							
							
SMG							
H3		•	•	•	•	•	•
H5		•	•	•	•	•	•
H7		•	•	•	•	•	•
H8		•	•	•	•	•	•
H11			•	•	•	•	•
H12			•	•	•	•	•
H21		•	•	•	•	•	•
H31		•	•	•	•	•	•

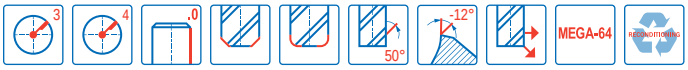
■ Prodotto standard ☐ Weldon disponibile, tempo di consegna 3 giorni.
• Prima scelta ○ Scelta alternativa

JHP170

Alte prestazioni – Acciaio temprato – Spallamento – 3-4 Eliche – Cilindrico – Raggio di punta o smusso







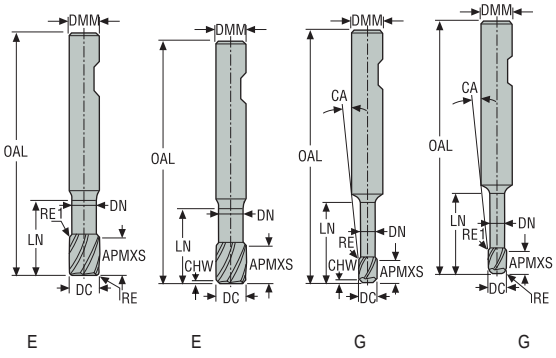
- Tolleranze:
- DMM= h5
- DC= -0,02/-0,04 mm
- CHW= Ø2- Ø4=+0,05 mm
- CHW= Ø5-Ø16=+0,1 mm
- RE= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm			
170020.0-MEGA-64	02462685	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	■
170020R020.0-MEGA-64	02587615	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	14,5	3	■
170020R050.0-MEGA-64	02587617	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	15,0	3	■
170030.0-MEGA-64	02462686	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	■
170030R020.0-MEGA-64	02587618	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	9,5	3	■
170030R050.0-MEGA-64	02587619	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	9,5	3	■
170040.0-MEGA-64	02462687	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	■
170040R020.0-MEGA-64	02587620	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	5,5	4	■
170040R050.0-MEGA-64	02587621	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	5,5	4	■
170050.0-MEGA-64	02462688	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	■
170050R020.0-MEGA-64	02587622	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	2,5	4	■
170050R050.0-MEGA-64	02587623	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	2,5	4	■
170060.0-MEGA-64	02462689	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	■
170060R020.0-MEGA-64	02587624	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	■
170060R050.0-MEGA-64	02587625	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	■
170080.0-MEGA-64	02462690	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	■
170080R020.0-MEGA-64	02587626	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	■
170080R050.0-MEGA-64	02587627	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	■
170080R100.0-MEGA-64	02587628	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	■
170100.0-MEGA-64	02462691	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	■
170100R050.0-MEGA-64	02587629	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	■
170100R100.0-MEGA-64	02587630	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	■
170120.0-MEGA-64	02462692	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	■
170120R050.0-MEGA-64	02587631	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	■
170120R100.0-MEGA-64	02587632	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	■
170160.0-MEGA-64	02462693	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	■
170160R050.0-MEGA-64	02587633	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	■

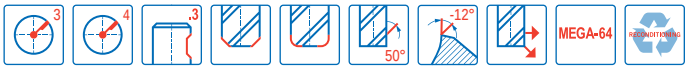
■ Prodotto standard.

JHP170

Alte prestazioni – Acciaio temprato – Spallamento – 3-4 Eliche – Weldon – Raggio di punta o smusso







- Tolleranze:
- DMM= h5
- DC= -0,02/-0,04 mm
- CHW= Ø2-Ø4=+0,05 mm
- CHW= Ø5-Ø16= +0,1 mm
- RE= ±0,05 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA°	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm			
170020-MEGA-64	02452924	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	■
170020R020.0-MEGA-64W	02669319	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	–	3	□
170020R050.0-MEGA-64W	02669320	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	–	3	□
170030-MEGA-64	02452925	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	■
170030R020.0-MEGA-64W	02669321	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	–	3	□
170030R050.0-MEGA-64W	02669322	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	–	3	□
170040-MEGA-64	02452927	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	■
170040R020.0-MEGA-64W	02669323	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	–	4	□
170040R050.0-MEGA-64W	02669324	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	–	4	□
170050-MEGA-64	02452928	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	■
170050R020.0-MEGA-64W	02669325	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	–	4	□
170050R050.0-MEGA-64W	02669326	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	–	4	□
170060-MEGA-64	02452929	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	■
170060R020.0-MEGA-64W	02669327	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	□
170060R050.0-MEGA-64W	02669328	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	□
170080-MEGA-64	02452930	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	■
170080R020.0-MEGA-64W	02669329	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	□
170080R050.0-MEGA-64W	02669331	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	□
170080R100.0-MEGA-64W	02669332	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	□
170100-MEGA-64	02452931	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	■
170100R050.0-MEGA-64W	02669333	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	□
170100R100.0-MEGA-64W	02669334	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	□
170120-MEGA-64	02452932	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	■
170120R050.0-MEGA-64W	02669335	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	□
170120R100.0-MEGA-64W	02669336	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	□
170160-MEGA-64	02452933	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	■
170160R050.0-MEGA-64W	02669337	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	□
170200R050-MEGA-64	02611637	2	E	20,0	20,0	20,0	100,0	40,0	19,2	–	0,5	–	4	■

■ Prodotto standard. □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

Parametri di taglio – JHP170 Contornatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
H3	M	0.150 *0,150*	0.60 *0,60*	0.0055 *0,00022*	0.0085 *0,00034*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	29 (22 — 35) *95 (73 — 110)*
H5	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	60 (56 — 68) *195 (190 — 220)*
H7	M	0.150 *0,150*	0.60 *0,60*	0.0055 *0,00022*	0.0085 *0,00034*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	29 (22 — 35) *95 (73 — 110)*
H8	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	65 (59 — 71) *215 (200 — 230)*
H11	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	80 (71 — 86) *260 (240 — 280)*
H12	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	75 (69 — 83) *245 (230 — 270)*
H21	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	65 (59 — 71) *215 (200 — 230)*
H31	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	60 (56 — 68) *195 (190 — 220)*

Parametri di taglio – JHP170 Scanalatura

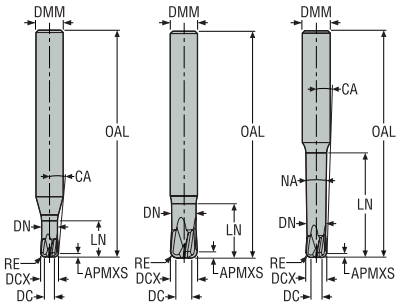
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
H3	M	0.40 *0,40*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	20 (16 — 25) *65 (53 — 82)*
H5	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	50 (46 — 55) *165 (160 — 180)*
H7	M	0.40 *0,40*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	20 (16 — 25) *65 (53 — 82)*
H8	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (46 — 55) *165 (160 — 180)*
H11	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	65 (58 — 70) *215 (200 — 220)*
H12	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	60 (53 — 64) *195 (180 — 200)*
H21	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (46 — 55) *165 (160 — 180)*
H31	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	50 (46 — 55) *165 (160 — 180)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JHF181

Elevato avanzamento – Acciaio temprato – Spallamento – 3-5 Eliche – Cilindrico – Raggio di punta – ICC







- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DCX	DC	DMM	APMXS	OAL	LN	DN	NA	RE	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm	mm	mm			
JHF181020G1R050.0Z4-HXT	03067297	1	G	–	2,0	1,0	6,0	0,5	50,0	4,0	1,8	0,0	0,5	10,0	4	■
JHF181030G1R075.0Z4-HXT	03067298	1	G	–	3,0	1,5	6,0	0,75	50,0	6,0	2,7	0,0	0,75	7,5	4	■
JHF181040G1R100.0Z4-HXT	03067299	1	G	–	4,0	2,0	6,0	1,0	50,0	8,0	3,6	0,0	1,0	5,0	4	■
JHF181060E1R150.0Z4-HXT	03067300	1	E	–	6,0	3,0	6,0	1,5	50,0	12,0	5,4	0,0	1,5	–	4	■
JHF181080E1R200.0Z4-HXT	03067301	1	E	–	8,0	4,0	8,0	2,0	55,0	16,0	7,3	0,0	2,0	–	4	■
JHF181100E1R200.0Z4-HXT	03067302	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	0,0	2,0	–	4	■
JHF181100E1R200.0Z5-HXT	03067303	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	0,0	2,0	–	5	■
JHF181120E1R300.0Z4-HXT	03067304	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	0,0	3,0	–	4	■
JHF181120E1R300.0Z5-HXT	03067305	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	0,0	3,0	–	5	■
JHF181160E1R300.0Z4-HXT	03067306	1	E	–	16,0	10,0	16,0	3,0	80,0	32,0	14,8	0,0	3,0	–	4	■
JHF181020G2R050.0Z4-HXT	03067307	2	G	–	2,0	1,0	6,0	0,5	50,0	8,0	1,8	0,0	0,5	7,5	4	■
JHF181030G2R075.0Z4-HXT	03067308	2	G	–	3,0	1,5	6,0	0,75	50,0	12,0	2,7	0,0	0,75	5,0	4	■
JHF181040G2R100.0Z4-HXT	03067309	2	G	–	4,0	2,0	6,0	1,0	50,0	16,0	3,6	0,0	1,0	3,0	4	■
JHF181060E2R150.0Z4A-HXT	03067311	2	E	■	6,0	3,0	6,0	1,5	65,0	24,0	5,4	0,0	1,5	–	4	■
JHF181060E2R150.0Z4-HXT	03067310	2	E	–	6,0	3,0	6,0	1,5	65,0	24,0	5,4	0,0	1,5	–	4	■
JHF181080E2R200.0Z4A-HXT	03067313	2	E	■	8,0	4,0	8,0	2,0	70,0	32,0	7,3	0,0	2,0	–	4	■
JHF181080E2R200.0Z4-HXT	03067312	2	E	–	8,0	4,0	8,0	2,0	70,0	32,0	7,3	0,0	2,0	–	4	■
JHF181100E2R200.0Z4A-HXT	03067315	2	E	■	10,0	6,0	10,0	2,0	85,0	40,0	9,2	0,0	2,0	–	4	■
JHF181100E2R200.0Z4-HXT	03067314	2	E	–	10,0	6,0	10,0	2,0	85,0	40,0	9,2	0,0	2,0	–	4	■
JHF181120E2R300.0Z4A-HXT	03067317	2	E	■	12,0	6,0	12,0	3,0	100,0	48,0	11,0	0,0	3,0	–	4	■
JHF181120E2R300.0Z4-HXT	03067316	2	E	–	12,0	6,0	12,0	3,0	100,0	48,0	11,0	0,0	3,0	–	4	■
JHF181020J3R050.0Z4-HXT	03067318	3	J	–	2,0	1,0	6,0	0,5	50,0	10,0	1,8	0,9	0,5	6,8	4	■
JHF181030J3R075.0Z4-HXT	03067319	3	J	–	3,0	1,5	6,0	0,75	50,0	15,0	2,7	0,9	0,75	4,4	4	■
JHF181040J3R100.0Z4-HXT	03067320	3	J	–	4,0	2,0	6,0	1,0	60,0	20,0	3,6	0,9	1,0	2,6	4	■
JHF181060J3R150.0Z4-HXT	03067321	3	J	–	6,0	3,0	8,0	1,5	65,0	30,0	5,4	0,9	1,5	1,9	4	■
JHF181080J3R200.0Z4-HXT	03067325	3	J	–	8,0	4,0	10,0	2,0	85,0	40,0	7,3	0,9	2,0	1,5	4	■
JHF181100J3R200.0Z4-HXT	03067327	3	J	–	10,0	6,0	12,0	2,0	100,0	50,0	9,2	0,9	2,0	1,2	4	■
JHF181020J4R050.0Z3-HXT	03067329	4	J	–	2,0	1,0	6,0	0,5	50,0	14,0	1,8	0,9	0,5	5,6	3	■
JHF181030J4R075.0Z3-HXT	03067330	4	J	–	3,0	1,5	6,0	0,75	60,0	21,0	2,7	0,9	0,75	3,4	3	■
JHF181040J4R100.0Z3-HXT	03067331	4	J	–	4,0	2,0	6,0	1,0	65,0	28,0	3,6	0,9	1,0	2,0	3	■
JHF181060J4R150.0Z3-HXT	03067332	4	J	–	6,0	3,0	8,0	1,5	80,0	42,0	5,4	0,9	1,5	1,4	3	■
JHF181080J4R200.0Z3-HXT	03067333	4	J	–	8,0	4,0	10,0	2,0	100,0	56,0	7,3	0,9	2,0	1,1	3	■
JHF181100J4R200.0Z3-HXT	03067334	4	J	–	10,0	6,0	12,0	2,0	125,0	70,0	9,2	0,9	2,0	0,9	3	■

■ Prodotto standard.

Parametri di taglio – JHF181 Contornatura sgrossatura

SMG		a_e/DCX	a_p/DCX	f_z								v_c
				2	3	4	6	8	10	12	16	
P6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	305 (290 — 320) *1000 (960 — 1000)*
P7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	290 (270 — 300) *950 (890 — 980)*
P8	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	270 (260 — 290) *890 (860 — 950)*
P11	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	280 (270 — 290) *920 (890 — 950)*
K1	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	210 (190 — 240) *690 (630 — 780)*
K2	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	185 (160 — 200) *610 (530 — 650)*
K3	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	155 (140 — 170) *510 (460 — 550)*
K4	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	150 (130 — 160) *490 (430 — 520)*
K5	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	150 (120 — 170) *490 (400 — 550)*
K6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	220 (180 — 260) *720 (600 — 850)*
K7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	190 (160 — 220) *620 (530 — 720)*
S1	E	0.18 *0,18*	0.014 *0,014*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	60 (40 — 79) *195 (140 — 250)*
S2	E	0.18 *0,18*	0.014 *0,014*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	48 (33 — 64) *155 (110 — 200)*
S3	E	0.18 *0,18*	0.014 *0,014*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	42 (28 — 55) *140 (92 — 180)*
S11	E	0.18 *0,18*	0.034 *0,034*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	200 (180 — 220) *660 (600 — 720)*
S12	E	0.18 *0,18*	0.034 *0,034*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	155 (140 — 170) *510 (460 — 550)*
S13	E	0.18 *0,18*	0.034 *0,034*	0.032 *0,0013*	0.046 *0,0018*	0.065 *0,0026*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.24 *0,0095*	125 (110 — 130) *410 (370 — 420)*
H3	M/A/D	0.30 *0,30*	0.020 *0,020*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	85 (73 — 96) *280 (240 — 310)*
H5	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H7	M/A/D	0.30 *0,30*	0.020 *0,020*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	85 (73 — 96) *280 (240 — 310)*
H8	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H11	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	210 (190 — 230) *690 (630 — 750)*
H12	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	190 (180 — 210) *620 (600 — 680)*
H21	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H31	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	125 (120 — 130) *410 (400 — 420)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JHF181 Scanalatura

SMG		a_p/DCX	f_z								v_c
			2	3	4	6	8	10	12	16	
P6	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	270 (260 — 280) *890 (860 — 910)*
P7	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	255 (240 — 270) *840 (790 — 880)*
P8	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	240 (230 — 250) *790 (760 — 820)*
P11	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	250 (240 — 260) *820 (790 — 850)*
K1	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	185 (170 — 210) *610 (560 — 680)*
K2	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	130 (120 — 140) *425 (400 — 450)*
K5	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	130 (110 — 150) *425 (370 — 490)*
K6	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	195 (160 — 230) *640 (530 — 750)*
K7	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	170 (140 — 200) *560 (460 — 650)*
S1	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	48 (33 — 64) *155 (110 — 200)*
S2	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	39 (26 — 51) *130 (86 — 160)*
S3	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	33 (23 — 44) *110 (76 — 140)*
S11	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	170 (150 — 190) *560 (500 — 620)*
S12	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	130 (120 — 140) *425 (400 — 450)*
S13	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	100 (89 — 110) *330 (300 — 360)*
H3	M/A/D	0.020 *0,020*	0.034 *0,0013*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	0.28 *0,011*	75 (63 — 83) *245 (210 — 270)*
H5	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H7	M/A/D	0.020 *0,020*	0.034 *0,0013*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	0.28 *0,011*	75 (63 — 83) *245 (210 — 270)*
H8	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H11	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	185 (170 — 200) *610 (560 — 650)*
H12	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	170 (160 — 180) *560 (530 — 590)*
H21	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H31	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	110 (98 — 120) *360 (330 — 390)*

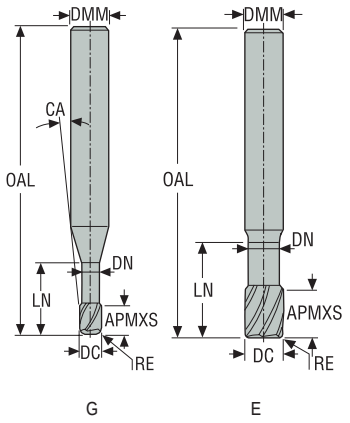
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

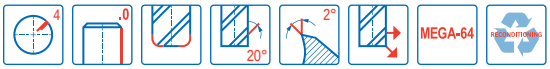
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH120

Alta velocità – Acciaio temprato – Spallamento – 4 Eliche – Cilindrico – Raggio di punta







- Tolleranze:
- DMM=h5
- DC=-0,02/-0,03 mm
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
120020-MEGA-64	00019437	2	G	2,0	6,0	2,5	50,0	5,0	1,9	0,2	10,5	4	■
120025-MEGA-64	00019448	2	G	2,5	6,0	3,0	50,0	6,0	2,4	0,25	8,5	4	■
120030-MEGA-64	00019450	2	G	3,0	6,0	4,0	50,0	7,0	2,8	0,3	7,0	4	■
120035-MEGA-64	00019460	2	G	3,5	6,0	4,5	50,0	8,0	3,2	0,35	5,5	4	■
120040-MEGA-64	00019462	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,4	4,5	4	■
120050-MEGA-64	00019476	2	G	5,0	6,0	6,0	50,0	12,0	4,6	0,5	2,5	4	■
120060-MEGA-64	00019479	2	E	6,0	6,0	7,0	55,0	14,0	5,6	0,6	–	4	■
120080-MEGA-64	00019481	2	E	8,0	8,0	10,0	60,0	18,0	7,4	0,8	–	4	■
120100-MEGA-64	00019494	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	4	■
120120-MEGA-64	00019501	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,2	–	4	■
120160-MEGA-64	00019503	2	E	16,0	16,0	18,0	90,0	35,0	15,4	1,6	–	4	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JH120 Contornatura

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
H3	M	0.0150 *0,0150*	0.50 *0,50*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	90 (57 — 130) *295 (190 — 420)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H7	M	0.0150 *0,0150*	0.50 *0,50*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	90 (57 — 130) *295 (190 — 420)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	275 (230 — 320) *900 (760 — 1000)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	250 (210 — 290) *820 (690 — 950)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	135 (120 — 150) *445 (400 — 490)*

Parametri di taglio – JH120 Scanalatura

SMG		a_p/DC	f_z											v_c
			2	2.5	3	3.5	4	5	6	8	10	12	16	
H3	M	0.050 *0,050*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	55 (34 — 78) *180 (120 — 250)*
H5	M	0.18 *0,18*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	120 (98 — 140) *395 (330 — 450)*
H7	M	0.050 *0,050*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	55 (34 — 78) *180 (120 — 250)*
H8	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	125 (110 — 140) *410 (370 — 450)*
H11	M	0.18 *0,18*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	150 (130 — 170) *490 (430 — 550)*
H12	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	145 (120 — 170) *475 (400 — 550)*
H21	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	125 (110 — 140) *410 (370 — 450)*
H31	M	0.18 *0,18*	0.0055 *0,00022*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	80 (70 — 92) *260 (230 — 300)*

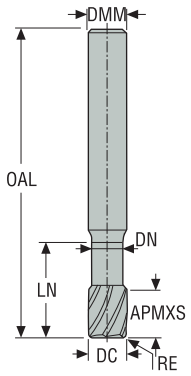
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH130

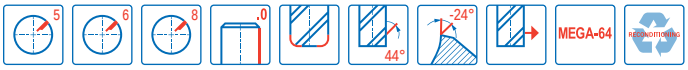
Alta velocità – Acciaio temprato – Spallamento – 5-8 Eliche – Cilindrico – Raggio di punta





E

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
130060-MEGA-64	00019504	2	E	6,0	6,0	6,0	55,0	12,0	5,6	0,2	5	■
130080-MEGA-64	00019507	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,2	5	■
130100-MEGA-64	00019511	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,3	6	■
130120-MEGA-64	00019512	2	E	12,0	12,0	12,0	80,0	24,0	11,4	0,5	6	■
130160-MEGA-64	00019514	2	E	16,0	16,0	16,0	90,0	30,0	15,4	0,5	8	■
130200-MEGA-64	00019542	2	E	20,0	20,0	20,0	100,0	35,0	19,2	0,5	8	■

■ Prodotto standard.

Parametri di taglio – JH130 Contornatura finitura

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
H3	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	255 (240 — 270) *840 (790 — 880)*
H7	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	320 (300 — 340) *1050 (990 — 1100)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	300 (280 — 320) *980 (920 — 1000)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	155 (140 — 170) *510 (460 — 550)*

Parametri di taglio – JH130 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
H3	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	255 (240 — 270) *840 (790 — 880)*
H7	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	320 (300 — 340) *1050 (990 — 1100)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	300 (280 — 320) *980 (920 — 1000)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	155 (140 — 170) *510 (460 — 550)*

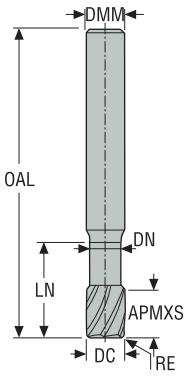
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH930

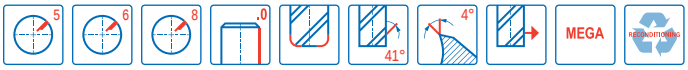
Alta velocità – Universale – Spallamento – 5-8 Eliche – Cilindrico – Raggio di punta





E

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
930060R020-MEGA	00022026	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,2	5	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	■

■ Prodotto standard.

Parametri di taglio – JH930 Contornatura

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300 — 1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	430 (360 — 480) *1400 (1200 — 1500)*
P3	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	375 (320 — 420) *1225 (1100 — 1300)*
P4	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	330 (280 — 370) *1075 (920 — 1200)*
P5	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	315 (270 — 350) *1025 (890 — 1100)*
P6	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	355 (300 — 390) *1175 (990 — 1200)*
P7	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	335 (280 — 370) *1100 (920 — 1200)*
P8	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (270 — 350) *1025 (890 — 1100)*
P11	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	325 (280 — 360) *1075 (920 — 1100)*
P12	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
K1	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	255 (210 — 300) *840 (690 — 980)*
K2	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	225 (180 — 260) *740 (600 — 850)*
K3	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	190 (160 — 220) *620 (530 — 720)*
K4	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	180 (150 — 210) *590 (500 — 680)*
K5	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	205 (160 — 250) *670 (530 — 820)*
K6	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	300 (230 — 370) *980 (760 — 1200)*
K7	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (200 — 320) *850 (660 — 1000)*
S1	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	80 (62 — 100) *260 (210 — 320)*
S2	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (50 — 82) *215 (170 — 260)*
S3	E/M/A	0.0200 *0,0200*	0.70 *0,70*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	41 (31 — 50) *135 (110 — 160)*
S11	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
S12	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	120 (110 — 140) *395 (370 — 450)*
S13	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	95 (81 — 110) *310 (270 — 360)*
H3	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H5	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	250 (210 — 300) *820 (690 — 980)*
H7	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H8	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H11	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	320 (260 — 380) *1050 (860 — 1200)*
H12	M/A	0.0400 *0,0400*	0.70 *0,70*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	270 (220 — 320) *890 (730 — 1000)*
H21	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H31	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (130 — 180) *510 (430 — 590)*

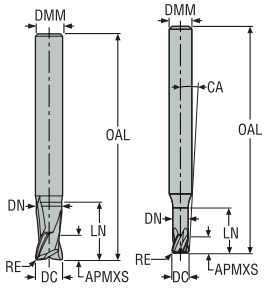
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JH142

Alta velocità – Alta precisione – Torico – Acciaio temprato – 2-6 Eliche – Cilindrico – Raggio di punta





- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Riaffilatura possibile se DC è ≥Ø6

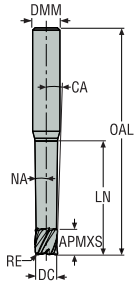


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

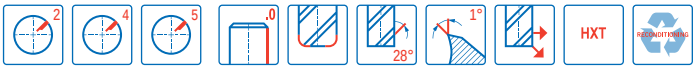
JH142

Alta velocità – Alta precisione – Torico – Acciaio temprato – 2-5 Eliche – Cilindrico – Raggio di punta



J





- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JH142020J3R030.0Z2-HXT	02968255	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	2	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	4	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	2	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	4	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	2	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	4	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	2	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	4	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	2	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	4	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	2	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	4	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	2	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	4	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	4	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	5	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	4	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	5	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	5	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	5	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	5	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	5	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	5	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	5	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	5	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	5	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	5	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	4	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	4	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	4	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	4	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	4	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	4	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	4	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a αη (lαη, rif.)*

Parametri di taglio – JH142 Copiatura sgrossatura

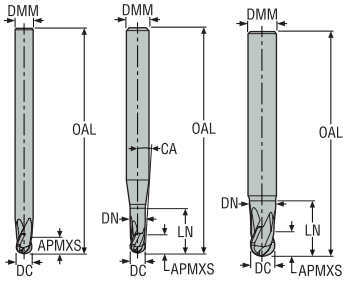
SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600 — 1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	470 (450 — 520) *1550 (1500 — 1700)*
P3	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	405 (390 — 450) *1325 (1300 — 1400)*
P4	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	360 (340 — 390) *1175 (1200 — 1200)*
P5	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
P6	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	385 (370 — 420) *1275 (1300 — 1300)*
P7	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	365 (350 — 400) *1200 (1200 — 1300)*
P8	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	340 (330 — 380) *1125 (1100 — 1200)*
P11	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	355 (340 — 390) *1175 (1200 — 1200)*
K1	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K2	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	300 (290 — 330) *980 (960 — 1000)*
K3	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	255 (240 — 280) *840 (790 — 910)*
K4	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	245 (230 — 260) *800 (760 — 850)*
K5	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K6	A/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (480 — 550) *1650 (1600 — 1800)*
K7	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	440 (420 — 490) *1450 (1400 — 1600)*
H3	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H5	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	305 (290 — 330) *1000 (960 — 1000)*
H7	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H8	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H11	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	390 (360 — 420) *1275 (1200 — 1300)*
H12	M/A	0.0500 *0,0500*	0.050 *0,050*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	345 (320 — 370) *1125 (1100 — 1200)*
H21	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H31	M/A	0.0300 *0,0300*	0.030 *0,030*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	140 (120 — 160) *460 (400 — 520)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

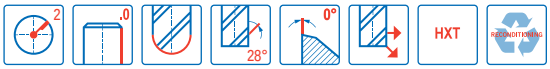
JH112

Alta velocità – Alta precisione – Acciaio temprato – A testa sferica – 2 Eliche – Cilindrico



D G E





- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Riaffilatura possibile se DC è ≥Ø6

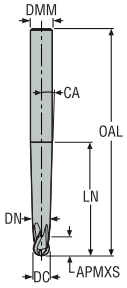
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm			
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	6,45	2	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	3,3	2	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	–	2	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,0	2	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	–	2	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	–	2	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	–	2	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	2,5	2	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	–	2	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	–	2	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	–	2	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	–	2	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	8,12	2	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	7,39	2	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	5,5	2	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	3,81	2	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	3,34	2	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,0	2	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	2,78	2	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	–	2	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	–	2	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	–	2	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	3,82	2	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	2,91	2	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	1,97	2	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	0,53	2	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	–	2	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	–	2	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	–	2	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	–	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

JH112

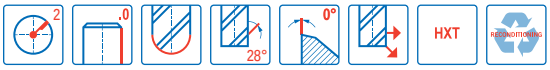
Alta velocità – Alta precisione – Acciaio temprato – A testa sferica – 2 Eliche – Cilindrico





J

- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Riaffilatura possibile se DC è ≥Ø6



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	DN	NA°	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm				
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	1,9	3,55	3,3	2	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	2,8	2,5	2,2	2	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	3,7	1,4	1,2	2	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	4,6	1,95	1,6	2	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	5,6	1,4	1,1	2	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	7,4	1,43	1,0	2	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	9,4	1,5	1,0	2	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	5,6	2,3	2,0	2	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	7,4	2,3	1,8	2	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	9,4	1,1	0,8	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JH112 Copiatura finitura

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	520 (500 — 730) *1700 (1700 — 2300)*
K2	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	445 (430 — 630) *1450 (1500 — 2000)*
K3	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	380 (360 — 530) *1250 (1200 — 1700)*
K4	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (350 — 510) *1175 (1200 — 1600)*
K5	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K6	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	610 (550 — 900) *2000 (1900 — 2900)*
K7	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	680 (560 — 790) *2225 (1900 — 2500)*
H3	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H5	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H7	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H8	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H11	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (300 — 420) *1175 (990 — 1300)*
H12	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	330 (280 — 380) *1075 (920 — 1200)*
H21	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H31	M	0.30 *0,30*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	300 (290 — 430) *980 (960 — 1400)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JH112 Copiatura sgrossatura

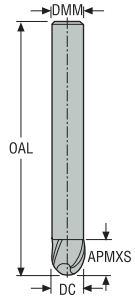
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100 — 1400)*
K2	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	280 (270 — 390) *920 (890 — 1200)*
K3	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	235 (230 — 330) *770 (760 — 1000)*
K4	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	225 (220 — 320) *740 (730 — 1000)*
K5	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	280 (250 — 410) *920 (830 — 1300)*
K6	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K7	E	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	420 (350 — 490) *1375 (1200 — 1600)*
H3	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H5	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H7	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H8	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H11	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	225 (190 — 260) *740 (630 — 850)*
H12	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	205 (170 — 240) *670 (560 — 780)*
H21	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H31	M	0.200 *0,200*	0.10 *0,10*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	200 (200 — 280) *660 (660 — 910)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

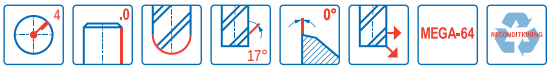
JH150

Alta velocità – Acciaio temprato – A testa sferica – 4 Eliche – Cilindrico



D





- Tolleranze:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Riaffilatura possibile

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
				mm	mm	mm	mm		
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	4	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	4	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	4	■

■ Prodotto standard.

Parametri di taglio – JH150 Copiatura sgrossatura

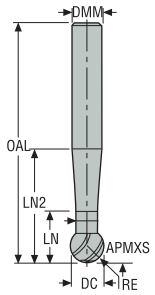
SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100 — 1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890 — 1000)*
K3	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (230 — 270) *690 (760 — 880)*
K5	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	255 (270 — 330) *840 (890 — 1000)*
K6	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	375 (390 — 500) *1225 (1300 — 1600)*
K7	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	325 (340 — 430) *1075 (1200 — 1400)*
H3	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H5	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H7	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H8	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H11	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	230 (210 — 250) *750 (690 — 820)*
H12	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 230) *690 (630 — 750)*
H21	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H31	M	0.150 *0,150*	0.060 *0,060*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	125 (130 — 180) *410 (430 — 590)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

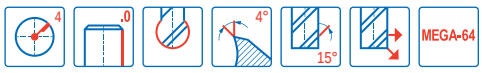
JH160

Alta velocità – Acciaio temprato – A testa sferica – 4 Eliche – Cilindrico



E





- Tolleranze:
- DMM= h5
- DC= 0,02/-0,06 mm
- SA=250°

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm	mm		
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	9,0	1,8	1,5	4	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	11,0	2,4	2,0	4	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	13,0	3,0	2,5	4	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	17,3	3,6	3,0	4	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	21,3	4,8	4,0	4	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	27,9	6,0	5,0	4	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	31,8	7,2	6,0	4	■

■ Prodotto standard.

Parametri di taglio – JH160 Copiatura finitura

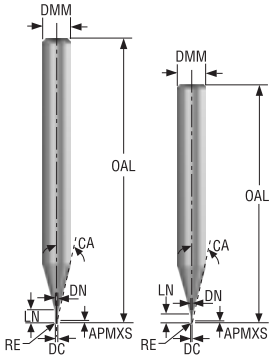
SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
P1	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	550 (450 — 700) *1800 (1500 — 2200)*
P2	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	530 (440 — 680) *1750 (1500 — 2200)*
P3	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	460 (380 — 590) *1500 (1300 — 1900)*
P4	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	405 (340 — 520) *1325 (1200 — 1700)*
P5	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P6	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	430 (360 — 560) *1400 (1200 — 1800)*
P7	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	410 (340 — 520) *1350 (1200 — 1700)*
P8	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P11	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	395 (330 — 510) *1300 (1100 — 1600)*
P12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	235 (200 — 300) *770 (660 — 980)*
H3	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H5	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H7	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H8	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H11	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	430 (400 — 460) *1400 (1400 — 1500)*
H12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	355 (340 — 380) *1175 (1200 — 1200)*
H21	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H31	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	165 (180 — 210) *540 (600 — 680)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JME142

Miniaturizzato – Acciaio temprato – Spallamento – 2 Eliche – Cilindrico – Raggio di punta







- Tolleranze:
- Run-out= <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

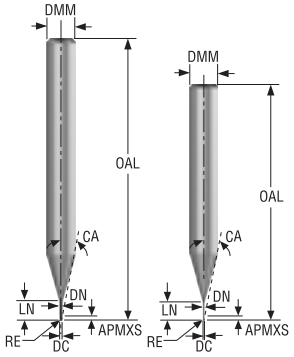
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm				
JME142002G1R005Z2.0-HXT	03205080	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,05	0,0	15,12	2	■
JME142003G1R005Z2.0-HXT	03205082	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,05	0,0	14,77	2	■
JME142004G1R005Z2.0-HXT	03205084	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,05	0,0	14,39	2	■
JME142005G1R005Z2.0-HXT	03205086	1	G	0,5	4,0	0,375	40,0	0,75	0,46	0,05	0,0	14,01	2	■
JME142006G1R005Z2.0-HXT	03205099	1	G	0,6	4,0	0,45	40,0	0,9	0,56	0,05	0,0	13,67	2	■
JME142008G1R005Z2.0-HXT	03205121	1	G	0,8	6,0	0,6	50,0	1,2	0,76	0,05	0,0	13,98	2	■
JME142010G1R005Z2.0-HXT	03205139	1	G	1,0	6,0	0,75	50,0	1,5	0,95	0,05	0,0	13,49	2	■
JME142012G1R005Z2.0-HXT	03205151	1	G	1,2	6,0	0,9	50,0	1,8	1,15	0,05	0,0	13,02	2	■
JME142015G1R005Z2.0-HXT	03205161	1	G	1,5	6,0	1,125	50,0	2,25	1,45	0,05	0,0	12,3	2	■
JME142002J2R005Z2.0-HXT	03205081	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,05	0,9	14,23	2	■
JME142003J2R005Z2.0-HXT	03205083	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,05	0,9	13,67	2	■
JME142004J2R005Z2.0-HXT	03205085	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,05	0,9	13,1	2	■
JME142005J2R005Z2.0-HXT	03205087	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,05	0,9	12,54	2	■
JME142005J2R010Z2.0-HXT	03205093	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,1	0,9	12,61	2	■
JME142005G2R005Z2.0-HXT	03205088	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,05	0,0	13,5	2	■
JME142005G2R010Z2.0-HXT	03205094	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,1	0,0	13,55	2	■
JME142006J2R005Z2.0-HXT	03205100	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,05	0,9	11,76	2	■
JME142006J2R010Z2.0-HXT	03205107	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,1	0,9	11,83	2	■
JME142006G2R005Z2.0-HXT	03205101	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,05	0,0	9,48	2	■
JME142006G2R010Z2.0-HXT	03205108	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,1	0,0	9,51	2	■
JME142008J2R005Z2.0-HXT	03205122	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,05	0,9	10,92	2	■
JME142008J2R010Z2.0-HXT	03205129	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,1	0,9	10,98	2	■
JME142008J2R020Z2.0-HXT	03205135	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,2	0,9	11,1	2	■
JME142008G2R005Z2.0-HXT	03205123	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,05	0,0	9,15	2	■
JME142008G2R010Z2.0-HXT	03205130	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,1	0,0	9,17	2	■
JME142008G2R020Z2.0-HXT	03205136	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,2	0,0	9,22	2	■
JME142010G2R005Z2.0-HXT	03205140	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,05	0,0	8,29	2	■
JME142010G2R010Z2.0-HXT	03205145	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,1	0,0	8,31	2	■
JME142010G2R020Z2.0-HXT	03205148	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,2	0,0	8,36	2	■
JME142012G2R005Z2.0-HXT	03205152	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,05	0,0	7,97	2	■
JME142012G2R010Z2.0-HXT	03205155	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,1	0,0	7,99	2	■
JME142012G2R020Z2.0-HXT	03205158	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,2	0,0	8,04	2	■
JME142015G2R005Z2.0-HXT	03205162	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,05	0,0	7,6	2	■
JME142015G2R010Z2.0-HXT	03205167	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,1	0,0	9,7	2	■
JME142015G2R020Z2.0-HXT	03205171	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,2	0,0	9,76	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a αη (lαη, rif.)*

JME142

Miniaturizzato – Acciaio temprato – Spallamento – 2 Eliche – Cilindrico – Raggio di punta





- Tolleranze:
- Run-out= <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

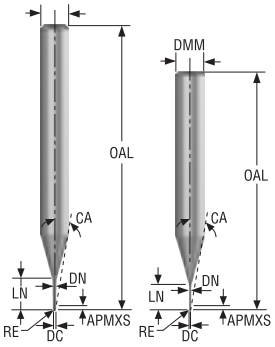


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm				
JME142020G2R005Z2.0-HXT	03205180	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,05	0,0	8,52	2	■
JME142020G2R010Z2.0-HXT	03205185	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,1	0,0	8,55	2	■
JME142020G2R020Z2.0-HXT	03205188	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,2	0,0	8,6	2	■
JME142020G2R030Z2.0-HXT	03205191	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,3	0,0	8,66	2	■
JME142030G2R005Z2.0-HXT	03205201	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,05	0,0	5,81	2	■
JME142005J3R005Z2.0-HXT	03205089	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,05	0,9	11,24	2	■
JME142005J3R010Z2.0-HXT	03205095	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,1	0,9	11,29	2	■
JME142005G3R005Z2.0-HXT	03205090	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,05	0,0	11,55	2	■
JME142005G3R010Z2.0-HXT	03205096	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,1	0,0	11,59	2	■
JME142006J3R005Z2.0-HXT	03205103	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,05	0,9	10,58	2	■
JME142006J3R010Z2.0-HXT	03205109	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,1	0,9	10,63	2	■
JME142006G3R005Z2.0-HXT	03205104	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,05	0,0	8,46	2	■
JME142006G3R010Z2.0-HXT	03205110	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,1	0,0	8,48	2	■
JME142008J3R005Z2.0-HXT	03205124	3	J	0,8	4,0	0,6	40,0	4,0	0,76	0,05	0,9	9,36	2	■
JME142008G3R005Z2.0-HXT	03205126	3	G	0,8	6,0	0,6	50,0	5,5	0,76	0,05	0,0	9,89	2	■
JME142010G3R005Z2.0-HXT	03205141	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,05	0,0	8,84	2	■
JME142010G3R010Z2.0-HXT	03205146	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,1	0,0	8,86	2	■
JME142010G3R020Z2.0-HXT	03205149	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,2	0,0	8,91	2	■
JME142015G3R005Z2.0-HXT	03205163	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,05	0,0	7,05	2	■
JME142015G3R010Z2.0-HXT	03205169	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,1	0,0	7,06	2	■
JME142015G3R020Z2.0-HXT	03205172	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,2	0,0	7,1	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

JME142

Miniaturizzato – Acciaio temprato – Spallamento – 2 Eliche – Cilindrico – Raggio di punta







- Tolleranze:
- Run-out= <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

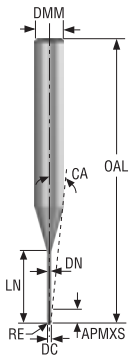
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm				
JME142020G3R005Z2.0-HXT	03205181	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,05	0,0	5,9	2	■
JME142020G3R010Z2.0-HXT	03205186	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,1	0,0	5,92	2	■
JME142020G3R020Z2.0-HXT	03205189	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,2	0,0	5,95	2	■
JME142030G3R010Z2.0-HXT	03205206	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,1	0,0	4,15	2	■
JME142005J4R010Z2.0-HXT	03205097	4	J	0,5	4,0	0,375	40,0	4,0	0,46	0,1	0,9	9,76	2	■
JME142005G4R005Z2.0-HXT	03205092	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,05	0,0	10,42	2	■
JME142005G4R010Z2.0-HXT	03205098	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,1	0,0	10,45	2	■
JME142006J4R005Z2.0-HXT	03205105	4	J	0,6	4,0	0,45	40,0	5,0	0,56	0,05	0,9	8,79	2	■
JME142008G4R005Z2.0-HXT	03205128	4	G	0,8	6,0	0,6	50,0	8,0	0,76	0,05	0,0	8,49	2	■
JME142010G4R010Z2.0-HXT	03205147	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,1	0,0	7,48	2	■
JME142010G4R020Z2.0-HXT	03205150	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,2	0,0	7,52	2	■
JME142012G4R010Z2.0-HXT	03205157	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,1	0,0	6,62	2	■
JME142012G4R020Z2.0-HXT	03205160	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,2	0,0	6,65	2	■
JME142015G4R010Z2.0-HXT	03205170	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,1	0,0	5,55	2	■
JME142015G4R020Z2.0-HXT	03205173	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,2	0,0	5,58	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a αη (lαη, rif.)*

JME142

Miniaturizzato – Acciaio temprato – Spallamento – 2 Eliche – Cilindrico – Raggio di punta





G

- Tolleranze:
- Run-out= <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JME142020G4R010Z2.0-HXT	03205187	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,1	4,19	2	■
JME142020G4R020Z2.0-HXT	03205190	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,2	4,21	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JME142 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z													v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1,5	1,8	2	2,5	3	
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	90 (59 — 110) *295 (200 — 360)*
H5	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140 — 190) *520 (460 — 620)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	90 (59 — 110) *295 (200 — 360)*
H8	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140 — 190) *520 (460 — 620)*
H11	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	205 (170 — 240) *670 (560 — 780)*
H12	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530 — 720)*
H21	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140 — 190) *520 (460 — 620)*
H31	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (110 — 140) *395 (370 — 450)*

Parametri di taglio – JME142 Scanalatura

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	1,8	2	2,5	3	
H3	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	65 (43 — 85) *215 (150 — 270)*
H5	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (97 — 130) *395 (320 — 420)*
H7	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	65 (43 — 85) *215 (150 — 270)*
H8	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (97 — 130) *395 (320 — 420)*
H11	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	150 (130 — 170) *490 (430 — 550)*
H12	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120 — 160) *445 (400 — 520)*
H21	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (98 — 140) *395 (330 — 450)*
H31	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	90 (73 — 100) *295 (240 — 320)*

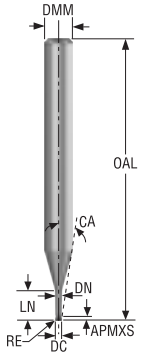
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JME144

Miniaturizzato – Acciaio temprato – Spallamento – 4 Eliche – Cilindrico – Raggio di punta





J

- Tolleranze:
- Run-out= <0,005 mm
- DMM=h5
- DC = 0-0,01 mm
- RE= ±0,005 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm				
JME144010J2R005Z4.0-HXT	03205214	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,05	0,9	9,08	4	■
JME144010J2R010Z4.0-HXT	03205217	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,1	0,9	9,13	4	■
JME144010J2R020Z4.0-HXT	03205220	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,2	0,9	9,22	4	■
JME144015J2R005Z4.0-HXT	03205227	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,05	0,9	7,52	4	■
JME144015J2R010Z4.0-HXT	03205229	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,1	0,9	7,56	4	■
JME144015J2R020Z4.0-HXT	03205232	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,2	0,9	7,63	4	■
JME144020J2R005Z4.0-HXT	03205234	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,05	0,9	5,97	4	■
JME144020J2R010Z4.0-HXT	03205236	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,1	0,9	6,0	4	■
JME144020J2R020Z4.0-HXT	03205239	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,2	0,9	6,06	4	■
JME144020J2R030Z4.0-HXT	03205241	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,3	0,9	6,12	4	■
JME144030J2R010Z4.0-HXT	03205243	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,1	0,9	2,66	4	■
JME144030J2R020Z4.0-HXT	03205246	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,2	0,9	2,69	4	■
JME144010J3R010Z4.0-HXT	03205218	3	J	1,0	4,0	0,75	40,0	5,0	0,95	0,1	0,9	8,3	4	■
JME144015J3R010Z4.0-HXT	03205230	3	J	1,5	4,0	1,125	50,0	7,5	1,45	0,1	0,9	6,06	4	■
JME144020J3R005Z4.0-HXT	03205235	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,05	0,9	4,29	4	■
JME144020J3R010Z4.0-HXT	03205237	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,1	0,9	4,31	4	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JME144 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				1.0	1.2	1.5	2.0	3	
H3	M/A	0.0500 *0,0500*	0.095 *0,095*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	95 (65 — 120) *310 (220 — 390)*
H5	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H7	M/A	0.0500 *0,0500*	0.095 *0,095*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	95 (65 — 120) *310 (220 — 390)*
H8	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H11	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	210 (180 — 240) *690 (600 — 780)*
H12	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	190 (160 — 220) *620 (530 — 720)*
H21	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H31	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	125 (110 — 140) *410 (370 — 450)*

Parametri di taglio – JME144 Scanalatura

SMG		a_p/DC	f_z					v_c
			1.0	1.2	1.5	2.0	3,0	
H3	M/A	0.0090 *0,0090*	0.0065 *0,00026*	0.0075 *0,00030*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	65 (43 — 84) *215 (150 — 270)*
H5	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H7	M/A	0.0090 *0,0090*	0.0065 *0,00026*	0.0075 *0,00030*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	65 (43 — 84) *215 (150 — 270)*
H8	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H11	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	150 (130 — 170) *490 (430 — 550)*
H12	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	135 (120 — 160) *445 (400 — 520)*
H21	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H31	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	90 (73 — 100) *295 (240 — 320)*

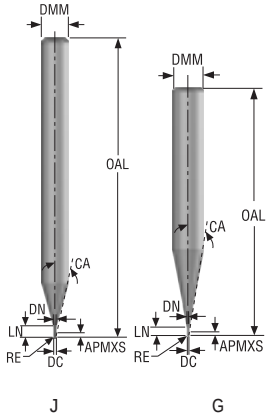
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JMB112

Miniaturizzato – Acciaio temprato – A testa sferica – 2 Eliche – Cilindrico





J G



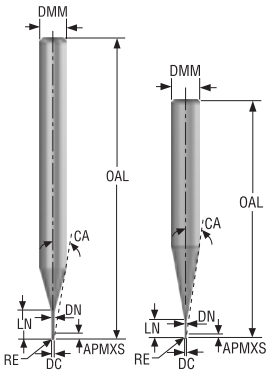
- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= <Ø0,6= 0/-0,008 mm
- DC= ≥Ø0,6= 0/-0,01 mm
- RE= <Ø0,5= ±0,004 mm
- RE= ≥Ø1,5= ±0,005 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm				
JMB112002G1BZ2.0-HXT	03204964	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,1	0,0	15,11	2	■
JMB112003G1BZ2.0-HXT	03204966	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,15	0,0	14,77	2	■
JMB112004G1BZ2.0-HXT	03204968	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,2	0,0	14,32	2	■
JMB112005G1BZ2.0-HXT	03204970	1	G	0,5	4,0	0,5	40,0	1,0	0,46	0,25	0,0	13,97	2	■
JMB112006G1BZ2.0-HXT	03204977	1	G	0,6	4,0	0,6	40,0	1,2	0,56	0,3	0,0	13,64	2	■
JMB112008G1BZ2.0-HXT	03204984	1	G	0,8	6,0	0,8	50,0	1,6	0,76	0,4	0,0	13,96	2	■
JMB112010G1BZ2.0-HXT	03204991	1	G	1,0	6,0	1,0	50,0	2,0	0,95	0,5	0,0	13,49	2	■
JMB112012G1BZ2.0-HXT	03205000	1	G	1,2	6,0	1,2	50,0	2,4	1,15	0,6	0,0	13,02	2	■
JMB112015G1BZ2.0-HXT	03205009	1	G	1,5	6,0	1,5	50,0	3,0	1,45	0,75	0,0	12,2	2	■
JMB112002J2BZ2.0-HXT	03204965	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,1	0,9	14,33	2	■
JMB112003J2BZ2.0-HXT	03204967	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,15	0,9	13,85	2	■
JMB112004J2BZ2.0-HXT	03204969	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,2	0,9	13,3	2	■
JMB112005J2BZ2.0-HXT	03204971	2	J	0,5	4,0	0,5	40,0	1,5	0,46	0,25	0,9	12,85	2	■
JMB112005G2BZ2.0-HXT	03204972	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	0,0	9,91	2	■
JMB112006J2BZ2.0-HXT	03204978	2	J	0,6	4,0	0,6	50,0	2,0	0,56	0,3	0,9	12,09	2	■
JMB112006G2BZ2.0-HXT	03204979	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	0,0	9,62	2	■
JMB112008J2BZ2.0-HXT	03204985	2	J	0,8	4,0	0,8	50,0	2,5	0,76	0,4	0,9	11,34	2	■
JMB112008G2BZ2.0-HXT	03204986	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	0,0	9,33	2	■
JMB112010J2BZ2.0-HXT	03204992	2	J	1,0	4,0	1,0	40,0	4,0	0,95	0,5	0,9	9,49	2	■
JMB112010G2BZ2.0-HXT	03204993	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	0,0	8,49	2	■
JMB112012J2BZ2.0-HXT	03205001	2	J	1,2	4,0	1,2	50,0	4,5	1,15	0,6	0,9	8,83	2	■
JMB112012G2BZ2.0-HXT	03205002	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	0,0	8,21	2	■
JMB112015J2BZ2.0-HXT	03205010	2	J	1,5	4,0	1,5	50,0	5,0	1,45	0,75	0,9	8,1	2	■
JMB112015G2BZ2.0-HXT	03205011	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	0,0	10,14	2	■
JMB112020J2BZ2.0-HXT	03205024	2	J	2,0	4,0	2,0	50,0	6,0	1,94	1,0	0,9	6,6	2	■
JMB112020G2BZ2.0-HXT	03205025	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	0,0	9,1	2	■
JMB112030J2BZ2.0-HXT	03205037	2	J	3,0	4,0	3,0	50,0	9,0	2,85	1,5	0,9	3,04	2	■
JMB112030G2BZ2.0-HXT	03205038	2	G	3,0	6,0	3,0	50,0	9,0	2,85	1,5	0,0	6,35	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

JMB112

Miniaturizzato – Acciaio temprato – A testa sferica – 2 Eliche – Cilindrico



J G





- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= <Ø0,6= 0/-0,008 mm
- DC= ≥Ø0,6= 0/-0,01 mm
- RE= <Ø0,5= ±0,004 mm
- RE= ≥Ø1,5= ±0,005 mm

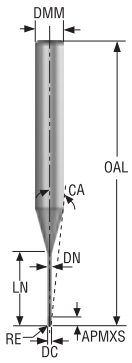
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm				
JMB112005J3BZ2.0-HXT	03204973	3	J	0,5	4,0	0,5	40,0	2,5	0,46	0,25	0,9	11,49	2	■
JMB112005G3BZ2.0-HXT	03204974	3	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	0,0	8,81	2	■
JMB112006J3BZ2.0-HXT	03204980	3	J	0,6	4,0	0,6	40,0	3,0	0,56	0,3	0,9	10,83	2	■
JMB112006G3BZ2.0-HXT	03204981	3	G	0,6	6,0	0,6	50,0	4,0	0,56	0,3	0,0	8,56	2	■
JMB112008J3BZ2.0-HXT	03204987	3	J	0,8	4,0	0,8	40,0	4,0	0,76	0,4	0,9	9,67	2	■
JMB112008G3BZ2.0-HXT	03204988	3	G	0,8	6,0	0,8	50,0	5,5	0,76	0,4	0,0	10,1	2	■
JMB112010J3BZ2.0-HXT	03204994	3	J	1,0	4,0	1,0	40,0	5,0	0,95	0,5	0,9	8,6	2	■
JMB112010G3BZ2.0-HXT	03204995	3	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	0,0	9,06	2	■
JMB112012J3BZ2.0-HXT	03205003	3	J	1,2	4,0	1,2	50,0	6,0	1,15	0,6	0,9	7,65	2	■
JMB112012G3BZ2.0-HXT	03205004	3	G	1,2	6,0	1,2	50,0	8,0	1,15	0,6	0,0	8,42	2	■
JMB112015J3BZ2.0-HXT	03205012	3	J	1,5	4,0	1,5	40,0	7,5	1,45	0,75	0,9	6,4	2	■
JMB112015G3BZ2.0-HXT	03205013	3	G	1,5	6,0	1,5	50,0	10,0	1,45	0,75	0,0	7,31	2	■
JMB112020J3BZ2.0-HXT	03205026	3	J	2,0	4,0	2,0	50,0	10,0	1,94	1,0	0,9	4,61	2	■
JMB112020G3BZ2.0-HXT	03205027	3	G	2,0	6,0	2,0	50,0	12,0	1,94	1,0	0,0	6,19	2	■
JMB112030J3BZ2.0-HXT	03205039	3	J	3,0	4,0	3,0	50,0	15,0	2,85	1,5	0,9	1,91	2	■
JMB112030G3BZ2.0-HXT	03205040	3	G	3,0	6,0	3,0	60,0	15,0	2,85	1,5	0,0	4,41	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a αη (lαη, rif.)*

JMB112

Miniaturizzato – Acciaio temprato – A testa sferica – 2 Eliche – Cilindrico





G

- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= <Ø0,6= 0/-0,008 mm
- DC= ≥Ø0,6= 0/-0,01 mm
- RE= <Ø0,5= ±0,004 mm
- RE= ≥Ø1,5= ±0,005 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm				
JMB112006G4BZ2.0-HXT	03204983	4	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	0,0	9,86	2	■
JMB112008G4BZ2.0-HXT	03204990	4	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	0,0	8,65	2	■
JMB112010G4BZ2.0-HXT	03204998	4	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	0,0	7,63	2	■
JMB112015G4BZ2.0-HXT	03205015	4	G	1,5	6,0	1,5	70,0	15,0	1,45	0,75	0,0	5,7	2	■
JMB112020G4BZ2.0-HXT	03205029	4	G	2,0	6,0	2,0	60,0	18,0	1,94	1,0	0,0	4,68	2	■
JMB112030G4BZ2.0-HXT	03205042	4	G	3,0	6,0	3,0	80,0	30,0	2,85	1,5	0,0	2,51	2	■
JMB112010G6BZ2.0-HXT	03205054	6	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	0,0	4,99	2	■

■ Prodotto standard.

Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JMB112 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z													v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	1,8	2	2,5	3	
H3	M	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	150 (130 — 170) *490 (430 — 550)*
H5	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (200 — 240) *720 (660 — 780)*
H7	M	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	150 (130 — 170) *490 (430 — 550)*
H8	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	220 (200 — 240) *720 (660 — 780)*
H11	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 310) *920 (830 — 1000)*
H12	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	255 (230 — 280) *840 (760 — 910)*
H21	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	220 (200 — 240) *720 (660 — 780)*
H31	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.036 *0,0014*	0.042 *0,0017*	0.044 *0,0017*	165 (150 — 180) *540 (500 — 590)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi



PLASTICA E CFRP

Seco presenta una gamma completa di frese in metallo duro integrale per la lavorazione di plastiche rinforzate con fibra di carbonio e di vetro. È composta da frese rivestite al diamante, non rivestite e con PCD; comprende differenti geometrie e differenti soluzioni con PCD saldobrasato. Questa gamma è composta da utensili ottimizzati per condizioni di lavorazione difficoltose o per materiali impegnativi.

- JC860, JC870, JC871, JC899, JPD890, J93F e J28 per tipo con tagliente affilato.
- JC845, JC880, JC885 e JC898 per tipo con raggio.
- JC875, JC876, JC877 e JPD880 per tipo con smusso a 45°.
- JC850 e JPD850 per tipo a testa sferica.

Selezione utensile plastica e CFRP

						
Nome		JC845	JC850	JC860	JC870	JC871
Pag.		420	422	424	426	432
Famiglia		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Tipo di fresa						
Attacco	Cilindrico	■	■	■	■	■
	Weldon					
Numero di eliche		3	4	5,6,8,9		
Adduz. refrig. interna						
	Metrico	6-8	3-12	6-12	3-12	3-12
	Pollici				1/4 -1/2	1/4 -1/2
Lunghezze disponibili		2	2	2	2	2
Operazione						
						
						
SMG						
TS1						
TS2		●	●	●	●	●
TS3		●	●	●	●	●
TP1						
TP2		●	●	●	●	●
TP3		●	●	●	●	●
Nido d'ape*				●	●	●

■ Prodotto standard ☐ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

Selezione utensile plastica e CFRP

								
Nome		JC875	JC876	JC877	JC880	JC885	JC898	JC899
Pag.		438	442	446	450	452	454	456
Famiglia		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Tipo di fresa								
Attacco	Cilindrico	■	■	■	■	■	■	■
	Weldon							
Numero di eliche		5,6,10	6,8,10,12,14	6,8,10,12,14	4	4	4	4
Adduz. refrig. interna							■	
	Metrico	3-10	3-12	3-12	4-20	4-10	8-15	8,5-14,8
	Pollici	1/4 -1/2	1/4-1/2	1/4-1/2				
Lunghezze disponibili		2	2	2	2	2	2	2
Operazione								
								
SMG								
TS1								
TS2		●	●	●	●	●		
TS3		●	●	●	●	●		
TP1								
TP2		●	●	●	●	●		
TP3		●	●	●	●	●		
Nido d'ape*								

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

Selezione utensile plastica e CFRP

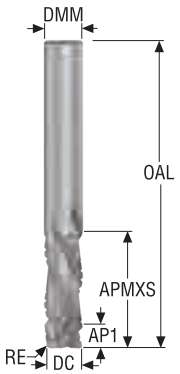
						
Nome		JPD850	JPD880	JPD890	J93F	J28
Pag.		459	461	463	465	467
Famiglia		PCD	PCD	PCD	VHM	VHM
Tipo di fresa						
Attacco	Cilindrico	■	■	■	■	■
	Weldon					
Numero di eliche		2	2	2	2	1
Adduz. refrig. interna		■	■	■		
	Metrico	4-10	6-16	6-12	1,5-20	3-12
	Pollici					
Lunghezze disponibili		2	2,3	2,3	1,2,3,4	2
Operazione						
						
						
SMG						
TS1					●	●
TS2		●	●	●		
TS3		●	●	●		
TP1					●	
TP2		●	●	●		
TP3		●	●	●		
Nido d'ape*						

■ Prodotto standard ☐ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

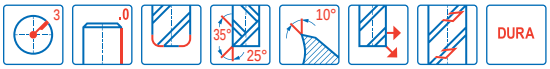
JC845

Compositi – Compressione – 3 Eliche – Cilindrico – Raggio di punta





- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	AP1	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm		
JC845060D2R050.0Z3-DURA	02843006	2	D	6,0	6,0	18,0	4,2	65,0	0,5	3	■
JC845080D2R050.0Z3-DURA	02843007	2	D	8,0	8,0	24,0	5,2	75,0	0,5	3	■
JC845100D2R050.0Z3-DURA	02843008	2	D	10,0	10,0	30,0	6,3	85,0	0,5	3	■
JC845120D2R050.0Z5-DURA	02843009	2	D	12,0	12,0	36,0	8,3	100,0	0,5	5	■

■ Prodotto standard.

Parametri di taglio – JC845 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.376 *0,376*	1.5 *1,5*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	185 (130 — 240) *610 (430 — 780)*
TS3	E/A/D	0.376 *0,376*	1.4 *1,4*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	125 (87 — 160) *410 (290 — 520)*
TP2	E/A/D	0.376 *0,376*	1.5 *1,5*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	125 (87 — 180) *410 (290 — 590)*
TP3	E/A/D	0.376 *0,376*	1.4 *1,4*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	85 (62 — 110) *280 (210 — 360)*

Parametri di taglio – JC845 Scanalatura

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	160 (110 — 210) *520 (370 — 680)*
TS3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	105 (76 — 130) *345 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	105 (75 — 160) *345 (250 — 520)*
TP3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	75 (54 — 96) *245 (180 — 310)*

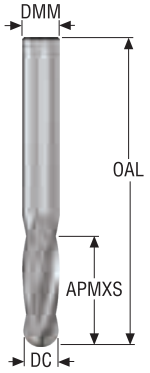
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JC850

Compositi – A testa sferica – 4 Eliche – Cilindrico





D

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
				mm	mm	mm	mm		
850030Z4.0-DURA	02719949	2	D	3,0	3,0	9,0	50,0	4	■
850040Z4.0-DURA	02719952	2	D	4,0	4,0	12,0	50,0	4	■
850060Z4.0-DURA	02719953	2	D	6,0	6,0	18,0	65,0	4	■
850080Z4.0-DURA	02719954	2	D	8,0	8,0	24,0	70,0	4	■
850100Z4.0-DURA	02719955	2	D	10,0	10,0	30,0	85,0	4	■
850120Z4.0-DURA	02719956	2	D	12,0	12,0	36,0	100,0	4	■

■ Prodotto standard.

Parametri di taglio – JC850 Copiatura

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.200 *0,200*	2.0 *2,0*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	265 (220 — 320) *870 (730 — 1000)*
TS3	E/A/D	0.200 *0,200*	2.0 *2,0*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	160 (110 — 210) *520 (370 — 680)*
TP2	E/A/D	0.200 *0,200*	2.0 *2,0*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	215 (110 — 320) *710 (370 — 1000)*
TP3	E/A/D	0.200 *0,200*	2.0 *2,0*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	105 (54 — 150) *345 (180 — 490)*

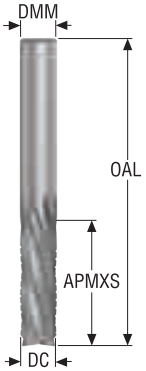
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JC860

Nido d'ape – Spallamento – 5-9 Eliche – Cilindrico – Spigolo vivo





D

- Tolleranze:
- DMM=h5
- DC= -0.02-0.08 mm
- FCEDC=denti frontali



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Cilindrico
				mm	mm	mm	mm			
860060Z5.0-DURA	02720211	2	D	6,0	6,0	18,0	70,0	2	5	■
860080Z6.0-DURA	02720212	2	D	8,0	8,0	24,0	80,0	2	6	■
860100Z8.0-DURA	02720216	2	D	10,0	10,0	30,0	90,0	2	8	■
860120Z9.0-DURA	02720217	2	D	12,0	12,0	36,0	110,0	2	9	■

■ Prodotto standard.

Parametri di taglio – JC860 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	235 (200 — 270) *770 (660 — 880)*
TS3	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	160 (130 — 180) *520 (430 — 590)*
TP2	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	165 (130 — 200) *540 (430 — 650)*
TP3	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	65 (50 — 110) *215 (170 — 360)*

Parametri di taglio – JC860 Scanalatura

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (85 — 120) *345 (280 — 390)*
TP2	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	110 (84 — 130) *360 (280 — 420)*
TP3	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	44 (34 — 78) *145 (120 — 250)*

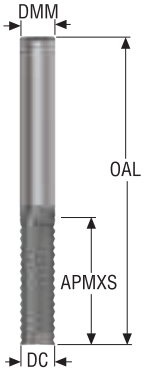
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JC870

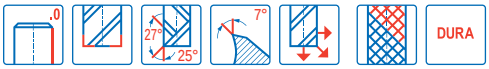
Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo





D

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,08 mm
- Sgrossatore (downcut)*



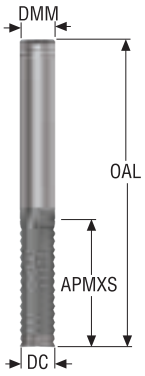
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Cilindrico
				mm	mm	mm	mm			
870030.0-DURA	02720219	2	D	3,0	3,0	9,0	50,0	2	8	■
870040.0-DURA	02720226	2	D	4,0	4,0	12,0	50,0	2	8	■
870060.0-DURA	02720228	2	D	6,0	6,0	18,0	65,0	2	10	■
870080.0-DURA	02720229	2	D	8,0	8,0	24,0	75,0	2	12	■
870100.0-DURA	02720231	2	D	10,0	10,0	30,0	85,0	2	12	■
870120.0-DURA	02720232	2	D	12,0	12,0	36,0	100,0	2	14	■

■ Prodotto standard.

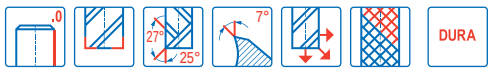
*Il downcut indica le geometrie dell'elica che vengono combinate per creare piccole forze verso il basso che contribuiscono a mantenere il serraggio dei componenti, in particolare nei casi in cui viene utilizzato il bloccaggio a sottovuoto.

JC870

Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo – Pollici



D





- Tolleranze:
- DMM= h5
- DC= -.0008/-.0030 *Inch*
- Sgrossatore (downcut)*

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	FCEDC	Cilindrico
				inch	inch	inch	inch		
8700250.0-DURA	02720784	2	D	0.250	0.250	0.750	2.250	2	■
8700375.0-DURA	02720785	2	D	0.375	0.375	1.250	3.500	2	■

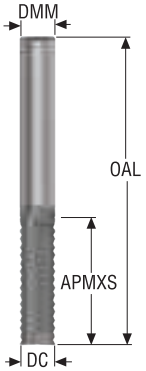
■ Prodotto standard.

*Il downcut indica le geometrie dell'elica che vengono combinate per creare piccole forze verso il basso che contribuiscono a mantenere il serraggio dei componenti, in particolare nei casi in cui viene utilizzato il bloccaggio a sottovuoto.

JC870

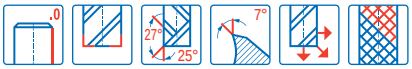
Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo





D

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,08 mm
- Sgrossatore (downcut)*



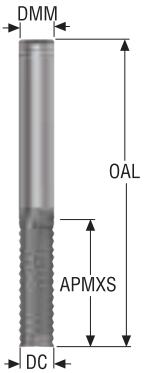
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Cilindrico
				mm	mm	mm	mm			
870030.0	02742789	2	D	3,0	3,0	9,0	50,0	2	8	■
870040.0	02742792	2	D	4,0	4,0	12,0	50,0	2	8	■
870050.0	02742793	2	D	5,0	5,0	15,0	50,0	2	10	■
870060.0	02742794	2	D	6,0	6,0	18,0	65,0	2	10	■
870080.0	02742795	2	D	8,0	8,0	24,0	75,0	2	12	■
870100.0	02742796	2	D	10,0	10,0	30,0	85,0	2	12	■
870120.0	02742797	2	D	12,0	12,0	36,0	100,0	2	14	■

■ Prodotto standard.

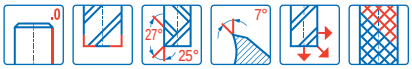
*Il downcut indica le geometrie dell'elica che vengono combinate per creare piccole forze verso il basso che contribuiscono a mantenere il serraggio dei componenti, in particolare nei casi in cui viene utilizzato il bloccaggio a sottovuoto.

JC870

Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo – Pollici



D





- Tolleranze:
- DMM= h5
- DC=- .0008 / -.0015 *pollici*
- Sgrossatore (downcut)*

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Cilindrico
				inch	inch	inch	inch			
8700250.0	02742798	2	D	0.250	0.250	0.750	2.250	2	10	■
8700500.0	02742800	2	D	0.500	0.500	1.500	4.250	2	14	■

■ Prodotto standard.

*Il downcut indica le geometrie dell'elica che vengono combinate per creare piccole forze verso il basso che contribuiscono a mantenere il serraggio dei componenti, in particolare nei casi in cui viene utilizzato il bloccaggio a sottovuoto.

Parametri di taglio – JC870 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Parametri di taglio – JC870 Scanalatura

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	39 (30 — 68) *130 (99 — 220)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JC870 Contornatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Parametri di taglio – JC870 Scanalatura – Pollici

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	39 (30 — 68) *130 (99 — 220)*

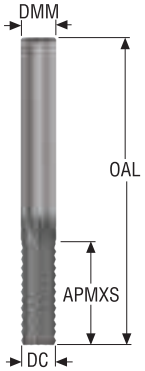
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JC871

Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo





D

- Tolleranze:
- DMM= h5
- DC= -0,02/-0,08 mm
- Sgrossatore (downcut)*



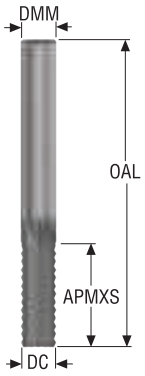
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
				mm	mm	mm	mm		
871030.0-DURA	02720249	2	D	3,0	3,0	9,0	50,0	8	■
871040.0-DURA	02720250	2	D	4,0	4,0	12,0	50,0	8	■
871060.0-DURA	02720252	2	D	6,0	6,0	18,0	65,0	10	■
871080.0-DURA	02720253	2	D	8,0	8,0	24,0	75,0	12	■
871100.0-DURA	02720254	2	D	10,0	10,0	30,0	85,0	12	■
871120.0-DURA	02720257	2	D	12,0	12,0	36,0	100,0	14	■

■ Prodotto standard.

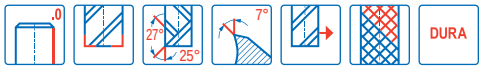
*Il downcut indica le geometrie dell'elica che vengono combinate per creare piccole forze verso il basso che contribuiscono a mantenere il serraggio dei componenti, in particolare nei casi in cui viene utilizzato il bloccaggio a sottovuoto.

JC871

Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo – Pollici



D





- Tolleranze:
- DMM= h5
- DC= -.0008 / -.0015 *pollici*
- Sgrossatore (downcut)*

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
				inch	inch	inch	inch		
8710250.0-DURA	02720788	2	D	0.250	0.250	0.750	2.250	10	■
8710375.0-DURA	02720789	2	D	0.375	0.375	1.250	3.500	12	■
8710500.0-DURA	02720790	2	D	0.500	0.500	1.500	4.250	14	■

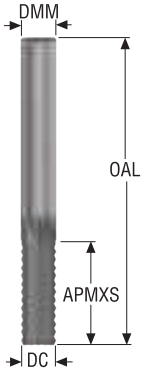
■ Prodotto standard.

*Il downcut indica le geometrie dell'elica che vengono combinate per creare piccole forze verso il basso che contribuiscono a mantenere il serraggio dei componenti, in particolare nei casi in cui viene utilizzato il bloccaggio a sottovuoto.

JC871

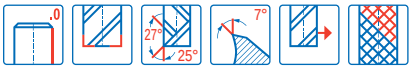
Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo





D

- Tolleranze:
- DMM= h5
- DC= -0,02/-0,08 mm
- Sgrossatore (downcut)*



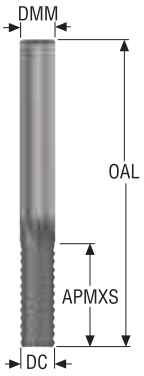
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
				mm	mm	mm	mm		
871030.0	02742801	2	D	3,0	3,0	9,0	50,0	8	■
871040.0	02742803	2	D	4,0	4,0	12,0	50,0	8	■
871060.0	02742806	2	D	6,0	6,0	18,0	65,0	10	■
871080.0	02742807	2	D	8,0	8,0	24,0	75,0	12	■
871100.0	02742808	2	D	10,0	10,0	30,0	85,0	12	■
871120.0	02742809	2	D	12,0	12,0	36,0	100,0	14	■

■ Prodotto standard.

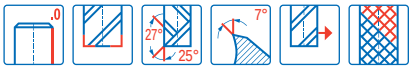
*Il downcut indica le geometrie dell'elica che vengono combinate per creare piccole forze verso il basso che contribuiscono a mantenere il serraggio dei componenti, in particolare nei casi in cui viene utilizzato il bloccaggio a sottovuoto.

JC871

Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo – Pollici



D





- Tolleranze:
- DMM=h5
- DC=-0,02/-0,08 mm
- Sgrossatore (downcut)*

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
				inch	inch	inch	inch		
8710500.0	02742814	2	D	0.500	0.500	1.500	4.250	14	■

■ Prodotto standard.
*Il downcut indica le geometrie dell'elica che vengono combinate per creare piccole forze verso il basso che contribuiscono a mantenere il serraggio dei componenti, in particolare nei casi in cui viene utilizzato il bloccaggio a sottovuoto.

Parametri di taglio – JC871 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Parametri di taglio – JC871 Scanalatura

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	155 (140 — 180) *510 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (84 — 120) *345 (280 — 390)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (79 — 130) *345 (260 — 420)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	40 (31 — 70) *130 (110 — 220)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JC871 Contornatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Parametri di taglio – JC871 Scanalatura – Pollici

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	39 (30 — 68) *130 (99 — 220)*

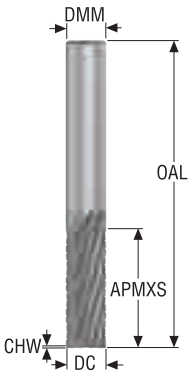
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JC875

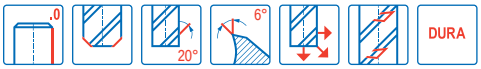
Compositi – Spallamento – 5-10 Eliche – Cilindrico – Smusso





D

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,08 mm

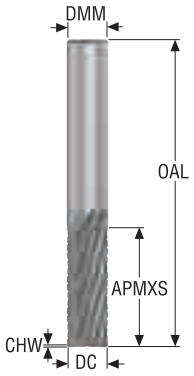


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JC875030D2.0-DURA	02968155	2	D	3,0	3,0	9,0	50,0	0,05	5	■
JC875050D2.0-DURA	02968157	2	D	5,0	5,0	15,0	50,0	0,05	6	■
JC875060D2.0-DURA	02968158	2	D	6,0	6,0	18,0	65,0	0,06	6	■
JC875080D2.0-DURA	02968159	2	D	8,0	8,0	24,0	70,0	0,08	10	■
JC875100D2.0-DURA	02968160	2	D	10,0	10,0	30,0	80,0	0,1	10	■

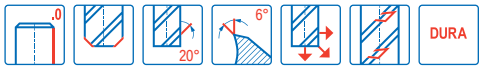
■ Prodotto standard.

JC875

Compositi – Spallamento – 6-10 Eliche – Cilindrico – Smusso – Pollici



D





- Tolleranze:
- DMM=h5
- DC= -.0008/-.0030 *Inch*

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
				inch	inch	inch	inch	inch		
JC875.250D2.0-DURA	02968162	2	D	0.250	0.250	0.750	3.000	0.002	6	■

■ Prodotto standard.

Parametri di taglio – JC875 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				3	5	6	8	10	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	190 (160 — 220) *620 (530 — 720)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	130 (96 — 150) *425 (320 — 490)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	50 (39 — 89) *165 (130 — 290)*

Parametri di taglio – JC875 Scanalatura

SMG		a_p/DC	f_z					v_c
			3	5	6	8	10	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	105 (86 — 120) *345 (290 — 390)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	105 (81 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	42 (33 — 74) *140 (110 — 240)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JC875 Contornatura – Pollici

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	190 (160 — 220) *620 (530 — 720)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	130 (96 — 150) *425 (320 — 490)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	50 (39 — 89) *165 (130 — 290)*

Parametri di taglio – JC875 Scanalatura – Pollici

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (86 — 120) *345 (290 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (81 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	42 (33 — 74) *140 (110 — 240)*

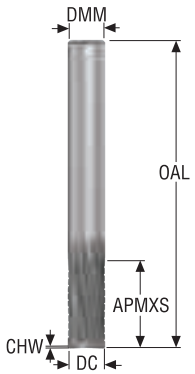
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

JC876

Compositi – Spallamento – 6-14 Eliche – Cilindrico – Smusso





D

- Tolleranze:
- DMM=h5
- DC=-0,02 -0,08 mm
- Elica sinistra

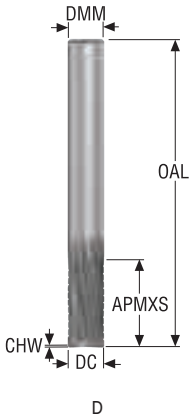


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JC876030D2C.0Z6-DURA	03135004	2	D	3,0	3,0	7,5	50,0	0,035	6	■
JC876040D2C.0Z6-DURA	03135005	2	D	4,0	4,0	10,0	54,0	0,045	6	■
JC876060D2C.0Z8-DURA	03135006	2	D	6,0	6,0	15,0	62,0	0,075	8	■
JC876060D2C.0Z10-DURA	03135007	2	D	6,0	6,0	15,0	62,0	0,075	10	■
JC876080D2C.0Z10-DURA	03135009	2	D	8,0	8,0	20,0	70,0	0,1	10	■
JC876100D2C.0Z12-DURA	03135011	2	D	10,0	10,0	25,0	82,0	0,125	12	■
JC876120D2C.0Z14-DURA	03135012	2	D	12,0	12,0	30,0	95,0	0,15	14	■

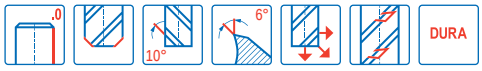
■ Prodotto standard.

JC876

Compositi – Spallamento – 8-14 Eliche – Cilindrico – Smusso – Pollici



D





- Tolleranze:
- DMM=h5
- DC= -.0008/-.0030 *Inch*
- Elica sinistra

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
				inch	inch	inch	inch	inch		
JC876.250D2C.0Z8-DURA	03135125	2	D	0.250	0.250	0.625	2.500	0.003	8	■
JC876.375D2C.0Z12-DURA	03135127	2	D	0.375	0.375	1.000	3.000	0.005	12	■

■ Prodotto standard.

Parametri di taglio – JC876 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	220 (190 — 250) *720 (630 — 820)*
TS3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	145 (120 — 170) *475 (400 — 550)*
TP2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	145 (110 — 180) *475 (370 — 590)*
TP3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	75 (44 — 100) *245 (150 — 320)*

Parametri di taglio – JC876 Scanalatura

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	115 (94 — 140) *375 (310 — 450)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	60 (36 — 81) *195 (120 — 260)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JC876 Contornatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	220 (190 — 250) *720 (630 — 820)*
TS3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	145 (120 — 170) *475 (400 — 550)*
TP2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	145 (110 — 180) *475 (370 — 590)*
TP3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	75 (44 — 100) *245 (150 — 320)*

Parametri di taglio – JC876 Scanalatura – Pollici

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	115 (94 — 140) *375 (310 — 450)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	60 (36 — 81) *195 (120 — 260)*

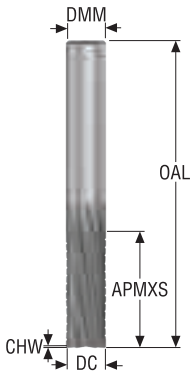
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

JC877

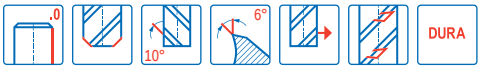
Compositi – Spallamento – 6-14 Eliche – Cilindrico – Smusso





D

- Tolleranze:
- DMM=h5
- DC=-0,02, -0,08 mm
- Elica sinistra

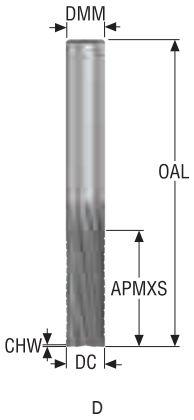


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JC877030D2C.0Z6-DURA	03135013	2	D	3,0	3,0	9,0	50,0	0,035	6	■
JC877040D2C.0Z6-DURA	03135014	2	D	4,0	4,0	12,0	54,0	0,045	6	■
JC877060D2C.0Z8-DURA	03135015	2	D	6,0	6,0	18,0	62,0	0,075	8	■
JC877060D2C.0Z10-DURA	03135016	2	D	6,0	6,0	18,0	62,0	0,075	10	■
JC877080D2C.0Z10-DURA	03135018	2	D	8,0	8,0	24,0	70,0	0,1	10	■
JC877100D2C.0Z12-DURA	03135020	2	D	10,0	10,0	30,0	82,0	0,125	12	■
JC877120D2C.0Z14-DURA	03135021	2	D	12,0	12,0	36,0	95,0	0,15	14	■

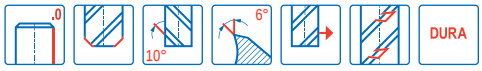
■ Prodotto standard.

JC877

Compositi – Spallamento – 8-14 Eliche – Cilindrico – Smusso – Pollici



D





- Tolleranze:
- DMM=h5
- DC= -.0008/-.0030 *Inch*
- Elica sinistra

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Cilindrico
				inch	inch	inch	inch	inch		
JC877.250D2C.0Z8-DURA	03135129	2	D	0.250	0.250	0.750	2.500	0.003	8	■

■ Prodotto standard.

Parametri di taglio – JC877 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	195 (170 — 220) *640 (560 — 720)*
TS3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	130 (98 — 160) *425 (330 — 520)*
TP3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	65 (40 — 91) *215 (140 — 290)*

Parametri di taglio – JC877 Scanalatura

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
TS2	E/A/D	1,0 *1,0*	0,0060 *0,0060*	0,0080 *0,0080*	0,012 *0,012*	0,016 *0,016*	0,020 *0,020*	0,025 *0,025*	170 (150 — 200) *115 (92 — 130)*
TP2	E/A/D	1,0 *1,0*	0,0060 *0,0060*	0,0080 *0,0080*	0,012 *0,012*	0,016 *0,016*	0,020 *0,020*	0,025 *0,025*	115 (86 — 140) *55 (35 — 80)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – JC877 Contornatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	195 (170 — 220) *640 (560 — 720)*
TS3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	130 (98 — 160) *425 (330 — 520)*
TP3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	65 (40 — 91) *215 (140 — 290)*

Parametri di taglio – JC877 Scanalatura – Pollici

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (85 — 120) *345 (280 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (80 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	55 (32 — 74) *180 (110 — 240)*

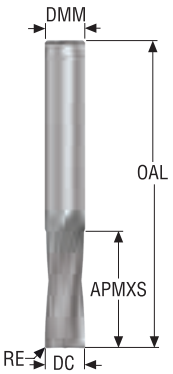
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (*in*/dente)
a_p = mm/DC (*in*/DC) = fattore
a_e = mm/DC (*in*/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

JC880

Compositi – Spallamento – 4 Eliche – Cilindrico – Raggio di punta





D

- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
880040R020Z4.0-DURA	02843012	2	D	4,0	4,0	12,0	50,0	0,2	4	■
880050R020Z4.0-DURA	02843013	2	D	5,0	5,0	15,0	50,0	0,2	4	■
880060R020Z4.0-DURA	02720258	2	D	6,0	6,0	18,0	65,0	0,2	4	■
880080R020Z4.0-DURA	02720259	2	D	8,0	8,0	24,0	70,0	0,2	4	■
880100R020Z4.0-DURA	02720260	2	D	10,0	10,0	30,0	80,0	0,2	4	■
880120R020Z4.0-DURA	02720261	2	D	12,0	12,0	36,0	100,0	0,2	4	■
880160R020Z4.0-DURA	02720262	2	D	16,0	16,0	48,0	110,0	0,2	4	■
880200R020Z4.0-DURA	02720263	2	D	20,0	20,0	60,0	130,0	0,2	4	■

■ Prodotto standard.

Parametri di taglio – JC880 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z							v_c
				4	6	8	10	12	16	20	
TS2	E/A/D	0.400 *0,400*	1.9 *1,9*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	190 (160 — 210) *620 (530 — 680)*
TS3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	130 (93 — 170) *425 (310 — 550)*
TP2	E/A/D	0.400 *0,400*	1.9 *1,9*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	125 (95 — 150) *410 (320 — 490)*
TP3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (40 — 92) *165 (140 — 300)*

Parametri di taglio – JC880 Scanalatura

SMG		a_p/DC	f_z								v_c
			4	5	6	8	10	12	16	20	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (130 — 170) *490 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	100 (71 — 130) *330 (240 — 420)*
TP2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (76 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	40 (31 — 70) *130 (110 — 220)*

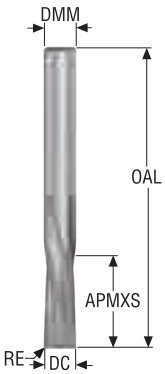
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JC885

Compositi – Spallamento – 4 Eliche – Cilindrico – Raggio di punta





D



- Tolleranze:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm
- Elica sinistra

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
JC885040D2R020.0Z4-DURA	02843014	2	D	4,0	4,0	12,0	50,0	0,2	4	■
JC885060D2R020.0Z4-DURA	02843016	2	D	6,0	6,0	18,0	70,0	0,2	4	■
JC885080D2R020.0Z4-DURA	02843017	2	D	8,0	8,0	24,0	80,0	0,2	4	■

■ Prodotto standard.

Parametri di taglio – JC885 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				4	6	8	10	
TS2	E/A/D	0.400 *0,400*	2.0 *2,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	190 (160 — 210) *620 (530 — 680)*
TS3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	130 (99 — 170) *425 (330 — 550)*
TP2	E/A/D	0.400 *0,400*	2.0 *2,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	125 (94 — 150) *410 (310 — 490)*
TP3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	50 (33 — 92) *165 (110 — 300)*

Parametri di taglio – JC885 Scanalatura

SMG		a_p/DC	f_z				v_c
			4	6	8	10	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	150 (130 — 170) *490 (430 — 550)*
TS3	E/A/D	0.70 *0,70*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	100 (76 — 130) *330 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	100 (75 — 120) *330 (250 — 390)*
TP3	E/A/D	0.70 *0,70*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	40 (26 — 70) *130 (86 — 220)*

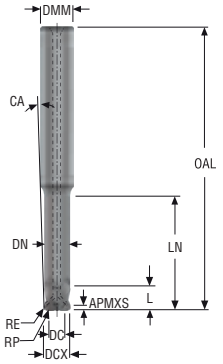
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JC898

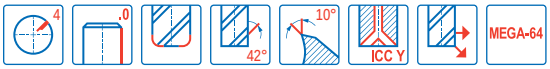
Elevato avanzamento – Materiali sandwich – Raggio di punta – 4 Eliche – Cilindrico – Raggio di punta





G

- Tolleranze:
- DMM=h5
- DC= e7
- RE= ±0,1 mm



Codice di ordinazione	Codice prodotto	Indice di lung-hezza	Forma utensile	Adduz. refrig. interna	DC	DCX	DMM	APMXS	L	OAL	LN	DN	RE	RP	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm	mm	mm	mm			
JC898080G3HZ4A.0-M64	03245308	3	G	■	4,0	8,0	10,0	0,43	6,0	88,0	35,0	7,6	0,5	0,87	1,5 °	4	■
JC898150G3HZ4A.0-M64	03245309	3	G	■	7,5	15,0	16,0	0,796	12,0	125,0	70,0	14,3	0,94	1,63	0,4 °	4	■

■ Prodotto standard.

Parametri di taglio – JC898 Contornatura

SMG		a_e/DCX	a_p/DCX	f_z		v_c
				8	15	
S12+TS2/TP2	D	0,30 *0,30*	0,020 *0,020*	0,1 *0,0040*	0,15 *0,0060*	90 (80-120) *300 (270-400)*
TP2+TS2/TP2	D	0,30 *0,30*	0,034 *0,034*	0,12 *0,0048*	0,25 *0,0100*	120 (90-150) *400 (300-490)*

Parametri di taglio – JC898 Scanalatura

SMG		a_p/DCX	f_z		v_c
			8	15	
S12+TP2/TS2	D	0.020 *0.020*	0.08 *0,0032*	0.10 *0,0040*	90 (80-120) *300 (270-400)*
N1+TP2/TS2	D	0.034 *0.034*	0.1 *0,0040*	0.10 *0,0040*	120 (90-150) *400 (300-490)*

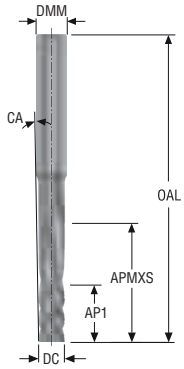
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JC899

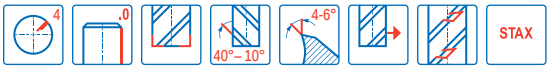
Alte prestazioni – Materiali sandwich – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo





F

- Tolleranze:
- DMM=h5
- DC= ±0,02 mm

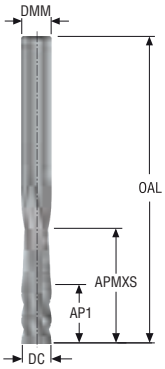


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	AP1	OAL	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm			
JC899085F3S.0Z4-STAX	03245482	3	F	■	8,5	10,0	38,0	19,0	100,0	0,8 °	4	■
JC899148F3S.0Z4-STAX	03245480	3	F	■	14,8	16,0	55,0	30,0	150,0	0,53 °	4	■
JC899148F4S.0Z4-STAX	03245481	4	F	■	14,8	16,0	62,0	37,0	150,0	0,48 °	4	■

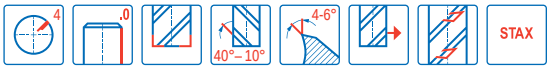
■ Prodotto standard.

JC899

Alte prestazioni – Materiali sandwich – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo – Pollici



D





- Tolleranze:
- DMM=h5
- DC= ±0,0008 *Inch*

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	AP1	OAL	PCEDC	Cilindrico
					inch	inch	inch	inch	inch		
JC8990375D4S.0Z4-STAX	03245483	4	D	■	0.373	0.375	1.500	0.625	4.000	4	■

■ Prodotto standard.

Parametri di taglio – JC899 Finitura

SMG		a_e/DC	a_p/DC	f_z		v_c
				8.5	14.8	
S12+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,04 *0,0016*	0,075 *0,0030*	40 (30 — 50) *140 (100 — 170)*
N1+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,06 *0,0032*	0,09 *0,0036*	60 (50 — 75) *200 (170 — 250)*

Parametri di taglio – JC899 Finitura – Pollici

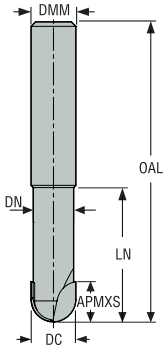
SMG		a_e/DC	a_p/DC	f_z	v_c
				3/8	
S12+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,05 *0,0022*	40 (30 — 50) *140 (100 — 170)*
N1+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,07 *0,0028*	60 (50 — 75) *200 (170 — 250)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JPD850

Compositi – A testa sferica – 2 Eliche – Cilindrico – ICC



E



- Tolleranze:
- DMM=h5
- DC= h10
- ICC= 2 canali diritti

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm		
JPD850060E2B.0Z2A	02968184	2	E	■	6,0	6,0	7,0	58,0	18,0	5,4	2	■
JPD850080E2B.0Z2A	02968185	2	E	■	8,0	8,0	8,0	64,0	24,0	7,2	2	■
JPD850100E2B.0Z2A	02968186	2	E	■	10,0	10,0	10,0	73,0	30,0	9,0	2	■

■ Prodotto standard.

Parametri di taglio – JPD850 Copiatura

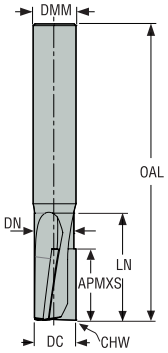
SMG		a_e/DC	a_p/DC	f_z					v_c
				4	5	6	8	10	
TS2	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	550 (470 — 820) *1800 (1600 — 2600)*
TS3	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	310 (270 — 460) *1025 (890 — 1500)*
TP2	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	890 (750 — 1300) *2925 (2500 — 4200)*
TP3	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	580 (500 — 870) *1900 (1700 — 2800)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

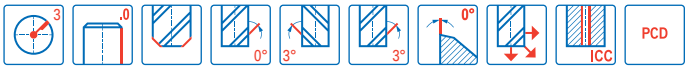
JPD880

Compositi – Spallamento – 3 Eliche – Cilindrico – Smusso – ICC



E





- Tolleranze:
- DMM=h5
- DC=h10
- ICC=Y

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JPD880060G2C.0Z3A	02968190	2	G	■	6,0	8,0	13,0	64,0	20,0	5,3	0,1	3	■
JPD880080E2C.0Z3A	02968191	2	E	■	8,0	8,0	15,0	64,0	20,0	7,3	0,1	3	■
JPD880100E2C.0Z3A	02968192	2	E	■	10,0	10,0	13,0	73,0	30,0	9,2	0,1	3	■
JPD880120E2C.0Z3A	02968194	2	E	■	12,0	12,0	13,0	83,0	30,0	11,0	0,1	3	■
JPD880160E2C.0Z3A	02968196	2	E	■	16,0	16,0	13,0	90,0	35,0	14,8	0,1	3	■
JPD880100E3C.0Z3A	02968193	3	E	■	10,0	10,0	20,0	73,0	30,0	9,2	0,1	3	■
JPD880160E3C.0Z3A	02968197	3	E	■	16,0	16,0	20,0	90,0	35,0	14,8	0,1	3	■

■ Prodotto standard.

Parametri di taglio – JPD880 Contornatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				6	8	10	12	16	
TS2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	510 (430 — 750) *1675 (1500 — 2400)*
TS3	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	275 (230 — 410) *900 (760 — 1300)*
TP2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	810 (680 — 940) *2650 (2300 — 3000)*
TP3	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	520 (440 — 780) *1700 (1500 — 2500)*

Parametri di taglio – JPD880 Scanalatura

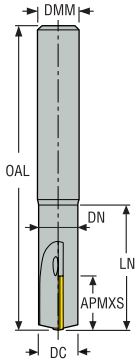
SMG		a_p/DC	f_z					v_c
			6	8	10	12	16	
TS2	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	385 (330 — 570) *1275 (1100 — 1800)*
TS3	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	210 (180 — 310) *690 (600 — 1000)*
TP2	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	620 (520 — 710) *2025 (1800 — 2300)*
TP3	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	395 (340 — 590) *1300 (1200 — 1900)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

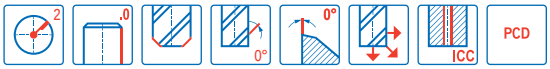
JPD890

Compositi – Spallamento – 2 Eliche – Cilindrico – Smusso – ICC



E





- Tolleranze:
- DMM=h5
- DC=h10
- ICC=2 canali diritti

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	Adduz. refrig. interna	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm	mm		
JPD890060G2S.0Z2A	02791382	2	G	■	6,0	8,0	13,0	64,0	20,0	5,4	0,1	2	■
JPD890080E2S.0Z2A	02791383	2	E	■	8,0	8,0	15,0	64,0	20,0	7,4	0,1	2	■
JPD890100E2S.0Z2A	02791384	2	E	■	10,0	10,0	13,0	73,0	30,0	9,4	0,1	2	■
JPD890120E2S.0Z2A	02791386	2	E	■	12,0	12,0	13,0	83,0	30,0	11,4	0,1	2	■
JPD890100E3S.0Z2A	02791385	3	E	■	10,0	10,0	20,0	73,0	30,0	9,4	0,1	2	■
JPD890120E3S.0Z2A	02791387	3	E	■	12,0	12,0	20,0	83,0	30,0	11,4	0,1	2	■

■ Prodotto standard.

Parametri di taglio – JPD890 Contornatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	415 (360 — 620) *1350 (1200 — 2000)*
TS3	E/A/D	0.200 *0,200*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	305 (260 — 450) *1000 (860 — 1400)*
TP2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	670 (560 — 770) *2200 (1900 — 2500)*
TP3	E/A/D	0.200 *0,200*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	580 (490 — 860) *1900 (1700 — 2800)*

Parametri di taglio – JPD890 Scanalatura

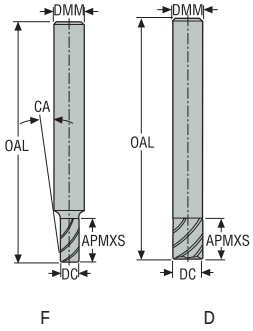
SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	375 (320 — 550) *1225 (1100 — 1800)*
TS3	E/A/D	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	225 (190 — 330) *740 (630 — 1000)*
TP2	E/A/D	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	600 (500 — 690) *1975 (1700 — 2200)*
TP3	E/A/D	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	420 (360 — 630) *1375 (1200 — 2000)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

J93F

Uso generico – Plastica – Spallamento – 2 Eliche – Cilindrico – Spigolo vivo







- Tolleranze:
- DMM= h5
- DC= Ø1-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø20= -0,02/-0,044 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CA	PCEDC	Cilindrico
				mm	mm	mm	mm	mm		
93015-F	02605874	2	F	1,5	3,0	6,0	40,0	4,0	2	■
93020-F	02605888	2	F	2,0	3,0	9,0	40,0	2,5	2	■
93030-F	02606060	2	D	3,0	3,0	12,0	40,0	–	2	■
93040-F	02606061	2	D	4,0	4,0	14,0	50,0	–	2	■
93060-F	02606063	2	D	6,0	6,0	20,0	65,0	–	2	■
93080-F	02606064	2	D	8,0	8,0	20,0	70,0	–	2	■
93100-F	02606065	2	D	10,0	10,0	25,0	80,0	–	2	■
93120-F	02606066	2	D	12,0	12,0	25,0	90,0	–	2	■
93160-F	02606068	2	D	16,0	16,0	30,0	90,0	–	2	■
93L060-F	02606071	3	D	6,0	6,0	40,0	100,0	–	2	■
93L080-F	02606072	3	D	8,0	8,0	40,0	100,0	–	2	■
93L100-F	02606073	3	D	10,0	10,0	40,0	100,0	–	2	■
93L120-F	02606074	3	D	12,0	12,0	45,0	100,0	–	2	■
93L160-F	02606077	3	D	16,0	16,0	45,0	100,0	–	2	■
93L200-F	02606078	3	D	20,0	20,0	55,0	125,0	–	2	■
93XL120-F	02606079	4	D	12,0	12,0	30,0	150,0	–	2	■
93XL160-F	02606080	4	D	16,0	16,0	65,0	150,0	–	2	■
93XL200-F	02606081	4	D	20,0	20,0	65,0	150,0	–	2	■

■ Prodotto standard.

Parametri di taglio – J93F Contornatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				1.5	2	3	4	6	8	10	12	16	20	
TS1	A	0.400 *0,400*	1.4 *1,4*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	590 (480 — 710) *1925 (1600 — 2300)*
TP1	A	0.400 *0,400*	1.4 *1,4*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	570 (460 — 680) *1875 (1600 — 2200)*

Parametri di taglio – J93F Scanalatura

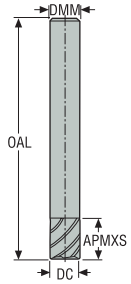
SMG		a_p/DC	f_z										v_c
			1.5	2	3	4	6	8	10	12	16	20	
TS1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
TP1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	485 (390 — 580) *1600 (1300 — 1900)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

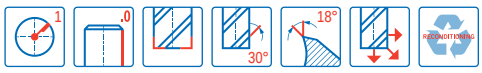
J28

Uso generico – Plastica – Spallamento – 1 Elica – Cilindrico – Spigolo vivo



D





- Tolleranze:
- DMM= h5
- DC= Ø2-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø12= -0,02/-0,044 mm
- Riaffilatura possibile se DC è ≥Ø6

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Cilindrico
				mm	mm	mm	mm		
28030	00029353	2	D	3,0	3,0	10,0	40,0	1	■
28040	00029361	2	D	4,0	4,0	14,0	50,0	1	■
28050	00029363	2	D	5,0	5,0	16,0	60,0	1	■
28060	00029366	2	D	6,0	6,0	20,0	65,0	1	■
28080	00029369	2	D	8,0	8,0	25,0	75,0	1	■
28100	00029370	2	D	10,0	10,0	25,0	75,0	1	■
28120	00029372	2	D	12,0	12,0	25,0	75,0	1	■

■ Prodotto standard.

Parametri di taglio – J28 Contornatura a_e/DC=0,4

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS1	A/D	0.300 *0,300*	1.5 *1,5*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	490 (370 — 610) *1600 (1300 — 2000)*

Parametri di taglio – J28 Scanalatura

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS1	A/D	1.0 *1,0*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	400 (310 — 490) *1300 (1100 — 1600)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi



GRAFITE

Le frese Seco in metallo duro integrale rivestite diamond sono progettate specificamente per la lavorazione della grafite. Offrono una durata fino a 10 volte superiore a quella delle frese con rivestimenti tradizionali. Disponibili in molte geometrie e in una gamma
estesa di diametri, questi utensili sono caratterizzati da un substrato di altissima qualità per garantire la perfetta idoneità del rivestimento diamond ad una vasta gamma di parametri di taglio.

- JD620, JD630, JD640 e JME642 per tipo con raggio.
- JD660, SMB614, SMB616 e JMB642 per tipo a testa sferica.

Selezione utensile grafite

					
Nome		JD620	JD630	JD640	JD660
Pag.		472	474	476	478
Famiglia		DIAMOND	DIAMOND	DIAMOND	DIAMOND
Tipo di fresa					
Attacco	Cilindrico	■	■	■	■
	Weldon				
Numero di eliche		2	3	4	2
Adduz. refrig. interna					
	Metrico	3-12	3-8	6-12	3-6
	Pollici				
Lunghezze disponibili		2,3,4	2,3,4	2,3,4	1,2,3,4,5
Operazione					
					
					
SMG					
GR		●	●	●	●

■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

Selezione utensile grafite

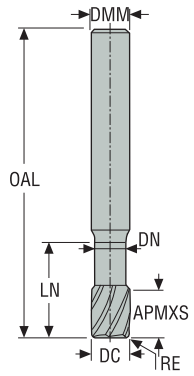
				
Nome		SMB614/616	JME642	JMB642/JMB662
Pag.		482	482	484
Famiglia		MINI DIAMOND	MINI DIAMOND	MINI DIAMOND
Tipo di fresa				
Attacco	Cilindrico	■	■	■
	Weldon			
Numero di eliche		2	2	2
Adduz. refrig. interna				
	Metrico	0,2-2,0	0,2-2,0	0,2-3,0
	Pollici			
Lunghezze disponibili		1,3,5,6,7	1,3,5,6,7	1,3,5,6,7
Operazione				
				
				
SMG				
GR		•	•	•

■ Prodotto standard ☐ Weldon disponibile, tempo di consegna 3 giorni.
• Prima scelta ○ Scelta alternativa

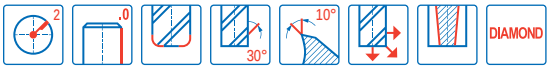
JD620

Diamante – Grafite – Spallamento – 2 Eliche – Cilindrico – Raggio di punta





E



- Tolleranze:
- Run-out= <0,01 mm
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
620V030R050-DIAMOND	00023425	2	E	3,0	3,0	5,0	60,0	30,0	2,85	0,5	2	■
620V040R050-DIAMOND	00023427	2	E	4,0	4,0	5,0	60,0	30,0	3,85	0,5	2	■
620V060R050-DIAMOND	00023429	2	E	6,0	6,0	10,0	80,0	40,0	5,8	0,5	2	■
620V080R050-DIAMOND	00023431	2	E	8,0	8,0	10,0	80,0	40,0	7,7	0,5	2	■
620V100R050-DIAMOND	00023435	2	E	10,0	10,0	10,0	80,0	40,0	9,7	0,5	2	■
620V120R050-DIAMOND	00023437	2	E	12,0	12,0	10,0	80,0	40,0	11,7	0,5	2	■
620VL060R050-DIAMOND	00023444	3	E	6,0	6,0	10,0	100,0	70,0	5,8	0,5	2	■
620VL080R050-DIAMOND	00023446	3	E	8,0	8,0	10,0	100,0	70,0	7,8	0,5	2	■
620VL080R100-DIAMOND	00023447	3	E	8,0	8,0	10,0	100,0	70,0	7,8	1,0	2	■
620VL100R050-DIAMOND	00023448	3	E	10,0	10,0	10,0	100,0	70,0	9,8	0,5	2	■
620VL100R100-DIAMOND	00023449	3	E	10,0	10,0	10,0	100,0	70,0	9,8	1,0	2	■
620VL120R050-DIAMOND	00023450	3	E	12,0	12,0	10,0	100,0	70,0	11,8	0,5	2	■
620VL120R100-DIAMOND	00023451	3	E	12,0	12,0	10,0	100,0	70,0	11,7	1,0	2	■
620VSL100R100-DIAMOND	00023452	4	E	10,0	10,0	10,0	150,0	100,0	9,8	1,0	2	■
620VSL120R100-DIAMOND	00023453	4	E	12,0	12,0	10,0	150,0	100,0	11,8	1,0	2	■

■ Prodotto standard.

Parametri di taglio – JD620 Contornatura

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
GR1	D	0.500 *0,500*	0.50 *0,50*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	690 (580 — 800) *2275 (2000 — 2600)*

Parametri di taglio – JD620 Scanalatura

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520 — 710) *2000 (1800 — 2300)*

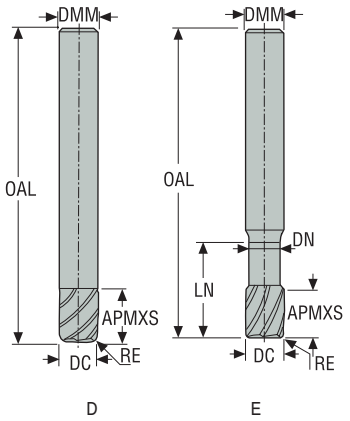
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

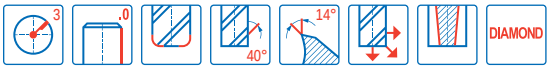
JD630

Diamante – Grafite – Spallamento – 3 Eliche – Cilindrico – Raggio di punta





- Tolleranze:
- Run-out= <0,01 mm
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
630030R015-DIAMOND	00023454	2	D	3,0	3,0	12,0	40,0	–	–	0,15	3	■
630040R020-DIAMOND	00023456	2	D	4,0	4,0	14,0	50,0	–	–	0,2	3	■
630050R030-DIAMOND	00023457	2	D	5,0	5,0	16,0	50,0	–	–	0,3	3	■
630060R030-DIAMOND	00023458	2	D	6,0	6,0	20,0	65,0	–	–	0,3	3	■
630080R050-DIAMOND	00023459	2	D	8,0	8,0	20,0	65,0	–	–	0,5	3	■
630V030R030-DIAMOND	00023464	3	E	3,0	3,0	5,0	40,0	15,0	2,9	0,3	3	■
630V040R030-DIAMOND	00023465	3	E	4,0	4,0	5,0	50,0	20,0	3,9	0,3	3	■
630VL030R020-DIAMOND	00023467	4	E	3,0	3,0	5,0	60,0	25,0	2,9	0,2	3	■
630VL040R020-DIAMOND	00023470	4	E	4,0	4,0	5,0	60,0	30,0	3,9	0,2	3	■
630VL050R020-DIAMOND	00023471	4	E	5,0	5,0	6,0	70,0	40,0	4,9	0,2	3	■
630VL060R050-DIAMOND	00023472	4	E	6,0	6,0	10,0	100,0	60,0	5,9	0,5	3	■

■ Prodotto standard.

Parametri di taglio – JD630 Contornatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				3	4	5	6	8	
GR1	D	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	680 (580 — 790) *2225 (2000 — 2500)*

Parametri di taglio – JD630 Scanalatura

SMG		a_p/DC	f_z					v_c
			3	4	5	6	8	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	620 (520 — 720) *2025 (1800 — 2300)*

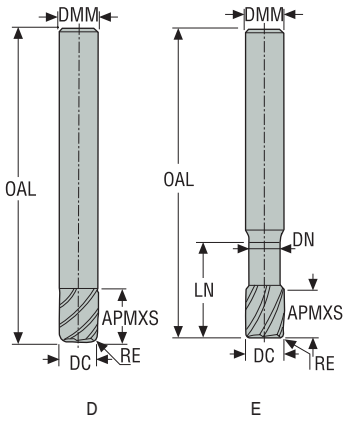
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

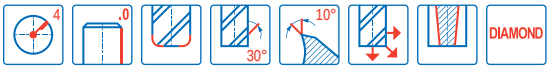
JD640

Diamante – Grafite – Spallamento – 4 Eliche – Cilindrico – Raggio di punta





- Tolleranze:
- Run-out= <0,01 mm
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
640100R050-DIAMOND	00023474	2	D	10,0	10,0	25,0	75,0	–	–	0,5	4	■
640120R050-DIAMOND	00023475	2	D	12,0	12,0	25,0	80,0	–	–	0,5	4	■
640V060R050-DIAMOND	00023479	3	E	6,0	6,0	10,0	80,0	40,0	5,9	0,5	4	■
640V080R050-DIAMOND	00023480	3	E	8,0	8,0	10,0	80,0	40,0	7,8	0,5	4	■
640V100R050-DIAMOND	00023481	3	E	10,0	10,0	12,0	80,0	40,0	9,8	0,5	4	■
640V120R050-DIAMOND	00023483	3	E	12,0	12,0	15,0	80,0	40,0	11,8	0,5	4	■
640VL100R050-DIAMOND	00023486	4	E	10,0	10,0	12,0	125,0	80,0	9,8	0,5	4	■
640VL120R050-DIAMOND	02462698	4	E	12,0	12,0	15,0	125,0	80,0	11,7	0,5	4	■

■ Prodotto standard.

Parametri di taglio – JD640 Contornatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
GR1	D	0.500 *0,500*	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	680 (570 — 780) *2225 (1900 — 2500)*

Parametri di taglio – JD640 Scanalatura

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
GR1	D	0.50 *0,50*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520 — 710) *2000 (1800 — 2300)*

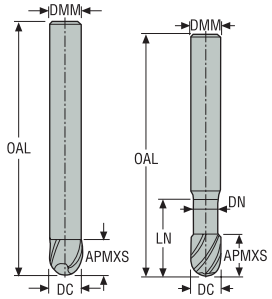
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

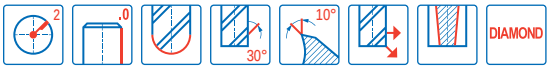
JD660

Diamante – Grafite – A testa sferica – 2 Eliche – Cilindrico





- Tolleranze:
- Run-out=<0,01 mm
- DMM=h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- B=0,9°



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm		
660030-DIAMOND	00023488	1	D	3,0	3,0	8,0	40,0	–	–	1,5	2	■
660040-DIAMOND	00023489	1	D	4,0	4,0	14,0	50,0	–	–	2,0	2	■
660060-DIAMOND	00023491	1	D	6,0	6,0	20,0	65,0	–	–	3,0	2	■
660V030-DIAMOND	00023501	2	E	3,0	3,0	6,0	40,0	15,0	2,9	1,5	2	■
660V040-DIAMOND	00023502	2	E	4,0	4,0	6,0	40,0	15,0	3,9	2,0	2	■
660V060-DIAMOND	00023505	2	E	6,0	6,0	10,0	65,0	35,0	5,9	3,0	2	■
660L030-DIAMOND	00023494	3	D	3,0	3,0	20,0	60,0	–	–	1,5	2	■
660L040-DIAMOND	00023496	3	D	4,0	4,0	30,0	60,0	–	–	2,0	2	■
660L060-DIAMOND	00023498	3	D	6,0	6,0	40,0	100,0	–	–	3,0	2	■
660VL030-DIAMOND	00023511	4	E	3,0	3,0	6,0	60,0	30,0	2,9	1,5	2	■
660VL040-DIAMOND	00023512	4	E	4,0	4,0	6,0	60,0	30,0	3,9	2,0	2	■
660VL060-DIAMOND	00023516	4	E	6,0	6,0	10,0	100,0	70,0	5,8	3,0	2	■

■ Prodotto standard.

Parametri di taglio – JD660 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z			v_c
				3	4	6	
GR1	D	0.400 *0,400*	2.4 *2,4*	0.024 *0,00095*	0.032 *0,0013*	0.046 *0,0018*	920 (780 — 1000) *3025 (2600 — 3200)*

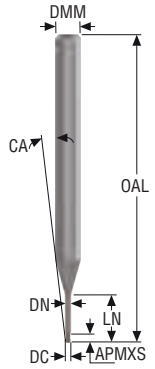
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

SMB614/616

Miniaturizzato – Grafite – A testa sferica – 2 Eliche – Cilindrico





G



- Tolleranze:
- Run-out= <0,005 mm
- DMM = h5
- DC Rivestito = -0,01/-0,025 mm
- DC Rivestito = 0/-0,015 mm
- RE = ±0,01 mm

Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	DN	LN	CA°	PCEDC	Cilindrico
					mm	mm	mm	mm	mm	mm			
SMB614010G4B.0Z2	–	10108702	4	G	1,0	4	1,0	50	0,95	7,5	6,54 °	2	■
SMB614010G4B.0Z2	DIA	10108776	4	G	1,0	4	1,0	50	0,95	7,5	6,54 °	2	■
SMB614020G4B.0Z2	–	10108703	4	G	2,0	4	2,0	50	1,9	12,0	3,74 °	2	■
SMB614020G4B.0Z2	DIA	10108777	4	G	2,0	4	2,0	50	1,9	12,0	3,74 °	2	■
SMB616020G4B.0Z2	–	10108768	4	G	2,0	6	2,0	50	1,9	12,0	5,99 °	2	■
SMB614030G4B.0Z2	–	10108704	4	G	3,0	4	3,0	50	2,85	20,0	1,36 °	2	■
SMB614030G4B.0Z2	DIA	10108778	4	G	3,0	4	3,0	50	2,85	20,0	1,36 °	2	■
SMB616030G4B.0Z2	–	10108769	4	G	3,0	6	3,0	55	2,85	20,0	3,47 °	2	■
SMB614020G5B.0Z2	–	10108705	5	G	2,0	4	2,0	50	1,9	16,0	2,96 °	2	■
SMB614020G5B.0Z2	DIA	10108779	5	G	2,0	4	2,0	50	1,9	16,0	3,13 °	2	■
SMB616020G5B.0Z2	–	10108770	5	G	2,0	6	2,0	50	1,9	16,0	4,96 °	2	■
SMB614006G6B.0Z2	–	10108706	6	G	0,6	4	0,6	50	0,55	6,0	7,72 °	2	■
SMB614006G6B.0Z2	DIA	10108780	6	G	0,6	4	0,6	50	0,55	6,0	7,72 °	2	■
SMB616006G6B.0Z2	–	10108771	6	G	0,6	6	0,6	50	0,55	6,0	9,43 °	2	■
SMB614008G6B.0Z2	–	10108707	6	G	0,8	4	0,8	50	0,75	10,0	5,69 °	2	■
SMB614008G6B.0Z2	DIA	10108781	6	G	0,8	4	0,8	50	0,75	10,0	5,69 °	2	■
SMB614010G6B.0Z2	–	10108708	6	G	1,0	4	0,5	50	0,95	12,0	4,88 °	2	■
SMB614010G6B.0Z2	DIA	10108782	6	G	1,0	4	0,5	50	0,95	12,0	4,88 °	2	■
SMB616010G6B.0Z2	–	10108772	6	G	1,0	6	1,0	50	0,95	12,0	6,69 °	2	■
SMB614020G6B.0Z2	–	10108709	6	G	2,0	4	2,0	50	1,9	20,0	2,46 °	2	■
SMB614020G6B.0Z2	DIA	10108783	6	G	2,0	4	2,0	50	1,9	20,0	2,46 °	2	■
SMB616020G6B.0Z2	–	10108773	6	G	2,0	6	2,0	55	1,9	20,0	4,23 °	2	■
SMB614006G7B.0Z2	–	10108710	7	G	0,6	4	0,6	50	0,55	10,0	5,87 °	2	■
SMB614006G7B.0Z2	DIA	10108784	7	G	0,6	4	0,6	50	0,55	10,0	5,87 °	2	■
SMB616006G7B.0Z2	–	10108774	7	G	0,6	6	0,6	50	0,55	10,0	7,59 °	2	■
SMB614010G7B.0Z2	–	10108711	7	G	1,0	4	1,0	50	0,95	18,0	3,64 °	2	■
SMB614010G7B.0Z2	DIA	10108785	7	G	1,0	4	1,0	50	0,95	18,0	3,64 °	2	■
SMB616010G7B.0Z2	–	10108775	7	G	1,0	6	1,0	55	0,95	18,0	5,23 °	2	■

■ Prodotto standard.

Parametri di taglio – SMB614 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.6	0.8	1	2	3	
GR1	D	0,0700 *0.0700*	0,10 *0.10*	0,018 *0.00070*	0,024 *0.00095*	0,030 *0.0012*	0,060 *0.0024*	0,090 *0.0036*	95 (54 — 120) *310 (180 — 390)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – SMB616 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				0.6	1	2	3	
GR1	D	0,0700 *0.0700*	0,10 *0.10*	0,018 *0.00070*	0,030 *0.0012*	0,060 *0.0024*	0,090 *0.0036*	95 (54 — 120) *310 (180 — 390)*

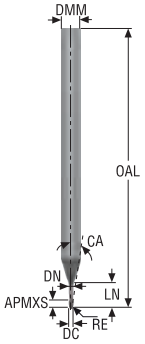
Per il ricalcolo dei parametri di taglio, vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JME642

Miniaturizzato – Grafite – Spallamento – Diamante – 2 Eliche – DMM 4 – Cilindrico – Raggio di punta





G

- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0/-0,015 mm
- RE= ±0,007 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JME642002G1R002.0Z2-DIA	03215524	1	G	0,2	4,0	0,3	40,0	0,4	0,18	0,02	14,32	2	■
JME642003G1R002.0Z2-DIA	03215525	1	G	0,3	4,0	0,5	40,0	0,5	0,28	0,02	14,1	2	■
JME642004G1R004.0Z2-DIA	03215526	1	G	0,4	4,0	0,6	40,0	2,0	0,37	0,04	11,67	2	■
JME642005G3R005.0Z2-DIA	03215527	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,05	10,97	2	■
JME642006G3R006.0Z2-DIA	03215528	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,06	10,31	2	■
JME642008G3R008.0Z2-DIA	03215529	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,08	9,31	2	■
JME642010G3R010.0Z2-DIA	03215530	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,1	8,04	2	■
JME642012G3R012.0Z2-DIA	03215531	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,12	7,09	2	■
JME642015G3R015.0Z2-DIA	03215532	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,15	5,8	2	■
JME642020G3R015.0Z2-DIA	03236441	3	G	2,0	4,0	2,2	60,0	10,0	1,9	0,15	4,11	2	■
JME642020G3R020.0Z2-DIA	03215533	3	G	2,0	4,0	3,0	60,0	10,0	1,9	0,2	4,11	2	■
JME642005G5R005.0Z2-DIA	03215534	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,05	9,43	2	■
JME642006G5R006.0Z2-DIA	03215535	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,06	8,5	2	■
JME642008G5R008.0Z2-DIA	03215536	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,08	7,02	2	■
JME642010G5R010.0Z2-DIA	03215537	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,1	6,06	2	■
JME642012G5R012.0Z2-DIA	03215538	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,12	5,23	2	■
JME642015G5R015.0Z2-DIA	03215539	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,15	4,25	2	■
JME642020G5R015.0Z2-DIA	03236442	5	G	2,0	4,0	2,2	60,0	16,0	1,9	0,15	2,87	2	■
JME642020G5R020.0Z2-DIA	03215540	5	G	2,0	4,0	3,0	60,0	16,0	1,9	0,2	2,87	2	■
JME642010G6R010.0Z2-DIA	03215541	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,1	4,86	2	■
JME642015G6R015.0Z2-DIA	03215542	6	G	1,5	4,0	2,4	50,0	18,0	1,4	0,15	3,13	2	■
JME642020G6R020.0Z2-DIA	03215543	6	G	2,0	4,0	3,0	60,0	25,0	1,9	0,2	1,97	2	■
JME642020G7R020.0Z2-DIA	03215544	7	G	2,0	4,0	3,0	60,0	30,0	1,9	0,2	1,68	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JME642/JME662 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.80 *0,80*	0.024 *0,00095*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	175 (130 — 370) *570 (430 — 1200)*

Parametri di taglio – JME642 Scanalatura

SMG		a_p/DC	f_z										v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.30 *0,30*	0.022 *0,00085*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.065 *0,0026*	0.075 *0,0030*	0.080 *0,0032*	140 (110 — 300) *460 (370 — 980)*

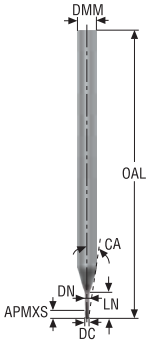
Tabella basata su LV3, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine. 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

JMB642/JMB662

Miniaturizzato – Grafite – A testa sferica – Diamante – 2 Eliche – DMM 4-6 – Cilindrico





G

- Tolleranze:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0/-0,015 mm
- RE= ±0,007 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cilindrico
				mm	mm	mm	mm	mm	mm	mm			
JMB642002G1B.0Z2-DIA	03215373	1	G	0,2	4,0	0,3	40,0	0,4	0,18	0,1	14,5	2	■
JMB642003G1B.0Z2-DIA	03215374	1	G	0,3	4,0	0,5	40,0	0,6	0,28	0,15	14,17	2	■
JMB642004G1B.0Z2-DIA	03215375	1	G	0,4	4,0	2,0	40,0	0,8	0,37	0,2	13,8	2	■
JMB642005G3B.0Z2-DIA	03215376	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,25	11,19	2	■
JMB642006G3B.0Z2-DIA	03215377	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,3	10,55	2	■
JMB642008G3B.0Z2-DIA	03215378	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,4	9,38	2	■
JMB642010G3B.0Z2-DIA	03215379	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,5	8,33	2	■
JMB642012G3B.0Z2-DIA	03215380	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,6	7,38	2	■
JMB642015G3B.0Z2-DIA	03215381	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,75	6,08	2	■
JMB642020G3B.0Z2-DIA	03215382	3	G	2,0	4,0	3,0	60,0	10,0	1,9	1,0	4,35	2	■
JMB662030G3B.0Z2-DIA	03215384	3	G	3,0	6,0	3,0	60,0	15,0	2,8	1,5	4,38	2	■
JMB642005G5B.0Z2-DIA	03215387	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,25	9,6	2	■
JMB642006G5B.0Z2-DIA	03215388	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,3	8,68	2	■
JMB642008G5B.0Z2-DIA	03215389	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,4	7,18	2	■
JMB642010G5B.0Z2-DIA	03215390	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,5	6,22	2	■
JMB642012G5B.0Z2-DIA	03215391	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,6	5,4	2	■
JMB642015G5B.0Z2-DIA	03215392	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,75	4,4	2	■
JMB642020G5B.0Z2-DIA	03215393	5	G	2,0	4,0	3,0	60,0	16,0	1,9	1,0	2,99	2	■
JMB662030G5B.0Z2-DIA	03215395	5	G	3,0	6,0	3,0	60,0	24,0	2,8	1,5	3,0	2	■
JMB642010G6B.0Z2-DIA	03215396	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,5	4,96	2	■
JMB642015G6B.0Z2-DIA	03215397	6	G	1,5	4,0	2,4	60,0	18,0	1,4	0,75	3,21	2	■
JMB642020G6B.0Z2-DIA	03215398	6	G	2,0	4,0	3,0	60,0	25,0	1,9	1,0	2,03	2	■
JMB642020G7B.0Z2-DIA	03215399	7	G	2,0	4,0	3,0	60,0	30,0	1,9	1,0	1,72	2	■

■ Prodotto standard.
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

Parametri di taglio – JMB642/662 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.50 *0,50*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	250 (200 — 300) *820 (660 — 980)*

Parametri di taglio – JMB642/662 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.50 *0,50*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	250 (200 — 300) *820 (660 — 980)*

Tabella basata su LV3, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 573 - 580

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi



SECO X-HEADS

La nuova gamma Seco Tools Exchangeable Head è un'offerta completa per soddisfare la maggior parte delle esigenze dei clienti. Utilizzando le nostre collaudate geometrie in metallo duro integrale, offriamo diversi tipi per lavorare la maggior parte dei materiali e completare diverse operazioni di lavorazione. La connessione è data da un comprovato design della testina intercambiabile per garantire sicurezza e affidabilità elevate nei processi. Gli steli offrono molti tipi di sporgenza da corta a lunga per diverse applicazioni. Colli dritti e conici offrono la migliore combinazione di stabilità in base alle esigenze delle operazioni di lavorazione.

- XSE550, XSE720, XSE450, XHF580, XHF780 XVE540 e XVE510 per tipo con smusso o raggio.
- XSB540, XSB720 e XVB510 per tipo a testa sferica.
- XSC509, XVC506, XVC509 e XVC512 per tipo conico.
- XHT740 per tipo a barile.

Selezione utensile X-Heads

								
Nome		XSE550	XSB540	XSE720	XSB720	XSE450	XSC509	XHT740
Pag.		497-505	514	516-517	522	528-529	567	304
Famiglia		X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS HSM/ TORNADO
Tipo di fresa								
Numero di eliche		3,4,5	4	6	6	3	6	4,6
Adduz. refrig. interna			■					
	Metrico	10-20	10-16	10-25	10-20	10-20	10-16	10-16
	Pollici	3/8-1		3/8-1	3/8-1	3/8-1		
Lunghezze disponibili		1,2	1	3	3	2	1	2,3
Operazione								
								
								
								
								
SMG								
P1-8		●	●	○	○		●	○
P11-12		●	○	●	●		●	●
M1-3		●	●	●	●		●	●
M4-5		●	●	●	●		●	
K1-7		●	●				●	
S1-3		●	○	●	●		○	○
S11-13		●	●	●	●		○	●
H3 H5 H7 H8 H11 H12 H21 H31		●	○					
N1		●	●			●	○	
N2-3		●	●			●	○	
N11		●	●			●	○	
TS1		●	●			●	●	
TP1		●	●			●	●	
GR		○	○				○	

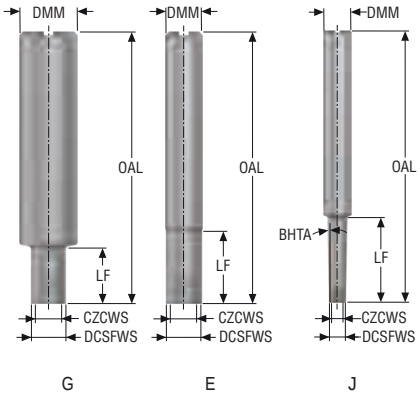
■ Prodotto standard.
● Prima scelta ○ Scelta alternativa

Selezione utensile X-Heads

								
Nome		XHF580	XHF780	XVE540	XVE510	XVB510	XVC506/509/512	XVK310
Pag.		537	542	555	560	563-564	567	571
Famiglia		X-HEADS HFM	X-HEADS HFM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM
Tipo di fresa								
Numero di eliche		4	4	3,4	2	2	2	4
Adduz. refrig. interna		■		■				
	Metrico	10-16	10-16	10-20	10-12	10-16	10-16	12-20
	Pollici	3/8-5/8	3/8-5/8	3/8-3/4		3/8-5/8		
Lunghezze disponibili		1	1	1	1	1	1	1
Operazione								
								
								
								
SMG								
P1-8		●	○	●	●	●	●	●
P11-12		●	○	●	●	●	●	●
M1-3		●	●	●	●	●	●	●
M4-5		●	●	●	●	●	●	●
K1-7		●		●	●	●	●	●
S1-3		○	●	○	○	○	○	○
S11-13		○	●	○	○	○	○	○
H3 H5 H7 H8 H11 H12 H21 H31		○	○	○				○
N1				●	○	○	○	●
N2-3				●	○	○	○	●
N11				●	○	○	○	●
TS1				●	●	●	●	●
TP1				●	●	●	●	●
GR				○	○	○	○	○

■ Prodotto standard ☐ Weldon disponibile, tempo di consegna 3 giorni. ☐ Safe-Lock disponibile, tempo di consegna 6 giorni
● Prima scelta ○ Scelta alternativa

Acciaio - In mm







- Tolleranze:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCSFWS	DMM	LF	OAL	BHTA°	Cilindrico
					mm	mm	mm	mm		
XE10160G1-065-00.0S	10138083	1	G	E10	9,6	16,0	5,0	65,0	0,0	■
XE10100E2-055-00.0S	10138092	2	E	E10	9,6	10,0	10,0	55,0	0,0	■
XE10100E2-075-00.0S	10138093	2	E	E10	9,6	10,0	20,0	75,0	0,0	■
XE10160G2-075-00.0S	10138088	2	G	E10	9,6	16,0	15,0	75,0	0,0	■
XE10160J3-120-01.0S	10138099	3	J	E10	9,6	16,0	35,0	120,0	1,0	■
XE10160J5-160-01.0S	10138100	5	J	E10	9,6	16,0	50,0	160,0	1,0	■
XE10160J3-140-05.0S	10138106	3	J	E10	9,6	16,0	36,6	140,0	5,0	■
XE10200J5-140-05.0S	10138108	5	J	E10	9,6	20,0	59,4	140,0	5,0	■
XE10320J6-250-10.0S	10138113	6	J	E10	9,6	32,0	63,5	250,0	10,0	■
XE12160G1-065-00.0S	10138084	1	G	E12	11,6	16,0	5,0	65,0	0,0	■
XE12120E2-065-00.0S	10138094	2	E	E12	11,6	12,0	12,0	65,0	0,0	■
XE12120E2-100-00.0S	10138095	2	E	E12	11,6	12,0	22,0	100,0	0,0	■
XE12160G2-080-00.0S	10138089	2	G	E12	11,6	16,0	18,0	80,0	0,0	■
XE12160J3-155-01.0S	10138101	3	J	E12	11,6	16,0	42,0	155,0	1,0	■
XE12160J5-170-01.0S	10138102	5	J	E12	11,6	16,0	60,0	170,0	1,0	■
XE12160J2-140-05.0S	10138107	2	J	E12	11,6	16,0	25,1	140,0	5,0	■
XE12200J4-155-05.0S	10138109	4	J	E12	11,6	20,0	48,0	155,0	5,0	■
XE12320J4-250-10.0S	10138114	4	J	E12	11,6	32,0	57,8	250,0	10,0	■
XE16200G1-070-00.0S	10138085	1	G	E16	15,4	20,0	5,0	70,0	0,0	■
XE16160E2-070-00.0S	10138096	2	E	E16	15,4	16,0	16,0	70,0	0,0	■
XE16200G2-090-00.0S	10138090	2	G	E16	15,4	20,0	24,0	90,0	0,0	■
XE16200G2-110-00.0S	10138091	2	G	E16	15,4	20,0	25,0	110,0	0,0	■
XE16200J3-190-01.0S	10138103	3	J	E16	15,4	20,0	56,0	190,0	1,0	■
XE16200J4-190-01.0S	10138104	4	J	E16	15,4	20,0	75,0	190,0	1,0	■
XE16250J3-170-05.0S	10138110	3	J	E16	15,4	25,0	54,9	170,0	5,0	■
XE20250G1-080-00.0S	10138086	1	G	E20	19,2	25,0	5,0	80,0	0,0	■
XE20200E2-120-00.0S	10138097	2	E	E20	19,2	20,0	30,0	120,0	0,0	■
XE20250J4-200-01.0S	10138105	4	J	E20	19,2	25,0	80,0	200,0	1,0	■
XE20320J3-180-05.0S	10138111	3	J	E20	19,2	32,0	73,2	180,0	5,0	■
XE25320G1-080-00.0S	10138087	1	G	E25	24,1	32,0	5,0	80,0	0,0	■
XE25250E2-140-00.0S	10138098	2	E	E25	24,1	25,0	40,0	140,0	0,0	■
XE25320J2-200-05.0S	10138112	2	J	E25	24,1	32,0	45,1	200,0	5,0	■

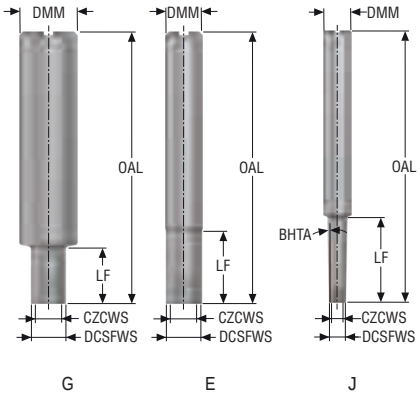
Parti di ricambio, comprese nella fornitura

Accessori

CZCMS	Chiave	Bit	Bit 1	Chiave dinamometrica
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Prodotto standard.

Acciaio - Pollici







- Tolleranze:
- DMM= h6
- DCSFWS= ±.002 Pollici
- BHTA= ±20'

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCSFMS	DMM	LF	OAL	BHTA°	Cilindrico
					inch	inch	inch	inch		
XE10.500G1-2.50-00.0S	10138050	1	G	E10	0.360	0.500	0.250	2.500	0,0	■
XE10.375E2-2.50-00.0S	10138053	2	E	E10	0.360	0.375	0.402	2.500	0,0	■
XE10.500G2-3.00-00.0S	10138051	2	G	E10	0.360	0.500	1.000	3.000	0,0	■
XE10.625J3-4.50-01.0S	10138063	3	J	E10	0.360	0.625	1.402	4.500	1,0	■
XE10.625J5-6.50-01.0S	10138064	5	J	E10	0.360	0.625	2.000	6.500	1,0	■
XE10.625J4-4.00-03.0S	10138071	4	J	E10	0.360	0.625	1.799	4.000	3,0	■
XE10.750J9-6.00-03.0S	10138072	9	J	E10	0.360	0.750	3.720	6.000	3,0	■
XE12.500E1-3.00-00.0S	10138054	1	E	E12	0.480	0.500	0.250	3.000	0,0	■
XE12.500E2-2.50-00.0S	10138055	2	E	E12	0.480	0.500	0.500	2.500	0,0	■
XE12.500E2-4.50-00.0S	10138056	2	E	E12	0.480	0.500	1.000	4.500	0,0	■
XE12.625J3-6.00-01.0S	10138065	3	J	E12	0.480	0.625	1.650	6.000	1,0	■
XE12.625J4-7.50-01.0S	10138066	4	J	E12	0.480	0.625	2.400	7.500	1,0	■
XE12.750J5-6.50-01.0S	10138067	5	J	E12	0.480	0.750	2.850	6.500	1,0	■
XE12.750J4-4.50-03.0S	10138073	4	J	E12	0.480	0.750	2.201	4.500	3,0	■
XE12.750J5-6.00-03.0S	10138074	5	J	E12	0.480	0.750	2.575	6.000	3,0	■
XE12.625J2-6.50-05.0S	10138075	2	J	E12	0.480	0.625	0.827	6.500	5,0	■
XE16.625E1-3.00-00.0S	10138057	1	E	E16	0.606	0.625	0.250	3.000	0,0	■
XE16.625E2-3.00-00.0S	10138058	2	E	E16	0.606	0.625	0.650	3.000	0,0	■
XE16.625E2-4.50-00.0S	10138059	2	E	E16	0.606	0.625	1.000	4.500	0,0	■
XE16.750J3-7.50-01.0S	10138068	3	J	E16	0.606	0.750	2.252	7.500	1,0	■
XE16.750J4-7.50-01.0S	10138070	4	J	E16	0.606	0.750	3.000	7.500	1,0	■
XE16.750J6-7.50-01.0S	10138069	6	J	E16	0.606	0.750	3.748	7.500	1,0	■
XE16.750J2-6.50-05.0S	10138076	2	J	E16	0.606	0.750	0.821	6.500	5,0	■
XE161.00J3-7.00-05.0S	10138077	3	J	E16	0.606	1.000	2.250	7.000	5,0	■
XE20.750E1-3.00-00.0S	10138060	1	E	E20	0.724	0.750	0.250	3.000	0,0	■
XE20.750E2-4.50-00.0S	10138061	2	E	E20	0.724	0.750	1.000	4.500	0,0	■
XE251.00E1-3.50-00.0S	10138062	1	E	E25	0.961	1.000	0.250	3.500	0,0	■
XE251.00E2-4.50-00.0S	10218129	2	E	E25	0.961	1.000	1.500	4.500	0,0	■
XE251.25G2-6.50-00.0S	10138052	2	G	E25	0.961	1.250	2.500	6.500	0,0	■
XE251.25J2-7.50-05.0S	10218130	2	J	E25	0.961	1.250	1.654	7.500	5,0	■

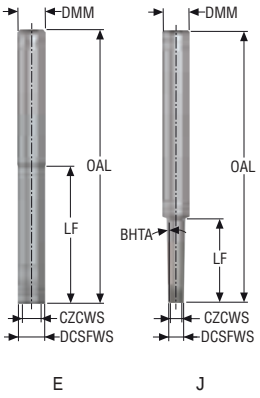
Parti di ricambio, comprese nella fornitura

Accessori

CZCMS	Chiave	Bit	Bit 1	Chiave dinamometrica
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Prodotto standard.

Metallo duro - In mm







- Tolleranze:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCSFWS	DMM	LF	OAL	BHTA°	Cilindrico
					mm	mm	mm	mm		
XE10100E5-100-00.0E	10138120	5	E	E10	9,6	10,0	50,0	100,0	0,0	■
XE10160J9-155-01.0E	10138126	9	J	E10	9,6	16,0	100,0	155,0	1,0	■
XE12120E4-100-00.0E	10138121	4	E	E12	11,6	12,0	48,0	100,0	0,0	■
XE12160J7-150-01.0E	10138127	7	J	E12	11,6	16,0	90,0	150,0	1,0	■
XE16160E5-135-00.0E	10138122	5	E	E16	15,4	16,0	80,0	135,0	0,0	■
XE16200J7-175-01.0E	10138128	7	J	E16	15,4	20,0	118,0	175,0	1,0	■
XE20200E2-095-00.0E	10138123	2	E	E20	19,2	20,0	38,0	95,0	0,0	■
XE20200E5-180-00.0E	10138124	5	E	E20	19,2	20,0	110,0	180,0	0,0	■
XE20250J4-200-02.0E	10138129	4	J	E20	19,2	25,0	83,0	200,0	2,0	■
XE25250E4-200-00.0E	10138125	4	E	E25	24,1	25,0	120,0	200,0	0,0	■
XE25320J2-190-05.0E	10218127	2	J	E25	24,1	32,0	45,1	190,0	5,0	■
XE25320J2-215-05.0E	10218128	2	J	E25	24,1	32,0	45,1	215,0	5,0	■

Parti di ricambio, comprese nella fornitura

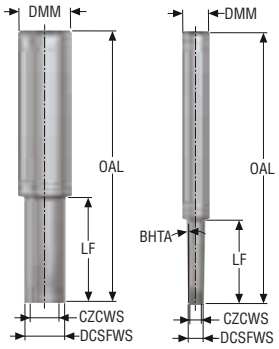
Accessori

CZCMS	Chiave	Bit	Bit 1	Chiave dinamometrica
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Prodotto standard.

Metallo duro - Pollici







- Tolleranze:
- DMM= h6
- DCSFWS= ±.002 Pollici
- BHTA= ±20'

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCSFMS	DMM	LF	OAL	BHTA°	Cilindrico
					inch	inch	inch	inch		
XE10.625J5-6.50-01.0E	10138079	5	J	E10	0.360	0.625	2.000	6.500	1,0	■
XE12.625J4-7.50-01.0E	10138080	4	J	E12	0.480	0.625	2.400	7.500	1,0	■
XE16.750J4-7.50-01.0E	10138081	4	J	E16	0.606	0.750	3.000	7.500	1,0	■
XE201.00J4-8.00-01.0E	10138082	4	J	E20	0.724	1.000	3.150	8.000	1,0	■
XE251.25G2-6.50-00.0E	10138078	2	G	E25	0.961	1.250	2.500	6.500	0,0	■
XE251.25J2-8.50-05.0E	10218131	2	J	E25	0.961	1.250	1.654	8.500	5,0	■

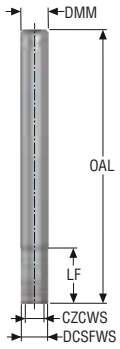
Parti di ricambio, comprese nella fornitura

Accessori

CZCMS	Chiave	Bit	Bit 1	Chiave dinamometrica
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Prodotto standard.

Densimet - In mm



E





- Tolleranze:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCSFWS	DMM	LF	OAL	BHTA°	Cilindrico
					mm	mm	mm	mm		
XE10100E2-100-00.0DM	10138115	2	E	E10	9,6	10,0	20,0	100,0	0,0	■
XE12120E2-110-00.0DM	10138116	2	E	E12	11,6	12,0	25,0	110,0	0,0	■
XE16160E2-130-00.0DM	10138117	2	E	E16	15,4	16,0	35,0	130,0	0,0	■
XE20200E2-160-00.0DM	10138118	2	E	E20	19,2	20,0	45,0	160,0	0,0	■
XE25250E2-185-00.0DM	10138119	2	E	E25	24,1	25,0	65,0	185,0	0,0	■

Parti di ricambio, comprese nella fornitura

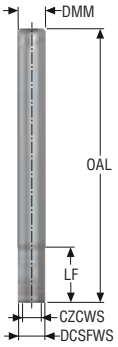
Accessori

CZCMS	Chiave	Bit	Bit 1	Chiave dinamometrica
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Prodotto standard.

Densimet - Pollici





E

- Tolleranze:
- DMM= h6
- DCSFWS= ±.002 Pollici



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCSFMS	DMM	LF	OAL	BHTA°	Cilindrico
					inch	inch	inch	inch		
XE251.00E2-7.28-00.0DM	10218132	2	E	E25	0.961	1.000	2.559	7.283	0,0	■

Parti di ricambio, comprese nella fornitura

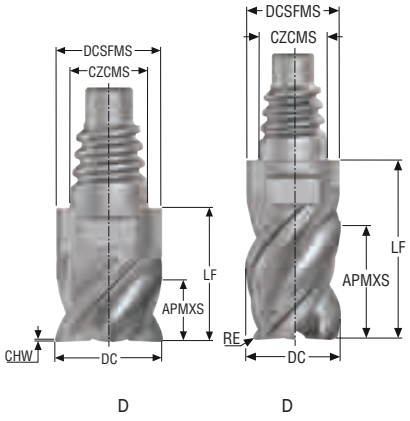
Accessori

CZCMS	Chiave	Bit	Chiave dinamometrica
			
E25	XW-E25	XTWH-E25.20	XTW-E16.E25

■ Prodotto standard.

XSE550

Alte prestazioni – Universale – Spallamento – 3 Eliche – Raggio di punta o smusso







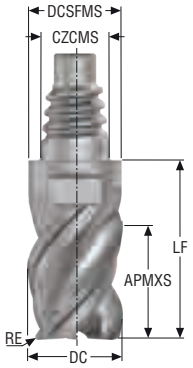
- Tolleranze:
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø12 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm	mm			SIRA
XSE550E25250D1CZ3	10219207	1	D	E25	25,0	24,2	13,75	25,5	0,3125	–	3	20	■
XSE550E10100D1R050Z3	10138138	1	D	E10	10,0	9,7	5,5	12,3	–	0,5	3	8	■
XSE550E10100D1R100Z3	10219210	1	D	E10	10,0	9,7	5,5	12,3	–	1,0	3	8	■
XSE550E10100D1R200Z3	10219211	1	D	E10	10,0	9,7	5,5	12,3	–	2,0	3	8	■
XSE550E12120D1R050Z3	10138139	1	D	E12	12,0	11,7	6,6	14,4	–	0,5	3	10	■
XSE550E12120D1R100Z3	10219212	1	D	E12	12,0	11,7	6,6	14,4	–	1,0	3	10	■
XSE550E12120D1R200Z3	10219213	1	D	E12	12,0	11,7	6,6	14,4	–	2,0	3	10	■
XSE550E16160D1R050Z3	10138140	1	D	E16	16,0	15,5	8,8	18,6	–	0,5	3	12	■
XSE550E16160D1R100Z3	10219214	1	D	E16	16,0	15,5	8,8	18,6	–	1,0	3	12	■
XSE550E16160D1R200Z3	10219215	1	D	E16	16,0	15,5	8,8	18,6	–	2,0	3	12	■
XSE550E20200D1R050Z3	10138141	1	D	E20	20,0	19,3	11,0	21,2	–	0,5	3	16	■
XSE550E20200D1R100Z3	10219216	1	D	E20	20,0	19,7	11,0	21,2	–	1,0	3	16	■
XSE550E20200D1R200Z3	10219217	1	D	E20	20,0	19,7	11,0	21,2	–	2,0	3	16	■
XSE550E25250D1R050Z3	10219208	1	D	E25	25,0	24,2	13,75	25,5	–	0,5	3	20	■
XSE550E25250D1R100Z3	10219209	1	D	E25	25,0	24,2	13,75	25,5	–	1,0	3	20	■
XSE550E10100D2R050Z3	10138142	2	D	E10	10,0	9,7	12,0	18,7	–	0,5	3	8	■
XSE550E10100D2R100Z3	10219218	2	D	E10	10,0	9,7	12,0	18,7	–	1,0	3	8	■
XSE550E10100D2R200Z3	10219219	2	D	E10	10,0	9,7	12,0	18,7	–	2,0	3	8	■
XSE550E12120D2R050Z3	10138143	2	D	E12	12,0	11,7	14,4	22,1	–	0,5	3	10	■
XSE550E12120D2R100Z3	10219220	2	D	E12	12,0	11,7	14,4	22,1	–	1,0	3	10	■
XSE550E12120D2R200Z3	10219221	2	D	E12	12,0	11,7	14,4	22,1	–	2,0	3	10	■
XSE550E16160D2R050Z3	10138144	2	D	E16	16,0	15,5	19,2	29,2	–	0,5	3	12	■
XSE550E16160D2R100Z3	10219222	2	D	E16	16,0	15,5	19,2	29,2	–	1,0	3	12	■
XSE550E16160D2R200Z3	10219223	2	D	E16	16,0	15,5	19,2	29,2	–	2,0	3	12	■
XSE550E20200D2R100Z3	10219224	2	D	E20	20,0	19,7	24,0	34,3	–	1,0	3	16	■
XSE550E20200D2R200Z3	10219225	2	D	E20	20,0	19,7	24,0	34,3	–	2,0	3	16	■
XSE550E20200D2R050Z3	10138145	2	D	E20	20,0	19,3	24,0	34,3	–	0,5	3	16	■

XSE550 – Pollici

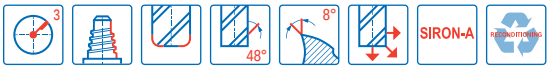
Alte prestazioni – Universale – Spallamento – 3 Eliche – Raggio di punta – Pollici





D

- Tolleranze:
- DC= e7
- RE= ±.0008 Pollici
- Riaffilatura possibile se DC è ≥Ø.500 Pollici



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XSE550E10.375D1R030Z3	10138146	1	D	E10	0.375	0.364	0.206	0.484	0.030	3	8	■
XSE550E12.500D1R030Z3	10138147	1	D	E12	0.500	0.484	0.275	0.567	0.030	3	10	■
XSE550E20.750D1R030Z3	10138148	1	D	E20	0.750	0.728	0.413	0.835	0.030	3	16	■
XSE550E10.375D2R030Z3	10138149	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8	■
XSE550E12.500D2R030Z3	10138150	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10	■
XSE550E20.750D2R030Z3	10138151	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16	■

.

Parametri di taglio – XSE550 – Contornatura PCEDC 3

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	185 (140 — 220) *610 (460 — 720)*
P2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	175 (140 — 210) *570 (460 — 680)*
P3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	155 (120 — 190) *510 (400 — 620)*
P4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	135 (110 — 170) *445 (370 — 550)*
P5	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	130 (98 — 160) *425 (330 — 520)*
P6	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	145 (110 — 180) *475 (370 — 590)*
P7	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	140 (110 — 170) *460 (370 — 550)*
P8	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	130 (97 — 160) *425 (320 — 520)*
P11	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 100) *310 (270 — 320)*
P12	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	60 (51 — 67) *195 (170 — 210)*
M1	E/M/A	0,30 *0.30*	1,1 *1.1*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	105 (92 — 120) *345 (310 — 390)*
M2	E/M/A	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	90 (76 — 100) *295 (250 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	55 (44 — 68) *180 (150 — 220)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	43 (34 — 52) *140 (120 — 170)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	36 (28 — 43) *120 (92 — 140)*
K1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	140 (130 — 160) *460 (430 — 520)*
K3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	120 (110 — 130) *395 (370 — 420)*
K4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	115 (97 — 120) *375 (320 — 390)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	200 (170 — 220) *660 (560 — 720)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	180 (150 — 200) *590 (500 — 650)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	600 (560 — 780) *1975 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	390 (360 — 500) *1275 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	260 (240 — 330) *850 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	32 (26 — 40) *105 (86 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	28 (21 — 34) *90 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	24 (19 — 30) *80 (63 — 98)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	75 (62 — 92) *245 (210 — 300)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	80 (64 — 95) *260 (210 — 310)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	80 (64 — 95) *260 (210 — 310)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (50 — 74) *195 (170 — 240)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	280 (170 — 390) *920 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	550 (450 — 660) *1800 (1500 — 2100)*

Parametri di taglio – XSE550 – Scanalatura PCEDC 3

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	75 (64 — 84) *245 (210 — 270)*
P12	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	45 (39 — 51) *150 (130 — 160)*
M1	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	85 (75 — 99) *280 (250 — 320)*
M2	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	105 (88 — 110) *345 (290 — 360)*
K4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	100 (84 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	125 (100 — 130) *410 (330 — 420)*
K6	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	540 (500 — 690) *1775 (1700 — 2200)*
N2	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	345 (330 — 440) *1125 (1100 — 1400)*
N3	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	230 (220 — 290) *750 (730 — 950)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	20 (15 — 25) *65 (50 — 82)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	50 (41 — 60) *165 (140 — 190)*
H8	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H21	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H31	M/A	0,30 *0.30*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	39 (32 — 46) *130 (110 — 150)*
TS1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	490 (410 — 600) *1600 (1400 — 1900)*

Parametri di taglio – XSE550 – Contornatura PCEDC 3 – Pollici

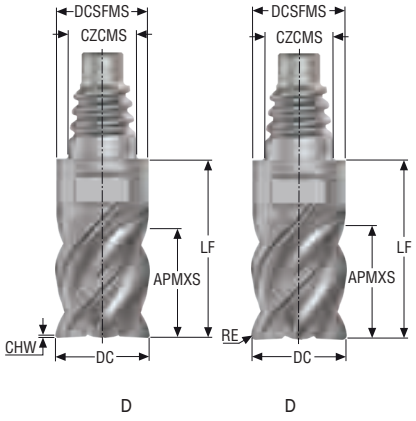
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	215 (190 — 240) *710 (630 — 780)*
P2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	160 (140 — 180) *520 (460 — 590)*
P5	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	105 (93 — 110) *345 (310 — 360)*
P12	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (60 — 75) *215 (200 — 240)*
M1	E/M/A	0,30 *0.30*	1,1 *1.1*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	120 (110 — 130) *395 (370 — 420)*
M2	E/M/A	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	100 (88 — 110) *330 (290 — 360)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (50 — 74) *195 (170 — 240)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	48 (39 — 57) *155 (130 — 180)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	40 (32 — 47) *130 (110 — 150)*
K1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	170 (160 — 200) *560 (530 — 650)*
K2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	150 (150 — 180) *490 (500 — 590)*
K3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	125 (120 — 150) *410 (400 — 490)*
K4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	120 (120 — 140) *395 (400 — 450)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	200 (180 — 220) *660 (600 — 720)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 780) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 500) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	75 (62 — 92) *245 (210 — 300)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (50 — 74) *195 (170 — 240)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 780) *2200 (1900 — 2500)*

Parametri di taglio – XSE550 – Scanalatura PCEDC 3 – Pollici

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	50 (46 — 58) *165 (160 — 190)*
M1	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	80 (70 — 89) *260 (230 — 290)*
M3	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	50 (41 — 60) *165 (140 — 190)*
M4	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (140 — 180) *490 (460 — 590)*
K2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H8	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H21	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H31	M/A	0,30 *0.30*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	39 (32 — 46) *130 (110 — 150)*
TS1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 690) *1975 (1700 — 2200)*

XSE550

Alte prestazioni – Universale – Spallamento – 4 Eliche – Raggio di punta o smusso







- Tolleranze:
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø12 mm

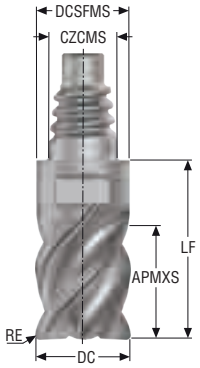
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm	mm			SIRA
XSE550E10100D1CZ4	10219229	1	D	E10	10,0	9,7	5,5	12,3	0,125	–	4	8	■
XSE550E12120D1CZ4	10219230	1	D	E12	12,0	11,7	6,6	14,4	0,15	–	4	10	■
XSE550E16160D1CZ4	10219231	1	D	E16	16,0	15,5	88,0	18,6	0,2	–	4	12	■
XSE550E20200D1CZ4	10219232	1	D	E20	20,0	19,7	11,0	21,2	0,25	–	4	16	■
XSE550E25250D1CZ4	10219226	1	D	E25	25,0	24,2	13,75	25,5	0,3125	–	4	20	■
XSE550E10100D2CZ4	10138152	2	D	E10	10,0	9,7	12,0	18,7	0,125	–	4	8	■
XSE550E12120D2CZ4	10138153	2	D	E12	12,0	11,7	14,4	22,1	0,15	–	4	10	■
XSE550E16160D2CZ4	10138154	2	D	E16	16,0	15,5	19,2	29,2	0,2	–	4	12	■
XSE550E20200D2CZ4	10138155	2	D	E20	20,0	19,3	24,0	34,3	0,25	–	4	16	■
XSE550E10100D1R100Z4	10219233	1	D	E10	10,0	9,7	5,5	12,3	–	1,0	4	8	■
XSE550E10100D1R200Z4	10219234	1	D	E10	10,0	9,7	5,5	12,3	–	2,0	4	8	■
XSE550E12120D1R100Z4	10219235	1	D	E12	12,0	11,7	6,6	14,4	–	1,0	4	10	■
XSE550E12120D1R200Z4	10219236	1	D	E12	12,0	11,7	6,6	14,4	–	2,0	4	10	■
XSE550E16160D1R100Z4	10219237	1	D	E16	16,0	15,5	8,8	18,6	–	1,0	4	12	■
XSE550E16160D1R200Z4	10219238	1	D	E16	16,0	15,5	8,8	18,6	–	2,0	4	12	■
XSE550E20200D1R200Z4	10219239	1	D	E20	20,0	19,7	11,0	21,2	–	2,0	4	16	■
XSE550E25250D1R100Z4	10219227	1	D	E25	25,0	24,2	13,75	25,5	–	1,0	4	20	■
XSE550E25250D1R200Z4	10219228	1	D	E25	25,0	24,2	13,75	25,5	–	2,0	4	20	■
XSE550E10100D1R050Z4	10138156	1	D	E10	10,0	9,7	5,5	12,3	–	0,5	4	8	■
XSE550E12120D1R050Z4	10138157	1	D	E12	12,0	11,7	6,6	14,4	–	0,5	4	10	■
XSE550E16160D1R050Z4	10138158	1	D	E16	16,0	15,5	8,8	18,6	–	0,5	4	12	■
XSE550E20200D1R100Z4	10138159	1	D	E20	20,0	19,3	11,0	21,2	–	1,0	4	16	■
XSE550E10100D2R100Z4	10138161	2	D	E10	10,0	9,7	12,0	18,7	–	1,0	4	8	■
XSE550E12120D2R100Z4	10138165	2	D	E12	12,0	11,7	14,4	22,1	–	1,0	4	10	■
XSE550E16160D2R100Z4	10138169	2	D	E16	16,0	15,5	19,2	29,2	–	1,0	4	12	■
XSE550E20200D2R100Z4	10138172	2	D	E20	20,0	19,3	24,0	34,3	–	1,0	4	16	■
XSE550E10100D2R050Z4	10138160	2	D	E10	10,0	9,7	12,0	18,7	–	0,5	4	8	■
XSE550E10100D2R200Z4	10138162	2	D	E10	10,0	9,7	12,0	18,7	–	2,0	4	8	■
XSE550E10100D2R250Z4	10138163	2	D	E10	10,0	9,7	12,0	18,7	–	2,5	4	8	■

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm	mm			SIRA
XSE550E12120D2R050Z4	10138164	2	D	E12	12,0	11,7	14,4	22,1	–	0,5	4	10	■
XSE550E12120D2R200Z4	10138166	2	D	E12	12,0	11,7	14,4	22,1	–	2,0	4	10	■
XSE550E12120D2R300Z4	10138167	2	D	E12	12,0	11,7	14,4	22,1	–	3,0	4	10	■
XSE550E16160D2R050Z4	10138168	2	D	E16	16,0	15,5	19,2	29,2	–	0,5	4	12	■
XSE550E16160D2R200Z4	10138170	2	D	E16	16,0	15,5	19,2	29,2	–	2,0	4	12	■
XSE550E16160D2R300Z4	10138171	2	D	E16	16,0	15,5	19,2	29,2	–	3,0	4	12	■
XSE550E20200D2R200Z4	10138173	2	D	E20	20,0	19,3	24,0	34,3	–	2,0	4	16	■
XSE550E20200D2R300Z4	10138174	2	D	E20	20,0	19,3	24,0	34,3	–	3,0	4	16	■
XSE550E20200D2R400Z4	10138175	2	D	E20	20,0	19,3	24,0	34,3	–	4,0	4	16	■

■ Prodotto standard.

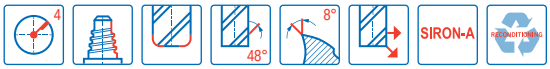
XSE550 – Pollici

Alte prestazioni – Universale – Spallamento – 4 Eliche – Raggio di punta – Pollici



D





- Tolleranze:
- DC= e7
- RE= ±.0008 Pollici
- Riaffilatura possibile se DC è ≥Ø.500 Pollici

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XSE550E10.375D1R030Z4	10138176	1	D	E10	0.375	0.364	0.206	0.484	0.030	4	8	■
XSE550E12.500D1R030Z4	10138177	1	D	E12	0.500	0.484	0.275	0.567	0.030	4	10	■
XSE550E20.750D1R030Z4	10138178	1	D	E20	0.750	0.728	0.413	0.835	0.030	4	16	■
XSE550E10.375D2R030Z4	10138179	2	D	E10	0.375	0.364	0.450	0.720	0.030	4	8	■
XSE550E12.500D2R030Z4	10138180	2	D	E12	0.500	0.484	0.600	0.906	0.030	4	10	■
XSE550E20.750D2R030Z4	10138181	2	D	E20	0.750	0.728	0.900	1.295	0.030	4	16	■

■ Prodotto standard.

Parametri di taglio – XSE550 – Contornatura PCEDC 4

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	170 (130 — 210) *560 (430 — 680)*
P2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	165 (130 — 200) *540 (430 — 650)*
P3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	145 (110 — 180) *475 (370 — 590)*
P4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	130 (97 — 160) *425 (320 — 520)*
P5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	125 (93 — 150) *410 (310 — 490)*
P6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 170) *460 (370 — 550)*
P7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	130 (98 — 160) *425 (330 — 520)*
P8	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	120 (91 — 150) *395 (300 — 490)*
P11	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	85 (72 — 100) *280 (240 — 320)*
P12	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	55 (46 — 68) *180 (160 — 220)*
M1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	95 (83 — 120) *310 (280 — 390)*
M2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	80 (69 — 100) *260 (230 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	47 (36 — 58) *155 (120 — 190)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	36 (28 — 45) *120 (92 — 140)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	30 (23 — 37) *100 (76 — 120)*
K1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
K2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	130 (120 — 150) *425 (400 — 490)*
K3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	110 (96 — 120) *360 (320 — 390)*
K4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	105 (92 — 120) *345 (310 — 390)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	215 (190 — 240) *710 (630 — 780)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	190 (170 — 210) *620 (560 — 680)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	550 (450 — 660) *1800 (1500 — 2100)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	355 (290 — 420) *1175 (960 — 1300)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	240 (200 — 280) *790 (660 — 910)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	310 (280 — 380) *1025 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	32 (26 — 40) *105 (86 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	28 (21 — 34) *90 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	24 (19 — 30) *80 (63 — 98)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	90 (77 — 120) *295 (260 — 390)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	70 (59 — 93) *230 (200 — 300)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	55 (47 — 74) *180 (160 — 240)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	75 (59 — 73) *245 (200 — 230)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	75 (62 — 76) *245 (210 — 240)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	75 (62 — 76) *245 (210 — 240)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (48 — 59) *195 (160 — 190)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	275 (170 — 380) *900 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	275 (170 — 380) *900 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	550 (450 — 660) *1800 (1500 — 2100)*

Parametri di taglio – XSE550 – Scanalatura PCEDC 4

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	75 (64 — 94) *245 (210 — 300)*
P12	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	44 (38 — 55) *145 (130 — 180)*
M1	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	85 (75 — 110) *280 (250 — 360)*
M2	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	70 (60 — 90) *230 (200 — 290)*
M3	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	40 (30 — 50) *130 (99 — 160)*
M4	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	30 (23 — 37) *100 (76 — 120)*
M5	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	25 (19 — 31) *80 (63 — 100)*
K1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	105 (88 — 110) *345 (290 — 360)*
K4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	100 (84 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 160) *460 (400 — 520)*
K6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	320 (260 — 380) *1050 (860 — 1200)*
N3	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	215 (180 — 250) *710 (600 — 820)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	280 (250 — 340) *920 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	80 (65 — 100) *260 (220 — 320)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	60 (50 — 79) *195 (170 — 250)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	46 (39 — 61) *150 (130 — 200)*
H5	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	50 (41 — 50) *165 (140 — 160)*
H8	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 50) *165 (140 — 160)*
H21	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 50) *165 (140 — 160)*
H31	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	38 (31 — 38) *125 (110 — 120)*
TS1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	500 (410 — 590) *1650 (1400 — 1900)*

Parametri di taglio – XSE550 – Contornatura PCEDC 4 – Pollici

SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	150 (140 — 170) *490 (460 — 550)*
P8	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	140 (130 — 160) *460 (430 — 520)*
P11	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	95 (84 — 100) *310 (280 — 320)*
P12	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	60 (54 — 68) *195 (180 — 220)*
M1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	110 (97 — 120) *360 (320 — 390)*
M2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	90 (80 — 100) *295 (270 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (47 — 70) *195 (160 — 220)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (37 — 54) *150 (130 — 170)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	38 (31 — 45) *125 (110 — 140)*
K1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	160 (160 — 190) *520 (530 — 620)*
K2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	140 (140 — 170) *460 (460 — 550)*
K3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	120 (120 — 140) *395 (400 — 450)*
K4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	115 (110 — 130) *375 (370 — 420)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	215 (190 — 240) *710 (630 — 780)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	190 (170 — 210) *620 (560 — 680)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 770) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 490) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	75 (59 — 73) *245 (200 — 230)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (48 — 59) *195 (160 — 190)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 770) *2200 (1900 — 2500)*

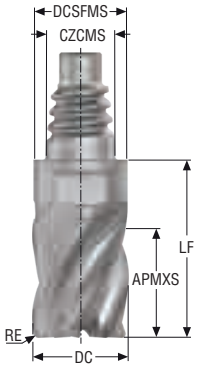
Parametri di taglio – XSE550 – Scanalatura PCEDC 4 – Pollici

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (44 — 55) *165 (150 — 180)*
M1	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	80 (70 — 90) *260 (230 — 290)*
M3	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (40 — 60) *165 (140 — 190)*
M4	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (150 — 180) *490 (500 — 590)*
K2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 160) *460 (400 — 520)*
K6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 350) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (65 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 90) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H8	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H21	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H31	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	38 (31 — 38) *125 (110 — 120)*
TS1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 700) *1975 (1700 — 2200)*

XSE550

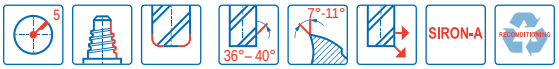
Alte prestazioni – Universale – Spallamento – 5 Eliche – Raggio di punta





D

- Tolleranze:
- DC= 0/-0,0508 mm
- RE= ±0,0254 mm
- Riaffilatura possibile se DC è ≥Ø12 mm

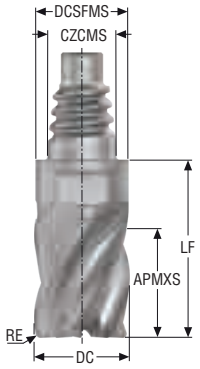


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D2R050Z5	10138337	2	D	E10	10,0	9,7	12,0	18,7	0,5	5	8	■
XSE550E10100D2R100Z5	10138338	2	D	E10	10,0	9,7	12,0	18,7	1,0	5	8	■
XSE550E12120D2R050Z5	10138339	2	D	E12	12,0	11,7	14,4	22,1	0,5	5	10	■
XSE550E12120D2R100Z5	10138340	2	D	E12	12,0	11,7	14,4	22,1	1,0	5	10	■
XSE550E16160D2R050Z5	10138341	2	D	E16	16,0	15,5	19,2	29,2	0,5	5	12	■
XSE550E16160D2R100Z5	10138342	2	D	E16	16,0	15,5	19,2	29,2	1,0	5	12	■
XSE550E20200D2R050Z5	10138343	2	D	E20	20,0	19,3	24,0	34,3	0,5	5	16	■
XSE550E20200D2R100Z5	10138344	2	D	E20	20,0	19,3	24,0	34,3	1,0	5	16	■

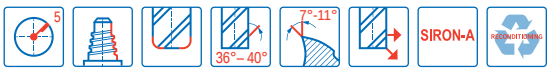
■ Prodotto standard.

XSE550

Alte prestazioni – Universale – Spallamento – 5 Eliche – Raggio di punta – Pollici



D





- Tolleranze:
- DC= 0/-.002 Pollici
- RE= ±.001 Pollici
- Riaffilatura possibile se DC è ≥Ø.500 Pollici

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XSE550E10.375D2R015Z5	10138345	2	D	E10	0.375	0.364	0.450	0.720	0.015	5	8	■
XSE550E10.375D2R030Z5	10138346	2	D	E10	0.375	0.364	0.450	0.720	0.030	5	8	■
XSE550E10.375D2R045Z5	10138347	2	D	E10	0.375	0.364	0.450	0.720	0.044	5	8	■
XSE550E12.500D2R030Z5	10138348	2	D	E12	0.500	0.484	0.600	0.906	0.030	5	10	■
XSE550E12.500D2R060Z5	10138349	2	D	E12	0.500	0.484	0.600	0.906	0.060	5	10	■
XSE550E12.500D2R120Z5	10138350	2	D	E12	0.500	0.484	0.600	0.906	0.120	5	10	■
XSE550E16.625D2R030Z5	10138351	2	D	E16	0.625	0.610	0.750	1.150	0.030	5	12	■
XSE550E16.625D2R060Z5	10138352	2	D	E16	0.625	0.610	0.750	1.150	0.060	5	12	■
XSE550E16.625D2R120Z5	10138353	2	D	E16	0.625	0.610	0.750	1.150	0.120	5	12	■
XSE550E20.750D2R030Z5	10138354	2	D	E20	0.750	0.728	0.900	1.295	0.030	5	16	■
XSE550E20.750D2R060Z5	10138355	2	D	E20	0.750	0.728	0.900	1.295	0.060	5	16	■
XSE550E20.750D2R120Z5	10138356	2	D	E20	0.750	0.728	0.900	1.295	0.120	5	16	■
XSE550E251.00D2R030Z5	10138357	2	D	E25	1.000	0.965	1.200	1.673	0.030	5	20	■
XSE550E251.00D2R060Z5	10138358	2	D	E25	1.000	0.965	1.200	1.673	0.060	5	20	■
XSE550E251.00D2R120Z5	10138359	2	D	E25	1.000	0.965	1.200	1.673	0.120	5	20	■

■ Prodotto standard.

Parametri di taglio – XSE550 – Contornatura PCEDC 5

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	165 (130 — 190) *540 (430 — 620)*
P2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	160 (130 — 190) *520 (430 — 620)*
P3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 160) *460 (370 — 520)*
P4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	125 (97 — 140) *410 (320 — 450)*
P5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	110 (97 — 130) *360 (320 — 420)*
P6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 150) *410 (370 — 490)*
P7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	120 (110 — 140) *395 (370 — 450)*
P8	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	110 (97 — 130) *360 (320 — 420)*
P11	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (89 — 110) *330 (300 — 360)*
P12	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	65 (56 — 71) *215 (190 — 230)*
M1	E/M/A	0,20 *0.20*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	115 (110 — 120) *375 (370 — 390)*
M2	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	95 (84 — 100) *310 (280 — 320)*
M3	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (47 — 69) *195 (160 — 220)*
M4	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	44 (36 — 53) *145 (120 — 170)*
M5	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (30 — 44) *120 (99 — 140)*
K1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	130 (120 — 150) *425 (400 — 490)*
K2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	115 (98 — 130) *375 (330 — 420)*
K3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	100 (83 — 110) *330 (280 — 360)*
K4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	95 (79 — 100) *310 (260 — 320)*
K5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	105 (89 — 130) *345 (300 — 420)*
K6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	155 (130 — 190) *510 (430 — 620)*
K7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	135 (120 — 160) *445 (400 — 520)*
N1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*
N2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	445 (380 — 520) *1450 (1300 — 1700)*
N3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	300 (250 — 340) *980 (830 — 1100)*
N11	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	345 (290 — 400) *1125 (960 — 1300)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	27 (24 — 41) *90 (79 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	26 (21 — 35) *85 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	25 (19 — 30) *80 (63 — 98)*
S11	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	65 (52 — 88) *215 (180 — 280)*
S12	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	50 (40 — 68) *165 (140 — 220)*
S13	E	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	41 (32 — 54) *135 (110 — 170)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	70 (56 — 83) *230 (190 — 270)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	55 (45 — 67) *180 (150 — 210)*
TS1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
GR1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	520 (470 — 630) *1700 (1600 — 2000)*

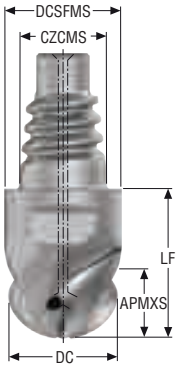
Parametri di taglio – XSE550 – Contornatura PCEDC 5 – Pollici

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P8	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (130 — 160) *475 (430 — 520)*
P11	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (89 — 110) *330 (300 — 360)*
P12	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	65 (56 — 71) *215 (190 — 230)*
M1	E/M/A	0,20 *0.20*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	115 (110 — 120) *375 (370 — 390)*
M2	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	95 (84 — 100) *310 (280 — 320)*
M3	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (47 — 69) *195 (160 — 220)*
M4	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	44 (36 — 53) *145 (120 — 170)*
M5	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (30 — 44) *120 (99 — 140)*
K1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	165 (160 — 190) *540 (530 — 620)*
K2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	145 (140 — 170) *475 (460 — 550)*
K3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	125 (120 — 140) *410 (400 — 450)*
K4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	120 (110 — 140) *395 (370 — 450)*
K5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	200 (170 — 220) *660 (560 — 720)*
N1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*
N2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	445 (380 — 520) *1450 (1300 — 1700)*
N3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	300 (250 — 340) *980 (830 — 1100)*
N11	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	345 (290 — 400) *1125 (960 — 1300)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	44 (27 — 61) *145 (89 — 200)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	35 (22 — 49) *115 (73 — 160)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	31 (19 — 43) *100 (63 — 140)*
S11	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	105 (75 — 130) *345 (250 — 420)*
S12	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	80 (58 — 100) *260 (200 — 320)*
S13	E	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	65 (46 — 81) *215 (160 — 260)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	70 (56 — 83) *230 (190 — 270)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	55 (45 — 67) *180 (150 — 210)*
TS1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
GR1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*

XSB540

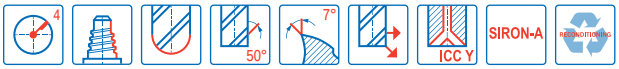
Alte prestazioni – Universale – A testa sferica – 4 Eliche – ICC





D

- Tolleranze:
- DC= e8
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø12 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Qualità
						mm	mm	mm	mm			SIRA
XSB540E10100D1BZ4A	10138334	1	D	✓	E10	10,0	9,7	5,5	12,3	4	8	■
XSB540E12120D1BZ4A	10138335	1	D	✓	E12	12,0	11,7	6,6	14,4	4	10	■
XSB540E16160D1BZ4A	10138336	1	D	✓	E16	16,0	15,5	8,8	18,6	4	12	■

■ Prodotto standard.

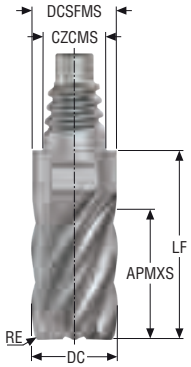
Parametri di taglio – XSB540 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	150 (130 — 170) *490 (430 — 550)*
P6	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	190 (160 — 220) *620 (530 — 720)*
P12	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	115 (97 — 130) *375 (320 — 420)*
M1	E/M/A	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	145 (120 — 170) *475 (400 — 550)*
M2	E/M/A	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	115 (97 — 130) *375 (320 — 420)*
M3	E/M/A	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	95 (75 — 110) *310 (250 — 360)*
M4	E/M/A	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	75 (57 — 88) *245 (190 — 280)*
M5	E/M/A	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	60 (48 — 74) *195 (160 — 240)*
K1	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	205 (190 — 220) *670 (630 — 720)*
K2	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	180 (160 — 190) *590 (530 — 620)*
K3	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	150 (140 — 160) *490 (460 — 520)*
K4	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	170 (150 — 190) *560 (500 — 620)*
K5	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*	105 (90 — 110) *345 (300 — 360)*
K6	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	150 (140 — 160) *490 (460 — 520)*
K7	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*	130 (120 — 140) *425 (400 — 450)*
N1	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	640 (540 — 740) *2100 (1800 — 2400)*
N2	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	415 (350 — 480) *1350 (1200 — 1500)*
N3	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	275 (230 — 320) *900 (760 — 1000)*
N11	E/M/A	0,15 *0.15*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	430 (380 — 480) *1400 (1300 — 1500)*
S1	E	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	65 (54 — 74) *215 (180 — 240)*
S2	E	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	65 (59 — 75) *215 (200 — 240)*
S3	E	0,10 *0.10*	0,50 *0.50*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*	32 (22 — 42) *105 (73 — 130)*
S11	E	0,15 *0.15*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	110 (98 — 120) *360 (330 — 390)*
S12	E	0,15 *0.15*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	85 (75 — 96) *280 (250 — 310)*
S13	E	0,15 *0.15*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	65 (59 — 75) *215 (200 — 240)*
H5	M/A	0,030 *0.030*	0,44 *0.44*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
H8	M/A	0,030 *0.030*	0,44 *0.44*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
H21	M/A	0,030 *0.030*	0,44 *0.44*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
H31	M/A	0,030 *0.030*	0,44 *0.44*	0,034 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	100 (86 — 110) *330 (290 — 360)*
TS1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	270 (170 — 370) *890 (560 — 1200)*
TP1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	270 (170 — 370) *890 (560 — 1200)*
GR1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	640 (540 — 740) *2100 (1800 — 2400)*

XSE720

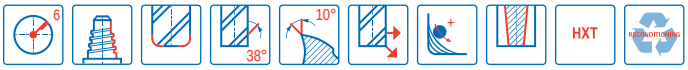
Alte prestazioni – Superlega – Spallamento – 6 Eliche – Raggio di punta





D

- Tolleranze:
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø12 mm

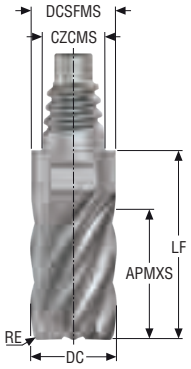


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			HXT
XSE720E10100D3R050Z6	10138187	3	D	E10	10,0	9,7	15,0	21,8	0,5	6	8	■
XSE720E10100D3R100Z6	10138188	3	D	E10	10,0	9,7	15,0	21,8	1,0	6	8	■
XSE720E12120D3R050Z6	10138189	3	D	E12	12,0	11,7	18,0	25,9	0,5	6	10	■
XSE720E12120D3R100Z6	10138190	3	D	E12	12,0	11,7	18,0	25,9	1,0	6	10	■
XSE720E12120D3R200Z6	10138191	3	D	E12	12,0	11,7	18,0	25,9	2,0	6	10	■
XSE720E12120D3R300Z6	10138192	3	D	E12	12,0	11,7	18,0	25,9	3,0	6	10	■
XSE720E16160D3R050Z6	10138193	3	D	E16	16,0	15,5	24,0	34,1	0,5	6	12	■
XSE720E16160D3R100Z6	10138194	3	D	E16	16,0	15,5	24,0	34,1	1,0	6	12	■
XSE720E16160D3R200Z6	10138195	3	D	E16	16,0	15,5	24,0	34,1	2,0	6	12	■
XSE720E16160D3R300Z6	10138196	3	D	E16	16,0	15,5	24,0	34,1	3,0	6	12	■
XSE720E20200D3R050Z6	10138197	3	D	E20	20,0	19,3	30,0	40,2	0,5	6	16	■
XSE720E20200D3R100Z6	10138198	3	D	E20	20,0	19,3	30,0	40,2	1,0	6	16	■
XSE720E20200D3R200Z6	10138199	3	D	E20	20,0	19,3	30,0	40,2	2,0	6	16	■
XSE720E20200D3R300Z6	10138200	3	D	E20	20,0	19,3	30,0	40,2	3,0	6	16	■
XSE720E25250D3R200Z6	10138201	3	D	E25	25,0	24,2	37,5	49,5	2,0	6	20	■
XSE720E25250D3R300Z6	10138202	3	D	E25	25,0	24,2	37,5	49,5	3,0	6	20	■
XSE720E25250D3R400Z6	10138203	3	D	E25	25,0	24,2	37,5	49,5	4,0	6	20	■

■ Prodotto standard.

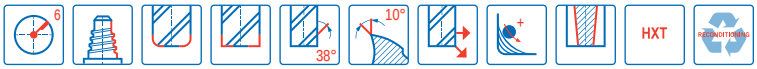
XSE720

Alte prestazioni – Superlega – Spallamento – 6 Eliche – Raggio di punta o spigolo vivo – Pollici



D





- Tolleranze:
- DC= e7
- RE= ±.0008 Pollici
- Riaffilatura possibile se DC è ≥Ø.500 Pollici

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			HXT
XSE720E10.375D3SZ6	10138204	3	D	E10	0.375	0.364	0.563	0.827	–	6	8	■
XSE720E12.500D3SZ6	10138205	3	D	E12	0.500	0.484	0.750	1.055	–	6	10	■
XSE720E16.625D3SZ6	10138206	3	D	E16	0.625	0.610	0.938	1.343	–	6	12	■
XSE720E20.750D3SZ6	10138207	3	D	E20	0.750	0.728	1.125	1.524	–	6	16	■
XSE720E251.00D3SZ6	10138208	3	D	E25	1.000	0.965	1.500	1.980	–	6	20	■
XSE720E10.375D3R030Z6	10138209	3	D	E10	0.375	0.364	0.563	0.827	0.030	6	8	■
XSE720E12.500D3R030Z6	10138210	3	D	E12	0.500	0.484	0.750	1.055	0.030	6	10	■
XSE720E12.500D3R060Z6	10138211	3	D	E12	0.500	0.484	0.750	1.055	0.060	6	10	■
XSE720E12.500D3R120Z6	10138212	3	D	E12	0.500	0.484	0.750	1.055	0.120	6	10	■
XSE720E16.625D3R030Z6	10138213	3	D	E16	0.625	0.610	0.938	1.343	0.030	6	12	■
XSE720E16.625D3R060Z6	10138214	3	D	E16	0.625	0.610	0.938	1.343	0.060	6	12	■
XSE720E16.625D3R120Z6	10138215	3	D	E16	0.625	0.610	0.938	1.343	0.120	6	12	■
XSE720E20.750D3R030Z6	10138216	3	D	E20	0.750	0.728	1.125	1.524	0.030	6	16	■
XSE720E20.750D3R060Z6	10138217	3	D	E20	0.750	0.728	1.125	1.524	0.060	6	16	■
XSE720E20.750D3R120Z6	10138218	3	D	E20	0.750	0.728	1.125	1.524	0.120	6	16	■
XSE720E251.00D3R030Z6	10138219	3	D	E25	1.000	0.965	1.500	1.980	0.030	6	20	■
XSE720E251.00D3R060Z6	10138220	3	D	E25	1.000	0.965	1.500	1.980	0.060	6	20	■
XSE720E251.00D3R120Z6	10138221	3	D	E25	1.000	0.965	1.500	1.980	0.120	6	20	■

■ Prodotto standard.

Parametri di taglio – XSE720 Contornatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	230 (180 — 280) *750 (600 — 910)*
P2	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	220 (170 — 270) *720 (560 — 880)*
P3	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (150 — 230) *640 (500 — 750)*
P4	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	170 (130 — 200) *560 (430 — 650)*
P5	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	130 (100 — 160) *425 (330 — 520)*
P6	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	145 (120 — 190) *475 (400 — 620)*
P7	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	140 (110 — 180) *460 (370 — 590)*
P8	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	130 (100 — 160) *425 (330 — 520)*
P11	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	130 (110 — 170) *425 (370 — 550)*
P12	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	95 (80 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	140 (120 — 150) *460 (400 — 490)*
M3	E/M/A	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	120 (100 — 130) *395 (330 — 420)*
M4	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	90 (77 — 100) *295 (260 — 320)*
M5	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	75 (64 — 88) *245 (210 — 280)*
S1	E	0,060 *0.060*	1,4 *1.4*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	35 (25 — 44) *115 (83 — 140)*
S3	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	30 (20 — 39) *100 (66 — 120)*
S11	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,10 *0.10*	1,4 *1.4*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	65 (48 — 79) *215 (160 — 250)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XSE720 sgrossatura avanzata

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	245 (190 — 300) *800 (630 — 980)*
P2	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	240 (190 — 290) *790 (630 — 950)*
P3	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	205 (160 — 250) *670 (530 — 820)*
P4	E/M/A/D	1,4 *1.4*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	185 (140 — 220) *610 (460 — 720)*
P5	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 180) *460 (370 — 590)*
P6	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	155 (130 — 200) *510 (430 — 650)*
P7	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (120 — 190) *490 (400 — 620)*
P8	E/M/A/D	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	140 (110 — 180) *460 (370 — 590)*
P11	E/M/A/D	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	140 (110 — 180) *460 (370 — 590)*
P12	E/M/A/D	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (86 — 110) *330 (290 — 360)*
M1	E/M/A	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	180 (160 — 200) *590 (530 — 650)*
M2	E/M/A	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,4 *1.4*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 140) *410 (370 — 450)*
M4	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 110) *310 (270 — 360)*
M5	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	80 (67 — 92) *260 (220 — 300)*
S1	E	1,4 *1.4*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	44 (35 — 53) *145 (120 — 170)*
S2	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	34 (25 — 43) *110 (83 — 140)*
S3	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	29 (20 — 39) *95 (66 — 120)*
S11	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	65 (50 — 83) *215 (170 — 270)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XSE720 Contornatura – Pollici

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	265 (200 — 320) *870 (660 — 1000)*
P2	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	255 (200 — 320) *840 (660 — 1000)*
P3	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (170 — 270) *740 (560 — 880)*
P4	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	195 (150 — 240) *640 (500 — 780)*
P5	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	160 (120 — 190) *520 (400 — 620)*
P6	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	180 (140 — 220) *590 (460 — 720)*
P7	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	170 (130 — 210) *560 (430 — 680)*
P8	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	160 (120 — 190) *520 (400 — 620)*
P11	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	160 (130 — 200) *520 (430 — 650)*
P12	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	95 (80 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	140 (120 — 150) *460 (400 — 490)*
M3	E/M/A	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	120 (100 — 110) *395 (330 — 360)*
M4	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	90 (77 — 91) *295 (260 — 290)*
M5	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	75 (64 — 76) *245 (210 — 240)*
S1	E	0,060 *0.060*	1,4 *1.4*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	35 (25 — 44) *115 (83 — 140)*
S3	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	30 (20 — 39) *100 (66 — 120)*
S11	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,10 *0.10*	1,4 *1.4*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	65 (48 — 79) *215 (160 — 250)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XSE720 sgrossatura avanzata – Pollici

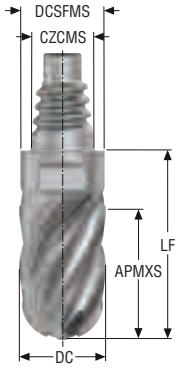
SMG		a_p/DC	f_z					v_c
			3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	285 (220 — 350) *940 (730 — 1100)*
P2	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	275 (210 — 340) *900 (690 — 1100)*
P3	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	240 (180 — 290) *790 (600 — 950)*
P4	E/M/A/D	1,4 *1.4*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	210 (160 — 260) *690 (530 — 850)*
P5	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	175 (130 — 210) *570 (430 — 680)*
P6	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (150 — 240) *640 (500 — 780)*
P7	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	185 (140 — 220) *610 (460 — 720)*
P8	E/M/A/D	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	170 (130 — 210) *560 (430 — 680)*
P11	E/M/A/D	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	170 (130 — 210) *560 (430 — 680)*
P12	E/M/A/D	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (86 — 110) *330 (290 — 360)*
M1	E/M/A	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	180 (160 — 200) *590 (530 — 650)*
M2	E/M/A	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,4 *1.4*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 120) *410 (370 — 390)*
M4	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 95) *310 (270 — 310)*
M5	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	80 (67 — 79) *260 (220 — 250)*
S1	E	1,4 *1.4*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	44 (35 — 53) *145 (120 — 170)*
S2	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	34 (25 — 43) *110 (83 — 140)*
S3	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	29 (20 — 39) *95 (66 — 120)*
S11	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	65 (50 — 83) *215 (170 — 270)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

XSB720

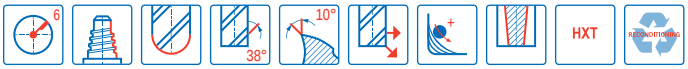
Alte prestazioni – Superlega – A testa sferica – 6 Eliche





D

- Tolleranze:
- DC= e7
- RE= ±0,02 mm
- Riaffilatura possibile se DC è ≥Ø12 mm

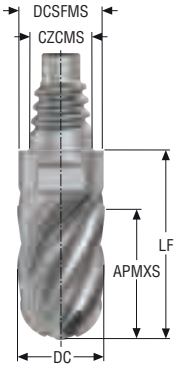


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Qualità
					mm	mm	mm	mm			HXT
XSB720E10100D3BZ6	10138222	3	D	E10	10,0	9,7	15,0	21,8	6	8	■
XSB720E12120D3BZ6	10138223	3	D	E12	12,0	11,7	18,0	25,9	6	10	■
XSB720E16160D3BZ6	10138224	3	D	E16	16,0	15,5	24,0	34,1	6	12	■
XSB720E20200D3BZ6	10138225	3	D	E20	20,0	19,3	30,0	40,2	6	16	■

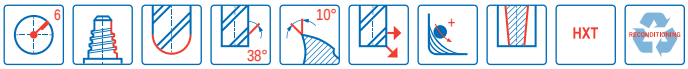
■ Prodotto standard.

XSB720

Alte prestazioni – Superlega – A testa sferica – 6 Eliche – Pollici



D





- Tolleranze:
- DC= e7
- RE= ±.0008 Pollici
- Riaffilatura possibile se DC è ≥Ø.500 Pollici

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*			HXT
XSB720E10.375D3BZ6	10138226	3	D	E10	0.375	0.364	0.563	0.827	6	8	■
XSB720E12.500D3BZ6	10138227	3	D	E12	0.500	0.484	0.750	1.055	6	10	■
XSB720E16.625D3BZ6	10138228	3	D	E16	0.625	0.610	0.938	1.343	6	12	■
XSB720E20.750D3BZ6	10138229	3	D	E20	0.750	0.728	1.125	1.524	6	16	■
XSB720E251.00D3BZ6	10138230	3	D	E25	1.000	0.965	1.500	1.980	6	20	■

■ Prodotto standard.

Parametri di taglio – XSB720 Contornatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	185 (150 — 140) *610 (500 — 450)*
P2	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	175 (140 — 130) *570 (460 — 420)*
P3	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	155 (120 — 110) *510 (400 — 360)*
P4	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	135 (110 — 100) *445 (370 — 320)*
P5	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	130 (110 — 100) *425 (370 — 320)*
P6	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (120 — 110) *475 (400 — 360)*
P7	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 100) *460 (370 — 320)*
P8	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	130 (99 — 98) *425 (330 — 320)*
P11	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	140 (110 — 100) *460 (370 — 320)*
P12	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	85 (68 — 67) *280 (230 — 210)*
M1	E/M/A	0,12 *0.12*	1,2 *1.2*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	140 (120 — 160) *460 (400 — 520)*
M3	E/M/A	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	120 (110 — 140) *395 (370 — 450)*
M4	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	90 (77 — 100) *295 (260 — 320)*
M5	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	75 (65 — 89) *245 (220 — 290)*
S1	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	35 (5 — 45) *115 (17 — 140)*
S3	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (79 — 130) *345 (260 — 420)*
S12	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (47 — 77) *195 (160 — 250)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XSB720 Contornatura sgrossatura avanzata a_e/DC=0,07

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	195 (160 — 150) *640 (530 — 490)*
P2	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,22 *0.0085*	190 (150 — 140) *620 (500 — 450)*
P3	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	165 (130 — 120) *540 (430 — 390)*
P4	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	145 (120 — 110) *475 (400 — 360)*
P5	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	140 (110 — 100) *460 (370 — 320)*
P6	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	160 (130 — 120) *520 (430 — 390)*
P7	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	150 (120 — 110) *490 (400 — 360)*
P8	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	140 (110 — 100) *460 (370 — 320)*
P11	E/M/A/D	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (120 — 110) *490 (400 — 360)*
P12	E/M/A/D	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	95 (73 — 72) *310 (240 — 230)*
M1	E/M/A	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	185 (160 — 200) *610 (530 — 650)*
M2	E/M/A	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	125 (110 — 140) *410 (370 — 450)*
M4	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (81 — 110) *310 (270 — 360)*
M5	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	80 (68 — 93) *260 (230 — 300)*
S1	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	35 (5 — 45) *115 (17 — 140)*
S3	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	65 (49 — 81) *215 (170 — 260)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XSB720 Contornatura – Pollici

SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P2	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	190 (170 — 210) *620 (560 — 680)*
P3	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	155 (140 — 170) *510 (460 — 550)*
P7	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (130 — 160) *490 (430 — 520)*
P8	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	140 (120 — 150) *460 (400 — 490)*
P11	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P12	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	95 (81 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,2 *1.2*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	220 (180 — 260) *720 (600 — 850)*
M2	E/M/A	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	180 (140 — 220) *590 (460 — 720)*
M3	E/M/A	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	160 (120 — 200) *520 (400 — 650)*
M4	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	125 (93 — 150) *410 (310 — 490)*
M5	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	105 (77 — 120) *345 (260 — 390)*
S1	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S12	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XSB720 Contornatura sgrossatura avanzata a_e/DC=0,07 – Pollici

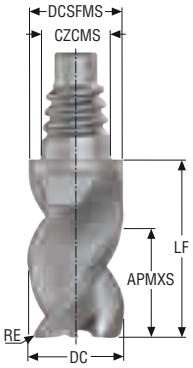
SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,22 *0.0085*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P6	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P12	E/M/A/D	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M1	E/M/A	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	235 (190 — 280) *770 (630 — 910)*
M2	E/M/A	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (160 — 230) *640 (530 — 750)*
M3	E/M/A	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	170 (130 — 200) *560 (430 — 650)*
M4	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	130 (97 — 160) *425 (320 — 520)*
M5	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	105 (81 — 130) *345 (270 — 420)*
S1	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S12	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

XSE450

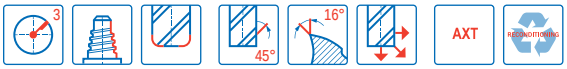
Alte prestazioni – Alluminio – Spallamento – 3 Eliche – Raggio di punta





D

- Tolleranze:
- DC= 0/-0,0508 mm
- RE= ±0,0254 mm
- Riaffilatura possibile se DC è ≥Ø12 mm

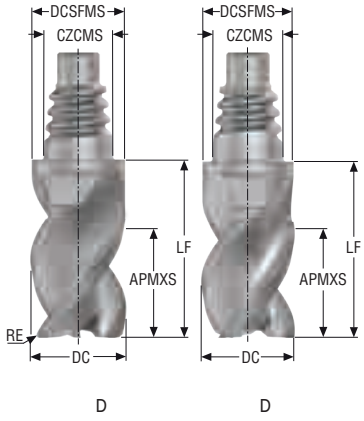


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			AXT
XSE450E10100D2R050Z3	10138362	2	D	E10	10,0	9,7	12,0	18,7	0,5	3	8	■
XSE450E12120D2R050Z3	10138363	2	D	E12	12,0	11,7	14,4	22,1	0,5	3	10	■
XSE450E12120D2R100Z3	10138364	2	D	E12	12,0	11,7	14,4	22,1	1,0	3	10	■
XSE450E16160D2R050Z3	10138365	2	D	E16	16,0	15,5	19,2	29,2	0,5	3	12	■
XSE450E16160D2R100Z3	10138366	2	D	E16	16,0	15,5	19,2	29,2	1,0	3	12	■
XSE450E20200D2R050Z3	10138367	2	D	E20	20,0	19,3	24,0	34,3	0,5	3	16	■
XSE450E20200D2R100Z3	10138369	2	D	E20	20,0	19,3	24,0	34,3	1,0	3	16	■

■ Prodotto standard.

XSE450

Alte prestazioni – Alluminio – Spallamento – 3 Eliche – Raggio di punta – Pollici







- Tolleranze:
- DC= 0/-.002 Pollici
- RE= ±.001 Pollici
- Riaffilatura possibile se DC è ≥Ø.500 Pollici

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			AXT
XSE450E10.375D2SZ3	10138370	2	D	E10	0.375	0.364	0.450	0.720	–	3	8	■
XSE450E12.500D2SZ3	10138371	2	D	E12	0.500	0.484	0.600	0.906	–	3	10	■
XSE450E16.625D2SZ3	10138372	2	D	E16	0.625	0.610	0.750	1.150	–	3	12	■
XSE450E20.750D2SZ3	10138373	2	D	E20	0.750	0.728	0.900	1.295	–	3	16	■
XSE450E251.00D2SZ3	10138374	2	D	E25	1.000	0.965	1.200	1.673	–	3	20	■
XSE450E10.375D2R030Z3	10138375	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8	■
XSE450E12.500D2R030Z3	10138376	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10	■
XSE450E12.500D2R060Z3	10138377	2	D	E12	0.500	0.484	0.600	0.906	0.060	3	10	■
XSE450E16.625D2R030Z3	10138378	2	D	E16	0.625	0.610	0.750	1.150	0.030	3	12	■
XSE450E16.625D2R060Z3	10138379	2	D	E16	0.625	0.610	0.750	1.150	0.060	3	12	■
XSE450E16.625D2R120Z3	10138380	2	D	E16	0.625	0.610	0.750	1.150	0.120	3	12	■
XSE450E20.750D2R030Z3	10138381	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16	■
XSE450E20.750D2R060Z3	10138382	2	D	E20	0.750	0.728	0.900	1.295	0.060	3	16	■
XSE450E20.750D2R120Z3	10138383	2	D	E20	0.750	0.728	0.900	1.295	0.120	3	16	■
XSE450E251.00D2R030Z3	10138384	2	D	E25	1.000	0.965	1.200	1.673	0.030	3	20	■
XSE450E251.00D2R060Z3	10138385	2	D	E25	1.000	0.965	1.200	1.673	0.060	3	20	■
XSE450E251.00D2R120Z3	10138386	2	D	E25	1.000	0.965	1.200	1.673	0.120	3	20	■

■ Prodotto standard.

Parametri di taglio – XSE450 Contornatura

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20		
N1	E/M/A	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	405 (340 — 450) *1325 (1200 — 1400)*
N2	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	275 (230 — 330) *900 (760 — 1000)*
N3	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	185 (150 — 220) *610 (500 — 720)*
N11	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	245 (200 — 290) *800 (660 — 950)*
TS1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*

Parametri di taglio – XSE450 Scanalatura

SMG		a_p/DC	f_z					v_c
			10	12	16	20		
N1	E/M/A	0,90 *0.90*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	360 (310 — 410) *1175 (1100 — 1300)*
N2	E/M/A	0,90 *0.90*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	250 (200 — 300) *820 (660 — 980)*
N3	E/M/A	0,90 *0.90*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	165 (140 — 200) *540 (460 — 650)*
N11	E/M/A	0,90 *0.90*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	220 (180 — 260) *720 (600 — 850)*
TS1	A/D	0,90 *0.90*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,90 *0.90*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XSE450 Contornatura – Pollici

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
N1	E/M/A	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	560 (450 — 670) *1825 (1500 — 2100)*
N2	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	445 (340 — 550) *1450 (1200 — 1800)*
N3	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	295 (230 — 360) *970 (760 — 1100)*
N11	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	395 (300 — 490) *1300 (990 — 1600)*
TS1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*

Parametri di taglio – XSE450 Scanalatura – Pollici

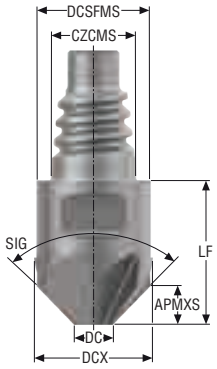
SMG		a_p/DC	f_z					v_c
			3/8	1/2	5/8	3/4	1	
N1	E/M/A	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	500 (400 — 590) *1650 (1400 — 1900)*
N2	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	400 (300 — 490) *1300 (990 — 1600)*
N3	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	265 (200 — 330) *870 (660 — 1000)*
N11	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	355 (270 — 440) *1175 (890 — 1400)*
TS1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

XSC509

Alte prestazioni – Universale – Smusso – 6 Eliche





N

- Tolleranze:
- SIG= ±1°



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCX	DC	DCSFMS	APMXS	LF	SIG°	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm				SIRA
XSC509E10100N1SZ6	10219277	1	N	E10	10,1	1,95	9,7	4,0	12,3	90,0	6	8	■
XSC509E12120N1SZ6	10219278	1	N	E12	12,1	2,95	11,7	4,5	14,4	90,0	6	10	■
XSC509E16160N1SZ6	10219279	1	N	E16	16,1	3,95	15,5	6,0	18,6	90,0	6	12	■

■ Prodotto standard.

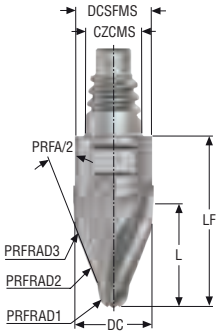
Parametri di taglio – XVC509 Smussatura

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,09 *0.0035*	0,11 *0.0043*	275 (135 — 310) *900 (440 — 1010)*
P2	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,09 *0.0035*	0,11 *0.0043*	270 (130 — 300) *890 (425 — 975)*
P3	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,09 *0.0035*	0,11 *0.0043*	235 (110 — 260) *770 (370 — 850)*
P4	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,085 *0.0035*	0,1 *0.0039*	220 (105 — 250) *720 (350 — 810)*
P5	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,085 *0.0035*	0,1 *0.0039*	200 (95 — 220) *660 (310 — 715)*
P6	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,055 *0.0022*	0,08 *0.0031*	0,1 *0.0039*	200 (95 — 220) *660 (310 — 715)*
P7	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,055 *0.0022*	0,08 *0.0031*	0,1 *0.0039*	200 (95 — 220) *660 (310 — 715)*
P8	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,055 *0.0022*	0,08 *0.0031*	0,1 *0.0039*	200 (95 — 220) *660 (310 — 715)*
P11	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,055 *0.0022*	0,08 *0.0031*	0,1 *0.0039*	180 (80 — 200) *590 (270 — 650)*
P12	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,08 *0.0022*	0,07 *0.0028*	130 (60 — 140) *425 (200 — 460)*
M1	E/M/A	0,20 *0.20*	0,30 *0.30*	0,065 *0.0026*	0,09 *0.0035*	0,11 *0.0043*	220 (100 — 240) *720 (330 — 790)*
M2	E/M/A	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.00314*	0,1 *0.0039*	180 (80 — 200) *590 (270 — 650)*
M3	E/M/A	0,20 *0.20*	0,30 *0.30*	0,05 *0.0018*	0,07 *0.0026*	0,08 *0.0032*	145 (65 — 155) *475 (210 — 510)*
M4	E/M/A	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,06 *0.0022*	0,07 *0.0028*	110 (50 — 120) *360 (160 — 390)*
M5	E/M/A	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,06 *0.0022*	0,07 *0.0028*	90 (40 — 100) *295 (140 — 330)*
K1	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0039*	215 (100 — 235) *710 (340 — 770)*
K2	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0039*	190 (90 — 205) *620 (300 — 675)*
K3	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0039*	160 (75 — 175) *520 (250 — 570)*
K4	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0039*	150 (70 — 165) *490 (240 — 540)*
K5	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,05 *0.002*	0,075 *0.00295*	0,09 *0.00354*	80 (45 — 100) *260 (145 — 330)*
K6	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.00314*	0,1 *0.0039*	115 (65 — 145) *375 (210 —480)*
K7	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,05 *0.002*	0,075 *0.003*	0,09 *0.0036*	100 (60 — 130) *330 (190 — 425)*
N1	E/M/A	0,20 *0.20*	0,30 *0.30*	0,08 *0.003*	0,11 *0.0044*	0,14 *0.0055*	1250 (775— 1800) *4100 (2540 — 5900)*
N2	E/M/A	0,20 *0.20*	0,30 *0.30*	0,08 *0.003*	0,11 *0.0044*	0,14 *0.0055*	570 (310 — 720) *1870 (1020 — 2370)*
N3	E/M/A	0,20 *0.20*	0,30 *0.30*	0,08 *0.003*	0,11 *0.0044*	0,14 *0.0055*	380 (210 — 480) *1240 (680 — 1580)*
N11	E/M/A	0,20 *0.20*	0,30 *0.30*	0,08 *0.003*	0,11 *0.0044*	0,14 *0.0055*	610 (240 — 555) *2000 (780 — 1820)*
S1	E	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	30 (17 — 40) *100 (55 — 125)*
S2	E	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	24 (15 — 31) *80 (44 — 102)*
S3	E	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	21 (12 — 27) *70 (38 — 88)*
S11	E	0,20 *0.20*	0,30 *0.30*	0,05 *0.0018*	0,065 *0.0026*	0,08 *0.0032*	43 (25 — 55) *140 (80 — 180)*
S12	E	0,20 *0.20*	0,30 *0.30*	0,05 *0.0018*	0,065 *0.0026*	0,08 *0.0032*	33 (20 — 42) *108 (60 — 138)*
S13	E	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	26 (15 — 33) *85 (50 — 110)*
H5	M/A	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	60 (30 — 70) *195 (105— 240)*
H8	M/A	0,20 *0.20*	0,30 *0.30*	0,03 *0.0012*	0,04 *0.0017*	0,06 *0.0022*	60 (30 — 70) *195 (105— 240)*
H21	M/A	0,20 *0.20*	0,30 *0.30*	0,03 *0.0012*	0,04 *0.0017*	0,06 *0.0022*	60 (30 — 70) *195 (105— 240)*
H31	M/A	0,20 *0.20*	0,30 *0.30*	0,03 *0.0012*	0,04 *0.0017*	0,06 *0.0022*	45 (25 — 55) *145 (80 — 185)*

XHT740

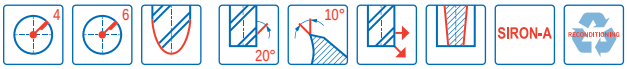
Alta velocità – ISO– M e ISO– S – Forma conica – 4-6 Eliche





T

- Tolleranze:
- PRFRAD1= ±0,03 mm
- Tolleranza di forma PRFRAD2= 0,02 mm
- Riaffilatura possibile se DC è ≥Ø12 mm e PRFRAD1 è ≥1,5 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	L	LF	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm	mm	mm				SIRA
XHT740E10100T2R1.5R250Z4	10138388	2	T	E10	10,0	9,7	5,4	18,7	1,5	250,0	2,0	65,0	4	8	■
XHT740E12120T2R3R250Z4	10138389	2	T	E12	12,0	11,7	10,5	22,1	3,0	250,0	6,0	32,5	4	10	■
XHT740E16160T2R4R500Z4	10138390	2	T	E16	16,0	15,5	14,6	29,2	4,0	500,0	8,0	27,5	4	12	■
XHT740E10100T3R2R250Z4	10138391	3	T	E10	10,0	9,7	12,7	21,8	2,0	250,0	5,0	20,0	4	8	■
XHT740E12120T3R3R250Z4	10138392	3	T	E12	12,0	11,7	13,7	25,9	3,0	250,0	6,0	20,0	4	10	■
XHT740E16160T3R4R1000Z4	10138394	3	T	E16	16,0	15,5	24,0	34,1	4,0	1000,0	5,0	20,0	4	12	■
XHT740E16160T3R4R500Z4	10138393	3	T	E16	16,0	15,5	17,6	34,1	4,0	500,0	8,0	20,0	4	12	■
XHT740E10100T3R2R250Z6	10138395	3	T	E10	10,0	9,7	12,7	21,8	2,0	250,0	5,0	20,0	6	8	■
XHT740E12120T3R3R250Z6	10138396	3	T	E12	12,0	11,7	13,7	25,9	3,0	250,0	6,0	20,0	6	10	■
XHT740E16160T3R4R500Z6	10138397	3	T	E16	16,0	15,5	17,6	34,1	4,0	500,0	8,0	20,0	6	12	■

■ Prodotto standard.

Parametri di taglio – XHT740 – Copiatura PCEDC 4

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

Parametri di taglio – XHT740 – Copiatura PCEDC 6

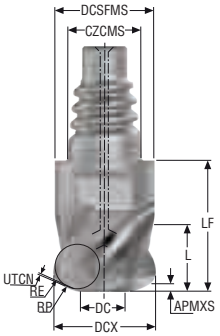
SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

XHF580

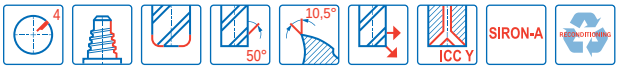
Elevato avanzamento – Universale – 4 Eliche – Raggio di punta – ICC





D

- Tolleranze:
- DCX= h9
- RE= ±0,03 mm
- Riaffilatura possibile se DCX è ≥Ø12 mm

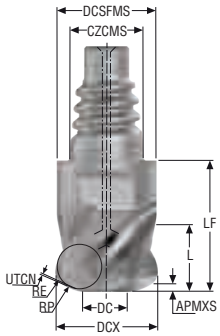


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Qualità
						mm	mm	mm	mm	mm	mm	mm	mm	mm			SIRA
XHF580E10100D1HZ4A	10137971	1	D	✓	E10	10,0	3,4	9,7	0,7	6,0	12,4	1,5	1,99	0,27	4	8	■
XHF580E12120D1HZ4A	10137972	1	D	✓	E12	12,0	4,5	11,7	0,8	7,5	14,5	1,5	2,1	0,323	4	10	■
XHF580E16160D1HZ4A	10137973	1	D	✓	E16	16,0	6,2	15,5	1,0	10,0	18,7	2,0	2,747	0,426	4	12	■

■ Prodotto standard.

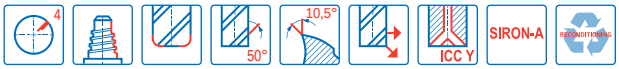
XHF580

Elevato avanzamento – Universale – 4 Eliche – Raggio di punta – ICC – Pollici



D





- Tolleranze:
- DCX= h9
- RE= ±.0012 Pollici
- Riaffilatura possibile se DCX è ≥Ø.500 Pollici

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Qualità
						Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XHF580E10.375D1HZ4A	10137974	1	D	✓	E10	0.375	0.134	0.364	0.024	0.236	0.488	0.060	0.076	0.008	4	8	■
XHF580E12.500D1HZ4A	10137975	1	D	✓	E12	0.500	0.197	0.484	0.033	0.315	0.571	0.060	0.086	0.014	4	10	■
XHF580E16.625D1HZ4A	10137976	1	D	✓	E16	0.614	0.236	0.610	0.039	0.394	0.736	0.080	0.110	0.016	4	12	■

■ Prodotto standard.

Parametri di taglio – XHF580 Contornatura

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	350 (330 — 400) *1150 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	340 (320 — 390) *1125 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (280 — 340) *970 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	190 (180 — 230) *620 (600 — 750)*
P7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	180 (170 — 220) *590 (560 — 720)*
P8	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	170 (160 — 200) *560 (530 — 650)*
P11	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	145 (150 — 170) *475 (500 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (83 — 100) *280 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	170 (170 — 200) *560 (560 — 650)*
M2	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	140 (140 — 160) *460 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (97 — 130) *345 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	75 (73 — 99) *245 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	65 (61 — 83) *215 (210 — 270)*
K1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	345 (330 — 400) *1125 (1100 — 1300)*
K2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	300 (280 — 340) *980 (920 — 1100)*
K3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	250 (240 — 290) *820 (790 — 950)*
K4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	240 (230 — 280) *790 (760 — 910)*
K5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	145 (140 — 160) *475 (460 — 520)*
K6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	210 (200 — 240) *690 (660 — 780)*
K7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	185 (180 — 210) *610 (600 — 680)*
S1	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	45 (36 — 71) *150 (120 — 230)*
S2	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	36 (29 — 57) *120 (96 — 180)*
S3	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	31 (25 — 49) *100 (83 — 160)*
S11	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	160 (160 — 190) *520 (530 — 620)*
S12	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	125 (120 — 150) *410 (400 — 490)*
S13	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	95 (91 — 110) *310 (300 — 360)*
H5	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H8	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H21	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H31	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	80 (74 — 100) *260 (250 — 320)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XHF580 Scanalatura

SMG		a_p/DCX	f_z			v_c
			10	12	16	
P1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	320 (300 — 360) *1050 (990 — 1100)*
P2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (290 — 350) *1025 (960 — 1100)*
P3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	265 (250 — 300) *870 (830 — 980)*
P4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	235 (220 — 270) *770 (730 — 880)*
P5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	235 (220 — 270) *770 (730 — 880)*
P6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	175 (160 — 210) *570 (530 — 680)*
P7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	165 (150 — 200) *540 (500 — 650)*
P8	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	155 (150 — 180) *510 (500 — 590)*
P11	E/M/A/D	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (130 — 160) *425 (430 — 520)*
P12	E/M/A/D	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (75 — 94) *260 (250 — 300)*
M1	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	155 (150 — 180) *510 (500 — 590)*
M2	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	125 (120 — 150) *410 (400 — 490)*
M3	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 110) *310 (290 — 360)*
M4	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (66 — 89) *230 (220 — 290)*
M5	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	60 (55 — 74) *195 (190 — 240)*
K1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (300 — 360) *1025 (990 — 1100)*
K2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (260 — 310) *890 (860 — 1000)*
K3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
K4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	220 (210 — 250) *720 (690 — 820)*
K5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	130 (130 — 150) *425 (430 — 490)*
K6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	190 (180 — 220) *620 (600 — 720)*
K7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	165 (160 — 190) *540 (530 — 620)*
S1	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	39 (32 — 62) *130 (110 — 200)*
S2	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	31 (26 — 50) *100 (86 — 160)*
S3	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	27 (22 — 43) *90 (73 — 140)*
S11	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	150 (150 — 180) *490 (500 — 590)*
S12	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	115 (110 — 140) *375 (370 — 450)*
S13	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	90 (85 — 100) *295 (280 — 320)*
H5	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H8	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H21	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H31	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (67 — 91) *230 (220 — 290)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XHF580 Contornatura – Pollici

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	485 (440 — 530) *1600 (1500 — 1700)*
P2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
P3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	405 (370 — 450) *1325 (1300 — 1400)*
P4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P5	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P6	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
P7	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	280 (250 — 300) *920 (830 — 980)*
P8	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P11	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (140 — 170) *520 (460 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	185 (170 — 200) *610 (560 — 650)*
M2	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 99) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 82) *230 (210 — 260)*
K1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
K2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	415 (370 — 450) *1350 (1300 — 1400)*
K3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	350 (320 — 380) *1150 (1100 — 1200)*
K4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	335 (300 — 370) *1100 (990 — 1200)*
K5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	200 (180 — 220) *660 (600 — 720)*
K6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
K7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	255 (230 — 280) *840 (760 — 910)*
S1	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	170 (150 — 190) *560 (500 — 620)*
S12	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	130 (120 — 140) *425 (400 — 450)*
S13	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	100 (89 — 110) *330 (300 — 360)*
H5	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H21	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (74 — 100) *295 (250 — 320)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XHF580 Scanalatura – Pollici

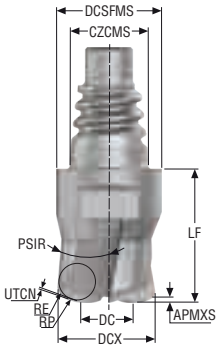
SMG		a_p/DCX	f_z			v_c
			3/8	1/2	5/8	
P1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	440 (400 — 480) *1450 (1400 — 1500)*
P2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 470) *1400 (1300 — 1500)*
P3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	370 (330 — 400) *1225 (1100 — 1300)*
P4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 360) *1075 (960 — 1100)*
P5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	275 (250 — 300) *900 (830 — 980)*
P7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	260 (240 — 280) *850 (790 — 910)*
P8	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P11	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	145 (130 — 160) *475 (430 — 520)*
P12	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	85 (75 — 94) *280 (250 — 300)*
M1	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	170 (150 — 180) *560 (500 — 590)*
M2	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	135 (120 — 150) *445 (400 — 490)*
M3	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 110) *345 (290 — 360)*
M4	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (66 — 89) *260 (220 — 290)*
M5	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (55 — 74) *215 (190 — 240)*
K1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 480) *1400 (1300 — 1500)*
K2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	375 (340 — 410) *1225 (1200 — 1300)*
K3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
K4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	305 (270 — 330) *1000 (890 — 1000)*
K5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	180 (170 — 200) *590 (560 — 650)*
K6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	265 (240 — 290) *870 (790 — 950)*
K7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (210 — 250) *750 (690 — 820)*
S1	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	47 (32 — 62) *155 (110 — 200)*
S2	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	38 (26 — 50) *125 (86 — 160)*
S3	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	32 (22 — 43) *105 (73 — 140)*
S11	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	160 (150 — 180) *520 (500 — 590)*
S12	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	125 (110 — 140) *410 (370 — 450)*
S13	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (84 — 100) *310 (280 — 320)*
H5	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H8	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H21	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H31	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (67 — 91) *260 (220 — 290)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

XHF780

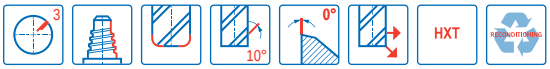
Elevato avanzamento – ISO– M e ISO– S – 3 Eliche – Raggio di punta





D

- Tolleranze:
- DCX= -0,02/-0,04 mm
- RE= ±0,05 mm
- Riaffilatura possibile se DCX è ≥Ø12 mm

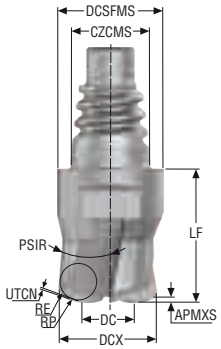


Codice di ordinazione	Codice prodotto	Indice di lung-hezza	Forma utensile	CZCMS	DCX	DC	DCSFMS	APMXS	LF	RE	RP	UTCN	PSIR°	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm	mm	mm	mm				HXT
XHF780E10100D1HZ3	10137957	1	D	E10	10,0	5,0	9,7	0,45	12,3	0,8	1,175	0,232	-5,0	3	8	■
XHF780E12120D1HZ3	10137958	1	D	E12	12,0	6,0	11,7	0,5	14,4	1,0	1,416	0,262	-5,0	3	10	■
XHF780E16160D1HZ3	10137959	1	D	E16	16,0	8,0	15,5	0,6	18,6	1,5	1,989	0,32	-5,0	3	12	■

■ Prodotto standard.

XHF780

Elevato avanzamento – ISO– M e ISO– S – 3 Eliche – Raggio di punta – Pollici



D



- Tolleranze:
- DCX= -.0008/-0.0016 Pollici
- RE= ±.002 Pollici
- Riaffilatura possibile se DCX è ≥Ø.500 Pollici

Codice di ordinazione	Codice prodotto	Indice di lung-hezza	Forma utensile	CZCMS	DCX	DC	DCSFMS	APMXS	LF	RE	RP	UTCN	PSIR°	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*				HXT
XHF780E10.375D1HZ3	10137960	1	D	E10	0.375	0.188	0.364	0.018	0.484	0.028	0.043	0.009	-5,0	3	8	■
XHF780E12.500D1HZ3	10137961	1	D	E12	0.500	0.250	0.484	0.020	0.567	0.045	0.061	0.010	-5,0	3	10	■
XHF780E16.625D1HZ3	10137962	1	D	E16	0.625	0.313	0.610	0.024	0.732	0.061	0.080	0.012	-5,0	3	12	■

■ Prodotto standard.

Parametri di taglio – XHF780 Contornatura

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	355 (330 — 410) *1175 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	345 (320 — 390) *1125 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (280 — 340) *970 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	195 (180 — 230) *640 (600 — 750)*
P7	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	185 (170 — 220) *610 (560 — 720)*
P8	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	175 (160 — 210) *570 (530 — 680)*
P11	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	180 (170 — 210) *590 (560 — 680)*
P12	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (83 — 100) *280 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	175 (170 — 210) *570 (560 — 680)*
M2	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	140 (140 — 160) *460 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (97 — 130) *345 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	75 (73 — 100) *245 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	65 (61 — 83) *215 (210 — 270)*
S1	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	45 (36 — 71) *150 (120 — 230)*
S2	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	36 (29 — 57) *120 (96 — 180)*
S3	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	31 (25 — 49) *100 (83 — 160)*
S11	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	160 (160 — 190) *520 (530 — 620)*
S12	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	120 (120 — 150) *395 (400 — 490)*
S13	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	95 (90 — 110) *310 (300 — 360)*
H5	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H8	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H11	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	135 (130 — 170) *445 (430 — 550)*
H21	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H31	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	80 (75 — 100) *260 (250 — 320)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XHF780 Scanalatura

SMG		a_p/DCX	f_z			v_c
			10	12	16	
P1	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (290 — 350) *1025 (960 — 1100)*
P2	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	300 (290 — 350) *980 (960 — 1100)*
P3	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	260 (250 — 300) *850 (830 — 980)*
P4	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
P5	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
P6	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	170 (160 — 200) *560 (530 — 650)*
P7	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	160 (150 — 190) *520 (500 — 620)*
P8	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	150 (140 — 180) *490 (460 — 590)*
P11	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	155 (150 — 180) *510 (500 — 590)*
P12	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (73 — 92) *245 (240 — 300)*
M1	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	150 (150 — 180) *490 (500 — 590)*
M2	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	120 (120 — 140) *395 (400 — 450)*
M3	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (85 — 110) *295 (280 — 360)*
M4	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (64 — 87) *215 (210 — 280)*
M5	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (53 — 72) *180 (180 — 230)*
S1	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	38 (31 — 60) *125 (110 — 190)*
S2	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	30 (25 — 48) *100 (83 — 150)*
S3	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	26 (21 — 41) *85 (69 — 130)*
S11	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	145 (140 — 170) *475 (460 — 550)*
S12	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	110 (110 — 130) *360 (370 — 420)*
S13	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	85 (82 — 100) *280 (270 — 320)*
H5	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H8	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H11	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	115 (110 — 140) *375 (370 — 450)*
H21	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H31	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (65 — 88) *230 (220 — 280)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XHF780 Contornatura – Pollici

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	370 (330 — 410) *1225 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	310 (280 — 340) *1025 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	305 (280 — 330) *1000 (920 — 1000)*
P7	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	290 (260 — 320) *950 (860 — 1000)*
P8	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P11	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (150 — 170) *520 (500 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	190 (170 — 210) *620 (560 — 680)*
M2	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 100) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 83) *230 (210 — 270)*
S1	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	175 (160 — 190) *570 (530 — 620)*
S12	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	135 (120 — 150) *445 (400 — 490)*
S13	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	105 (90 — 110) *345 (300 — 360)*
H5	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H11	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (130 — 170) *490 (430 — 550)*
H21	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (75 — 100) *295 (250 — 320)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

Parametri di taglio – XHF780 Scanalatura – Pollici

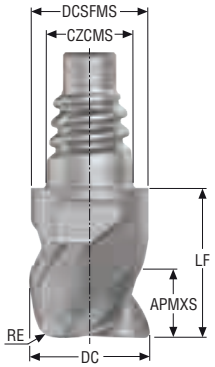
SMG		a_p/DCX	f_z			v_c
			3/8	1/2	5/8	
P1	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 350) *1075 (960 — 1100)*
P2	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
P3	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (250 — 300) *890 (830 — 980)*
P4	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P5	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P6	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (240 — 290) *890 (790 — 950)*
P7	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	255 (230 — 280) *840 (760 — 910)*
P8	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P11	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	140 (130 — 150) *460 (430 — 490)*
P12	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (73 — 92) *260 (240 — 300)*
M1	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	165 (150 — 180) *540 (500 — 590)*
M2	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (120 — 140) *425 (400 — 450)*
M3	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (85 — 110) *330 (280 — 360)*
M4	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (64 — 87) *245 (210 — 280)*
M5	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (53 — 72) *215 (180 — 230)*
S1	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	45 (31 — 60) *150 (110 — 190)*
S2	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	36 (25 — 48) *120 (83 — 150)*
S3	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	31 (21 — 41) *100 (69 — 130)*
S11	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	155 (140 — 170) *510 (460 — 550)*
S12	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	120 (110 — 130) *395 (370 — 420)*
S13	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (82 — 100) *310 (270 — 320)*
H5	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H8	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H11	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (110 — 140) *425 (370 — 450)*
H21	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H31	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (65 — 88) *245 (220 — 280)*

SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (*sf/min*)
f_z = mm (*in/dente*)
a_p = mm/DC (*in/DC*) = fattore
a_e = mm/DC (*in/DC*) = fattore
Tutti i parametri di taglio sono valori indicativi

XVE540

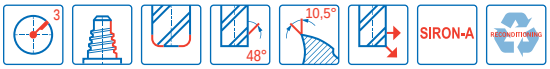
Uso generico – Universale – Spallamento – 3 Eliche – Raggio di punta





D

- Tolleranze:
- DC= h9
- RE= ±0,015 mm
- Riaffilatura possibile se DC è ≥Ø12 mm

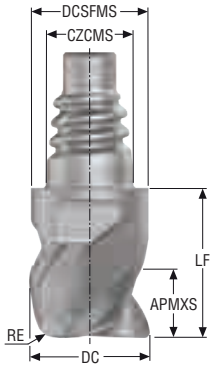


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z3	10137981	1	D	E10	10,0	9,7	5,5	12,4	0,5	3	8	■
XVE540E12120D1R050Z3	10137982	1	D	E12	12,0	11,7	6,5	14,5	0,5	3	10	■
XVE540E16160D1R050Z3	10137983	1	D	E16	16,0	15,5	8,5	18,7	0,5	3	12	■
XVE540E20200D1R050Z3	10137984	1	D	E20	20,0	19,3	11,0	21,3	0,5	3	16	■

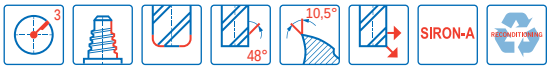
■ Prodotto standard.

XVE540

Uso generico – Universale – Spallamento – 3 Eliche – Raggio di punta



D





- Tolleranze:
- DC= h9
- RE= .015 Pollici= ±.0006 Pollici
- RE= .031 Pollici= ±.0012 Pollici
- Riaffilatura possibile se DC è ≥Ø.500 Pollici

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XVE540E10.375D1R015Z3	10137985	1	D	E10	0.375	0.364	0.209	0.488	0.015	3	8	■
XVE540E12.500D1R015Z3	10137986	1	D	E12	0.500	0.484	0.276	0.575	0.015	3	10	■
XVE540E16.625D1R015Z3	10137987	1	D	E16	0.625	0.610	0.335	0.736	0.015	3	12	■
XVE540E20.750D1R031Z3	10137988	1	D	E20	0.750	0.728	0.413	0.839	0.031	3	16	■

■ Prodotto standard.

Parametri di taglio – XVE540 – Contornatura PCEDC 3

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (140 — 220) *570 (460 — 720)*
P2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	170 (130 — 210) *560 (430 — 680)*
P3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	150 (120 — 180) *490 (400 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (100 — 160) *445 (330 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	125 (96 — 150) *410 (320 — 490)*
P6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	145 (110 — 170) *475 (370 — 550)*
P7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	135 (110 — 160) *445 (370 — 520)*
P8	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (96 — 150) *410 (320 — 490)*
P11	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	80 (70 — 93) *260 (230 — 300)*
P12	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (45 — 59) *165 (150 — 190)*
M1	E/M/A	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	95 (81 — 100) *310 (270 — 320)*
M2	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (67 — 88) *245 (220 — 280)*
M3	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	50 (39 — 60) *165 (130 — 190)*
M4	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	38 (30 — 46) *125 (99 — 150)*
M5	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	32 (25 — 39) *105 (83 — 120)*
K1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (140 — 170) *510 (460 — 550)*
K2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
K3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	115 (99 — 130) *375 (330 — 420)*
K4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	110 (95 — 120) *360 (320 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	200 (170 — 220) *660 (560 — 720)*
K7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	175 (150 — 190) *570 (500 — 620)*
N1	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	550 (510 — 710) *1800 (1700 — 2300)*
N2	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	355 (330 — 450) *1175 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	235 (220 — 300) *770 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,50 *0.50*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0050*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	30 (24 — 37) *100 (79 — 120)*
S2	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	25 (19 — 32) *80 (63 — 100)*
S3	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	22 (17 — 27) *70 (56 — 88)*
S11	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (56 — 99) *245 (190 — 320)*
S13	E	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (44 — 79) *195 (150 — 250)*
TS1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*

Parametri di taglio – XVE540 – Scanalatura PCEDC 3

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (64 — 84) *245 (210 — 270)*
P12	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	44 (38 — 49) *145 (130 — 160)*
M1	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (75 — 99) *280 (250 — 320)*
M2	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	45 (35 — 55) *150 (120 — 180)*
M4	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 150) *460 (400 — 490)*
K2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (89 — 110) *345 (300 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (85 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	540 (510 — 700) *1775 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	345 (330 — 450) *1125 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	230 (220 — 300) *750 (730 — 980)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	300 (260 — 350) *980 (860 — 1100)*
S1	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	27 (22 — 34) *90 (73 — 110)*
S2	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	23 (18 — 29) *75 (60 — 95)*
S3	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (51 — 90) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	55 (39 — 69) *180 (130 — 220)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*

Parametri di taglio – XVE540 – Contornatura PCEDC 3 – Pollici

SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	185 (150 — 210) *610 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 200) *590 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (100 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (94 — 140) *375 (310 — 450)*
P8	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (89 — 130) *360 (300 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (70 — 110) *310 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (45 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (81 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
M3	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (56 — 99) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 76) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	50 (36 — 63) *165 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 140) *395 (370 — 450)*
K3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	105 (87 — 110) *345 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 80) *215 (180 — 260)*
K6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (69 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	395 (330 — 450) *1300 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,50 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	300 (250 — 340) *1025 (860 — 1100)*
S1	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (32 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (26 — 37) *100 (86 — 120)*
S3	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	28 (23 — 33) *90 (76 — 100)*
S11	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (87 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
S13	E	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*

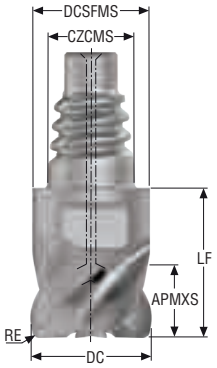
Parametri di taglio – XVE540 – Scanalatura PCEDC 3 – Pollici

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 190) *540 (460 — 620)*
P3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (90 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (85 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P11	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (64 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (38 — 62) *165 (130 — 200)*
M1	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (75 — 120) *330 (250 — 390)*
M2	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
M3	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 67) *165 (130 — 210)*
M5	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	44 (32 — 56) *145 (110 — 180)*
K1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (92 — 120) *360 (310 — 390)*
K3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (78 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 71) *195 (160 — 230)*
K6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (71 — 100) *295 (240 — 320)*
K7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 91) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	300 (260 — 340) *980 (860 — 1100)*
S1	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 43) *120 (96 — 140)*
S2	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (24 — 34) *95 (79 — 110)*
S3	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 30) *80 (66 — 98)*
S11	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (79 — 130) *345 (260 — 420)*
S12	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 77) *195 (160 — 250)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*

XVE540

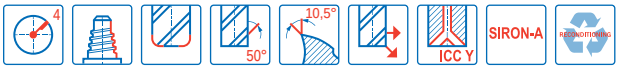
Uso generico – Universale – Spallamento – 4 Eliche – Raggio di punta – ICC





D

- Tolleranze:
- DC= h9
- RE= ±0,015 mm
- Riaffilatura possibile se DC è ≥Ø12 mm

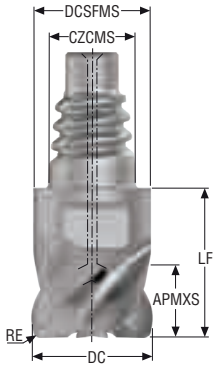


Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
						mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z4A	10137989	1	D	✓	E10	10,0	9,7	6,0	12,4	0,5	4	8	■
XVE540E12120D1R050Z4A	10137990	1	D	✓	E12	12,0	11,7	7,5	14,5	0,5	4	10	■
XVE540E16160D1R050Z4A	10137991	1	D	✓	E16	16,0	15,5	10,0	18,7	0,5	4	12	■
XVE540E20200D1R050Z4A	10137992	1	D	✓	E20	20,0	19,3	12,0	21,3	0,5	4	16	■

■ Prodotto standard.

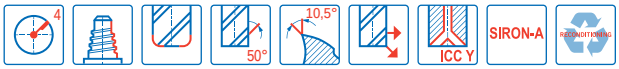
XVE540

Uso generico – Universale – Spallamento – 4 Eliche – Raggio di punta – ICC – *Inch*



D





- Tolleranze:
- DC= h9
- RE= .015 Pollici= ±.0006 Pollici
- RE= .031 Pollici= ±.0012 Pollici
- Riaffilatura possibile se DC è ≥Ø.500 Pollici

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
						Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XVE540E10.375D1R015Z4A	10137993	1	D	✓	E10	0.375	0.364	0.236	0.488	0.015	4	8	■
XVE540E12.500D1R031Z4A	10137994	1	D	✓	E12	0.500	0.484	0.315	0.571	0.031	4	12	■
XVE540E16.625D1R031Z4A	10137995	1	D	✓	E16	0.625	0.610	0.394	0.736	0.031	4	16	■
XVE540E20.750D1R031Z4A	10137996	1	D	✓	E20	0.750	0.728	0.453	0.839	0.031	4	18	■

■ Prodotto standard.

Parametri di taglio – XVE540 – Contornatura PCEDC 4

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (140 — 210) *570 (460 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	170 (130 — 210) *560 (430 — 680)*
P3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	150 (120 — 180) *490 (400 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	130 (99 — 160) *425 (330 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	125 (95 — 150) *410 (320 — 490)*
P6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	140 (110 — 170) *460 (370 — 550)*
P7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	135 (110 — 160) *445 (370 — 520)*
P8	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (95 — 150) *410 (320 — 490)*
P11	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	80 (70 — 92) *260 (230 — 300)*
P12	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (44 — 58) *165 (150 — 190)*
M1	E/M/A	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	95 (80 — 100) *310 (270 — 320)*
M2	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (66 — 87) *245 (220 — 280)*
M3	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	49 (39 — 60) *160 (130 — 190)*
M4	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	38 (30 — 46) *125 (99 — 150)*
M5	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	32 (25 — 38) *105 (83 — 120)*
K1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (140 — 170) *510 (460 — 550)*
K2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
K3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	115 (99 — 130) *375 (330 — 420)*
K4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	110 (94 — 120) *360 (310 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (110 — 150) *445 (370 — 490)*
K6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	200 (160 — 220) *660 (530 — 720)*
K7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	175 (150 — 190) *570 (500 — 620)*
N1	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	540 (510 — 700) *1775 (1700 — 2200)*
N2	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	350 (330 — 450) *1150 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	235 (220 — 300) *770 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,55 *0.55*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0050*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	30 (24 — 37) *100 (79 — 120)*
S2	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	25 (19 — 31) *80 (63 — 100)*
S3	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	22 (17 — 27) *70 (56 — 88)*
S11	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (55 — 98) *245 (190 — 320)*
S13	E	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (44 — 78) *195 (150 — 250)*
TS1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*

Parametri di taglio – XVE540 – Scanalatura PCEDC 4

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 200) *520 (430 — 650)*
P2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	155 (120 — 190) *510 (400 — 620)*
P3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	135 (110 — 160) *445 (370 — 520)*
P4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (96 — 150) *410 (320 — 490)*
P7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (91 — 150) *395 (300 — 490)*
P8	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (63 — 83) *245 (210 — 270)*
P12	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	43 (37 — 49) *140 (130 — 160)*
M1	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (74 — 98) *280 (250 — 320)*
M2	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	33 (26 — 40) *110 (86 — 130)*
M5	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 150) *460 (400 — 490)*
K2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (88 — 110) *330 (290 — 360)*
K4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	95 (84 — 110) *310 (280 — 360)*
K5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 130) *410 (330 — 420)*
K6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	530 (500 — 690) *1750 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	345 (320 — 440) *1125 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	230 (220 — 290) *750 (730 — 950)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (65 — 110) *295 (220 — 360)*
S12	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	55 (39 — 69) *180 (130 — 220)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*

Parametri di taglio – XVE540 – Contornatura PCEDC 4 – Pollici

SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 210) *590 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (150 — 200) *570 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (110 — 150) *445 (370 — 490)*
P5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (99 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (93 — 130) *375 (310 — 420)*
P8	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (88 — 130) *360 (290 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (70 — 110) *295 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (44 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (80 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
M3	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (55 — 98) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 75) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	49 (36 — 63) *160 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (120 — 150) *445 (400 — 490)*
K2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	100 (86 — 110) *330 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 79) *215 (180 — 250)*
K6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (68 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*
N2	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	390 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,55 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	295 (250 — 340) *1000 (860 — 1100)*
S1	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (31 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (25 — 37) *100 (83 — 120)*
S3	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	27 (22 — 32) *90 (73 — 100)*
S11	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (86 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
S13	E	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*

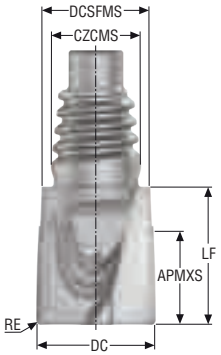
Parametri di taglio – XVE540 – Scanalatura PCEDC 4 Pollici

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 180) *540 (460 — 590)*
P3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (89 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (84 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P11	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (63 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	49 (37 — 61) *160 (130 — 200)*
M1	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (74 — 120) *330 (250 — 390)*
M2	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
M3	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 66) *165 (130 — 210)*
M5	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	43 (31 — 55) *140 (110 — 180)*
K1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (91 — 120) *345 (300 — 390)*
K3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (77 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
K5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 70) *195 (160 — 220)*
K6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (70 — 100) *280 (230 — 320)*
K7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 90) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	380 (320 — 440) *1250 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 42) *120 (96 — 130)*
S2	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (23 — 34) *95 (76 — 110)*
S3	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 29) *80 (66 — 95)*
S11	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 76) *195 (160 — 240)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*

XVE510

Uso generico – Universale – Spallamento – 2 Eliche – Raggio di punta





D

- Tolleranze:
- DC= h10
- RE= ±0,015 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			SIRA
XVE510E10100D1R050Z2	10138003	1	D	E10	10,0	9,7	8,0	11,8	0,5	2	6	■
XVE510E12120D1R050Z2	10138004	1	D	E12	12,0	11,7	10,0	14,0	0,5	2	8	■

■ Prodotto standard.

Parametri di taglio – XVE510 Contornatura

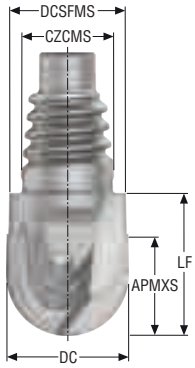
SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	210 (170 — 250) *690 (560 — 820)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	205 (170 — 240) *670 (560 — 780)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	175 (150 — 210) *570 (500 — 680)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	175 (140 — 200) *570 (460 — 650)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	165 (140 — 190) *540 (460 — 620)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	115 (82 — 140) *375 (270 — 450)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,080 *0.0032*	70 (50 — 89) *230 (170 — 290)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	135 (97 — 170) *445 (320 — 550)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	110 (78 — 130) *360 (260 — 420)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	70 (55 — 85) *230 (190 — 270)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	50 (41 — 64) *165 (140 — 200)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	44 (35 — 53) *145 (120 — 170)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	185 (160 — 210) *610 (530 — 680)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	130 (110 — 150) *425 (370 — 490)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	230 (190 — 270) *750 (630 — 880)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	100 (83 — 110) *330 (280 — 360)*
N1	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	470 (410 — 530) *1550 (1400 — 1700)*
N2	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	305 (270 — 340) *1000 (890 — 1100)*
N3	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	200 (180 — 230) *660 (600 — 750)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	370 (300 — 440) *1225 (990 — 1400)*
S1	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	60 (39 — 85) *195 (130 — 270)*
S2	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	55 (32 — 77) *180 (110 — 250)*
S3	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	39 (24 — 54) *130 (79 — 170)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	120 (110 — 140) *395 (370 — 450)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	95 (78 — 100) *310 (260 — 320)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	70 (61 — 84) *230 (210 — 270)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	540 (470 — 620) *1775 (1600 — 2000)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	540 (470 — 620) *1775 (1600 — 2000)*
GR1	A/D	0,20 *0.20*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	570 (510 — 630) *1875 (1700 — 2000)*

Parametri di taglio – XVE510 Scanalatura

SMG		a_p/DC	f_z		v_c
			10	12	
P1	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	135 (110 — 160) *445 (370 — 520)*
P2	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	130 (110 — 150) *425 (370 — 490)*
P3	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	115 (91 — 130) *375 (300 — 420)*
P4	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (80 — 110) *330 (270 — 360)*
P5	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (81 — 120) *330 (270 — 390)*
P6	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	110 (90 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	105 (85 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (81 — 120) *330 (270 — 390)*
P11	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	75 (53 — 94) *245 (180 — 300)*
P12	E/M/A/D	0,40 *0.40*	0,040 *0.0016*	0,048 *0.0019*	46 (33 — 58) *150 (110 — 190)*
M1	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	85 (62 — 110) *280 (210 — 360)*
M2	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	70 (50 — 89) *230 (170 — 290)*
M3	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,38 *0.38*	0,050 *0.0020*	0,060 *0.0024*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,38 *0.38*	0,050 *0.0020*	0,060 *0.0024*	28 (23 — 34) *90 (76 — 110)*
K1	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	120 (100 — 130) *395 (330 — 420)*
K2	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	105 (87 — 120) *345 (290 — 390)*
K3	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	90 (74 — 100) *295 (250 — 320)*
K4	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	85 (70 — 97) *280 (230 — 310)*
K5	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (80 — 120) *330 (270 — 390)*
K6	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	150 (120 — 170) *490 (400 — 550)*
K7	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	65 (54 — 74) *215 (180 — 240)*
N1	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
N2	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	225 (200 — 250) *740 (660 — 820)*
N3	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	150 (130 — 170) *490 (430 — 550)*
N11	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	250 (200 — 290) *820 (660 — 950)*
S1	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	40 (25 — 54) *130 (83 — 170)*
S2	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	35 (20 — 49) *115 (66 — 160)*
S3	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	80 (65 — 90) *260 (220 — 290)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	60 (50 — 69) *195 (170 — 220)*
S13	E	0,42 *0.42*	0,050 *0.0020*	0,060 *0.0024*	47 (39 — 54) *155 (130 — 170)*
TS1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
TP1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
GR1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	450 (400 — 490) *1475 (1400 — 1600)*

XVB510

Uso generico – Universale – A testa sferica – 2 Eliche



D





- Tolleranze:
- DC= h9
- RE= ±0,01 mm

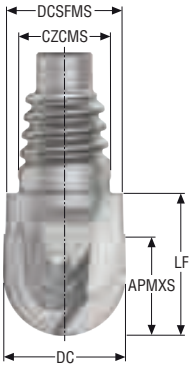
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Qualità
					mm	mm	mm	mm			SIRA
XVB510E10100D1BZ2	10138005	1	D	E10	10,0	9,7	8,0	11,8	2	6	■
XVB510E12120D1BZ2	10138006	1	D	E12	12,0	11,7	10,0	14,0	2	8	■
XVB510E16160D1BZ2	10138007	1	D	E16	16,0	15,5	13,0	18,1	2	10	■

■ Prodotto standard.

XVB510

Uso generico – Universale – A testa sferica – 2 Eliche – Pollici





D

- Tolleranze:
- DC= h9
- RE= ±.0004 Pollici



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*			SIRA
XVB510E10.375D1BZ2	10138008	1	D	E10	0.375	0.364	0.315	0.465	2	6	■
XVB510E12.500D1BZ2	10138009	1	D	E12	0.500	0.484	0.413	0.551	2	8	■
XVB510E16.625D1BZ2	10138010	1	D	E16	0.624	0.610	0.512	0.713	2	10	■

■ Prodotto standard.

Parametri di taglio – XVB510 Copiatura sgrossatura

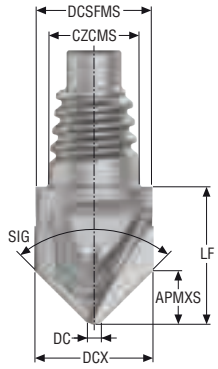
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (150 — 210) *610 (500 — 680)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	180 (150 — 210) *590 (500 — 680)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (130 — 180) *490 (430 — 590)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	145 (120 — 170) *475 (400 — 550)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	65 (50 — 78) *215 (170 — 250)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	39 (30 — 47) *130 (99 — 150)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	75 (59 — 91) *245 (200 — 290)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	60 (48 — 74) *195 (160 — 240)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	60 (48 — 74) *195 (160 — 240)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	46 (36 — 55) *150 (120 — 180)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	38 (30 — 46) *125 (99 — 150)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	180 (150 — 210) *590 (500 — 680)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	130 (110 — 150) *425 (370 — 490)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	125 (110 — 150) *410 (370 — 490)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	80 (63 — 94) *260 (210 — 300)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	115 (93 — 130) *375 (310 — 420)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	100 (81 — 120) *330 (270 — 390)*
N1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
N2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	285 (250 — 320) *940 (830 — 1000)*
N3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	190 (170 — 210) *620 (560 — 680)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	335 (270 — 400) *1100 (890 — 1300)*
S1	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	55 (33 — 76) *180 (110 — 240)*
S2	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	44 (27 — 61) *145 (89 — 200)*
S3	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	38 (23 — 52) *125 (76 — 170)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	105 (88 — 120) *345 (290 — 390)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	80 (68 — 94) *260 (230 — 300)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	65 (53 — 73) *215 (180 — 230)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
GR1	A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	630 (570 — 700) *2075 (1900 — 2200)*

Parametri di taglio – XVB510 Copiatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	365 (320 — 420) *1200 (1100 — 1300)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	355 (310 — 400) *1175 (1100 — 1300)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	305 (270 — 350) *1000 (890 — 1100)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	270 (230 — 310) *890 (760 — 1000)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	195 (160 — 240) *640 (530 — 780)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (150 — 220) *610 (500 — 720)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	95 (78 — 110) *310 (260 — 360)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (160 — 210) *610 (530 — 680)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	120 (95 — 140) *395 (320 — 450)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	90 (71 — 110) *295 (240 — 360)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	75 (59 — 92) *245 (200 — 300)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	360 (310 — 410) *1175 (1100 — 1300)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	310 (270 — 350) *1025 (890 — 1100)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	265 (230 — 300) *870 (760 — 980)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	250 (220 — 280) *820 (730 — 910)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	100 (79 — 120) *330 (260 — 390)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (120 — 180) *490 (400 — 590)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	130 (110 — 160) *425 (370 — 520)*
N1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	510 (390 — 630) *1675 (1300 — 2000)*
N2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	330 (250 — 400) *1075 (830 — 1300)*
N3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	220 (170 — 270) *720 (560 — 880)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	405 (270 — 530) *1325 (890 — 1700)*
S1	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	110 (66 — 150) *360 (220 — 490)*
S2	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	90 (53 — 120) *295 (180 — 390)*
S3	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	75 (46 — 100) *245 (160 — 320)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (130 — 220) *570 (430 — 720)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (95 — 170) *445 (320 — 550)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	105 (74 — 130) *345 (250 — 420)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
GR1	A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	850 (710 — 980) *2800 (2400 — 3200)*

XVC506/509/512

Uso generico – Universale – Smusso – 2 Eliche



N





- Tolleranze:
- SIG= ±1°

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCX	DC	DCSFMS	APMXS	LF	SIG°	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm				SIRA
XVC506E10100N1SZ2	10138012	1	N	E10	10,0	1,5	9,7	7,23	11,8	60,0	2	6	■
XVC506E12120N1SZ2	10138013	1	N	E12	12,0	1,5	11,7	7,73	14,0	60,0	2	8	■
XVC509E10100N1SZ2	10138014	1	N	E10	10,0	1,5	9,7	4,23	11,8	90,0	2	6	■
XVC509E12120N1SZ2	10138015	1	N	E12	12,0	1,5	11,7	5,23	14,0	90,0	2	8	■
XVC509E16160N1SZ2	10138016	1	N	E16	16,0	1,5	15,5	7,23	18,1	90,0	2	10	■
XVC512E12120N1SZ2	10138017	1	N	E12	12,0	1,5	11,7	3,03	14,0	120,0	2	8	■

■ Prodotto standard.

Parametri di taglio – XVC506 Smussatura

SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	195 (180 — 220) *640 (600 — 720)*
P3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	150 (130 — 160) *490 (430 — 520)*
P5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	150 (140 — 170) *490 (460 — 550)*
P11	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	105 (86 — 120) *345 (290 — 390)*
P12	E/M/A/D	0,10 *0.10*	1,6 *1.6*	0,15 *0.0060*	0,16 *0.0065*	65 (52 — 76) *215 (180 — 240)*
M1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,26 *0.010*	0,28 *0.011*	125 (99 — 140) *410 (330 — 450)*
M2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	100 (80 — 120) *330 (270 — 390)*
M3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	65 (45 — 84) *215 (150 — 270)*
M4	E/M/A	0,10 *0.10*	1,5 *1.5*	0,19 *0.0075*	0,20 *0.0080*	47 (33 — 60) *155 (110 — 190)*
M5	E/M/A	0,10 *0.10*	1,5 *1.5*	0,19 *0.0075*	0,20 *0.0080*	39 (27 — 50) *130 (89 — 160)*
K1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	200 (180 — 220) *660 (600 — 720)*
K2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	175 (160 — 190) *570 (530 — 620)*
K3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	150 (130 — 160) *490 (430 — 520)*
K4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	140 (130 — 150) *460 (430 — 490)*
K5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	85 (74 — 95) *280 (250 — 310)*
K6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	125 (110 — 140) *410 (370 — 450)*
K7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	110 (94 — 120) *360 (310 — 390)*
N1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,13 *0.0050*	43 (15 — 71) *140 (50 — 230)*
S2	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,13 *0.0050*	35 (12 — 57) *115 (40 — 180)*
S3	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	30 (10 — 49) *100 (33 — 160)*
S11	E	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	95 (72 — 120) *310 (240 — 390)*
S12	E	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	75 (55 — 94) *245 (190 — 300)*
S13	E	0,10 *0.10*	1,7 *1.7*	0,19 *0.0075*	0,20 *0.0080*	55 (43 — 72) *180 (150 — 230)*
H5	M/A	0,050 *0.050*	2,0 *2.0*	0,11 *0.0044*	0,12 *0.0048*	120 (110 — 140) *395 (370 — 450)*
H8	M/A	0,050 *0.050*	1,8 *1.8*	0,080 *0.0032*	0,085 *0.0034*	120 (99 — 130) *395 (330 — 420)*
H21	M/A	0,050 *0.050*	1,8 *1.8*	0,080 *0.0032*	0,085 *0.0034*	120 (99 — 130) *395 (330 — 420)*
H31	M/A	0,050 *0.050*	1,8 *1.8*	0,070 *0.0028*	0,075 *0.0030*	90 (75 — 100) *295 (250 — 320)*
TS1	A/D	0,10 *0.10*	2,0 *2.0*	0,17 *0.0065*	0,18 *0.0070*	260 (160 — 360) *850 (530 — 1100)*
TP1	A/D	0,10 *0.10*	2,0 *2.0*	0,17 *0.0065*	0,18 *0.0070*	260 (160 — 360) *850 (530 — 1100)*
GR1	A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	600 (500 — 690) *1975 (1700 — 2200)*

Parametri di taglio – XVC509 Smussatura

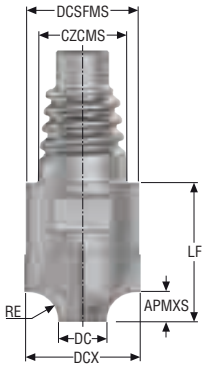
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	195 (180 — 220) *640 (600 — 720)*
P3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	0,26 *0.010*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	150 (130 — 160) *490 (430 — 520)*
P5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	150 (130 — 160) *490 (430 — 520)*
P11	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	105 (85 — 120) *345 (280 — 390)*
P12	E/M/A/D	0,10 *0.10*	1,6 *1.6*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	60 (50 — 74) *195 (170 — 240)*
M1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	0,28 *0.011*	120 (98 — 140) *395 (330 — 450)*
M2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	100 (80 — 120) *330 (270 — 390)*
M3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	65 (45 — 84) *215 (150 — 270)*
M4	E/M/A	0,10 *0.10*	1,5 *1.5*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	46 (33 — 60) *150 (110 — 190)*
M5	E/M/A	0,10 *0.10*	1,5 *1.5*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	39 (27 — 50) *130 (89 — 160)*
K1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	200 (180 — 220) *660 (600 — 720)*
K2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	175 (160 — 190) *570 (530 — 620)*
K3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	145 (130 — 160) *475 (430 — 520)*
K4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	140 (130 — 150) *460 (430 — 490)*
K5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	85 (74 — 95) *280 (250 — 310)*
K6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	125 (110 — 130) *410 (370 — 420)*
K7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	110 (94 — 120) *360 (310 — 390)*
N1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	600 (500 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0,10 *0.10*	2,0 *2.0*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*	43 (15 — 71) *140 (50 — 230)*
S2	E	0,10 *0.10*	2,0 *2.0*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*	35 (12 — 57) *115 (40 — 180)*
S3	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*	30 (10 — 50) *100 (33 — 160)*
S11	E	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	75 (55 — 94) *245 (190 — 300)*
S13	E	0,10 *0.10*	1,7 *1.7*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	55 (42 — 72) *180 (140 — 230)*
H5	M/A	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*	120 (110 — 140) *395 (370 — 450)*
H8	M/A	0,10 *0.10*	1,8 *1.8*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	120 (99 — 130) *395 (330 — 420)*
H21	M/A	0,10 *0.10*	1,8 *1.8*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	120 (99 — 130) *395 (330 — 420)*
H31	M/A	0,10 *0.10*	1,8 *1.8*	0,075 *0.0030*	0,080 *0.0032*	0,085 *0.0034*	90 (75 — 100) *295 (250 — 320)*
TS1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	600 (500 — 700) *1975 (1700 — 2200)*

Parametri di taglio – XVC512 Smussatura

SMG		a_e/DC	a_p/DC	f_z	v_c
				12	
P1	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	165 (150 — 180) *540 (500 — 590)*
P2	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	160 (140 — 170) *520 (460 — 550)*
P3	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	135 (120 — 150) *445 (400 — 490)*
P4	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P5	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P6	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	135 (120 — 150) *445 (400 — 490)*
P7	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	125 (120 — 140) *410 (400 — 450)*
P8	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P11	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	85 (68 — 100) *280 (230 — 320)*
P12	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,22 *0.0085*	50 (41 — 61) *165 (140 — 200)*
M1	E/M/A	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	100 (80 — 110) *330 (270 — 360)*
M2	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	80 (65 — 96) *260 (220 — 310)*
M3	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	50 (37 — 68) *165 (130 — 220)*
M4	E/M/A	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	39 (28 — 51) *130 (92 — 160)*
M5	E/M/A	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	33 (23 — 42) *110 (76 — 130)*
K1	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	140 (130 — 150) *460 (430 — 490)*
K3	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	115 (110 — 130) *375 (370 — 420)*
K4	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	110 (98 — 120) *360 (330 — 390)*
K5	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	65 (58 — 75) *215 (200 — 240)*
K6	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	100 (86 — 110) *330 (290 — 360)*
K7	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	85 (74 — 96) *280 (250 — 310)*
N1	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	480 (410 — 560) *1575 (1400 — 1800)*
N2	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	310 (260 — 360) *1025 (860 — 1100)*
N3	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	205 (180 — 240) *670 (600 — 780)*
N11	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	320 (290 — 360) *1050 (960 — 1100)*
S1	E	0,10 *0.10*	1,3 *1.3*	0,19 *0.0075*	35 (12 — 58) *115 (40 — 190)*
S2	E	0,10 *0.10*	1,3 *1.3*	0,19 *0.0075*	29 (9,6 — 47) *95 (32 — 150)*
S3	E	0,10 *0.10*	1,3 *1.3*	0,17 *0.0065*	25 (8,3 — 41) *80 (28 — 130)*
S11	E	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	80 (58 — 98) *260 (200 — 320)*
S12	E	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	60 (45 — 76) *195 (150 — 240)*
S13	E	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	47 (35 — 59) *155 (120 — 190)*
H5	M/A	0,10 *0.10*	1,3 *1.3*	0,17 *0.0065*	100 (83 — 110) *330 (280 — 360)*
H8	M/A	0,10 *0.10*	1,3 *1.3*	0,13 *0.0050*	100 (84 — 110) *330 (280 — 360)*
H21	M/A	0,10 *0.10*	1,3 *1.3*	0,13 *0.0050*	100 (84 — 110) *330 (280 — 360)*
H31	M/A	0,10 *0.10*	1,3 *1.3*	0,11 *0.0044*	75 (64 — 88) *245 (210 — 280)*
TS1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	200 (130 — 280) *660 (430 — 910)*
TP1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	200 (130 — 280) *660 (430 — 910)*
GR1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	480 (410 — 560) *1575 (1400 — 1800)*

XVK310

Uso generico – Universale – Concava – 4 Eliche







- Tolleranze:
- RE= ≤5= ±0,05 mm
- RE= >5= ±0,1 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCX	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm	mm			SIRA
XVK310E12120D1K300Z4	10137998	1	D	E12	12,0	5,0	11,7	3,0	14,5	3,0	4	10	■
XVK310E12120D1K400Z4	10137999	1	D	E12	12,0	4,0	11,7	4,0	14,5	4,0	4	10	■
XVK310E16160D1K500Z4	10138000	1	D	E16	16,0	6,0	15,5	5,0	18,7	5,0	4	12	■
XVK310E20200D1K600Z4	10138001	1	D	E20	20,0	8,0	19,3	6,0	21,3	6,0	4	16	■

■ Prodotto standard.

Parametri di taglio – XVK310 Contornatura sgrossatura

SMG		a_p/D_c	f_z			v_c
			12	16	20	
P1	E/M/A/D	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	290 (195 — 310) *950 (640 — 1100)*
P2	E/M/A/D	0,24 *0,24*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	280 (190 — 305) *910 (620 — 1000)*
P3	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	240 (165 — 260) *790 (540 — 850)*
P4	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	210 (145 — 230) *680 (475 — 760)*
P5	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
P6	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	230 (155 — 245) *760 (510 — 800)*
P7	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	215 (145 — 230) *710 (475 — 760)*
P8	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (140 — 220) *670 (460 — 730)*
P11	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	210 (140 — 225) *680 (460 — 740)*
M1	E/M/A	0,24 *0,24*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	255 (170 — 270) *840 (560 — 890)*
M2	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
M3	E/M/A	0,24 *0,24*	0,036 *0,0014*	0,048 *0,0019*	0,060 *0,0024*	150 (105 — 165) *490 (345 — 540)*
M4	E/M/A	0,24 *0,24*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	110 (75 — 120) *360 (250 — 400)*
M5	E/M/A	0,24 *0,24*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	95 (65 — 100) *310 (220 — 320)*
K1	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
K2	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	175 (120 — 190) *570 (400 — 620)*
K3	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	150 (100 — 160) *490 (320 — 530)*
K4	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	140 (95 — 150) *460 (310 — 490)*
K5	E/M/A/D	0,24 *0,24*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	85 (55 — 90) *280 (180 — 300)*
K6	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	125 (85 — 135) *410 (280 — 445)*
K7	E/M/A/D	0,24 *0,24*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	105 (70 — 115) *345 (220 — 375)*
N1	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	315 (215 — 340) *1025 (710 — 1125)*
N2	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
N3	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	135 (90 — 145) *445 (300 — 475)*
N11	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S1	E	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	205 (140 — 220) *670 (460 — 730)*
S2	E	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	205 (140 — 220) *670 (460 — 730)*
S3	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S11	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	265 (180 — 285) *870 (590 — 940)*
S12	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S13	E	0,24 *0,24*	0,040 *0,0016*	0,050 *0,0022*	0,065 *0,0026*	155 (105 — 165) *510 (345 — 540)*
TS1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
TP1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
GR1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*

Ricalcolo

Usare la versione standard contornatura sgrossaturaparametri di taglio e poi ricalcolare i parametri!										Usare la versione standard parametri di taglio con versione standard scanalatura parametri di taglio e poi ricalcolare i parametri!						
	Scanalatura		Contornatura sgrossatura			**Contornatura finitura**				Rampa		Elicoidale			Foratura	
Dritto																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% di DC)	f_z	a_p	a_p	f_z	f_z	a_p/360º (% di DC)	foro Ø (**≥ % di** DC)	f_z	a_p (% di DC)
										≤ 30° *						
JS412																
LV2	100	100	100	100	100	140	3	40	120	80	100	50	10	130	50	100
										≤ 10° *						
JS413																
LV2	100	100	100	100	100	150	3	40	120	70	50	50	10	130	X	X
LV3	X	X	25	60	240	120	3	40	230	70	50	50	10	130	X	X
										≤ 30° *						
JS452																
LV2	100	100	100	100	100	140	3	35	120	70	100	50	10	130	50	100
LV3	50	60	75	60	50	120	3	40	100	70	70	50	10	130	20	10
										≤ 10° *						
JS453																
LV2	100	100	100	100	100	140	3	35	120	70	50	50	10	130	20	10
LV3	X	X	25	60	240	120	3	40	230	70	70	50	10	130	20	10
										≤ 30° *						
JSE512																
LV2	100	100	100	100	100	110	3	65	125	40	40	100	5	130	40	40
										≤ 5° *						
JSE513																
LV2	100	100	100	100	100	110	3	85	150	100	100	100	5	130	50	40
LV3	30	100	30	50	200	110	3	85	250	X	X	X	X	X	X	X
LV4	X	X	X	X	X	60	3	80	350	X	X	X	X	X	X	X
										≤ 5° *						
JSE514																
LV1	100	100	100	100	100	110	3	60	150	100	100	100	5	130	X	X
LV2	100	100	100	100	100	110	3	60	150	100	100	100	5	130	X	X
LV3	X	X	25	50	200	110	3	60	250	X	X	X	X	X	X	X
LV4	X	X	X	X	X	60	3	80	350	X	X	X	X	X	X	X
										≤ 45° *						
JS553																
LV1	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV2	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV3	40	60	40	105	200	110	3	55	250	50	15	35	3	130	35	50
										≤ 5° *						
JS554																
LV1	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV2	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	53	250	50	50	60	3	130	X	X
JS564																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	105	140	110	3	55	140	X	X	60	1,5	130	X	X
JS565																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	105	140	110	3	55	140	X	X	60	1,5	130	X	X

*Massimo angolo di entrata in rampa
Tutti i valori sono percentuali dei parametri di taglio originali (100%).

Ricalcolo

Usare la versione standard contornatura sgrossaturaparametri di taglio e poi ricalcolare i parametri!										Usare la versione standard parametri di taglio con versione standard scanalatura parametri di taglio e poi ricalcolare i parametri!						
	Scanalatura		Contornatura sgrossatura			**Contornatura finitura**				Rampa		Elicoidale			Foratura	
Dritto																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% di DC)	f_z	a_p	a_p	f_z	f_z	a_p/360º (% di DC)	foro Ø (**≥ % di** DC)	f_z	a_p (% di DC)
										≤ 45° *						
J28																
LV2	100	100	100	100	100	140	3	100	135	40	25	100	10	130	25	60
										≤ X° *						
J36																
LV2	X	X	100	100	100	120	3	85	150	X	X	X	X	X	X	X
										≤ 20° *						
J93F																
LV2	100	100	100	100	100	133	3	40	100	100	100	100	3	130	25	30
										≤ 1°						
JH120																
LV2	100	100	100	100	100	120	3	120	80	17	100	100	2	130	X	X
										≤ X° *						
JH130																
LV2	X	X	100	100	100	120	3	120	80	X	X	X	X	X	X	X
										≤ X° *						
JH142																
LV2	X	X	100	100	100	110	3	80	70	X	X	30	2	130	X	X
LV3	X	X	100	100	100	110	3	80	70	X	X	20	1	130	X	X
LV6	X	X	100	100	100	110	3	80	70	X	X	10	1	130	X	X
										≤ 45° *						
JH830																
LV2	100	100	100	100	100	110	3	110	80	9	135	135	3	130	X	X
										≤ X° *						
JH910																
LV2	100	100	100	100	100	125	4	100	80	15	140	140	3	130	X	X
LV3	80	80	100	80	80	125	4	80	65	10	110	110	3	130	X	X
										≤ X° *						
JH930																
LV2	X	X	100	100	100	125	2	30	100	X	X	X	X	X	X	X

*Massimo angolo di entrata in rampa
Tutti i valori sono percentuali dei parametri di taglio originali (100%).

Ricalcolo

Usare la versione standard contornatura sgrossaturaparametri di taglio e poi ricalcolare i parametri!										Usare la versione standard parametri di taglio con versione standard scanalatura parametri di taglio e poi ricalcolare i parametri!						
	Scanalatura		Contornatura sgrossatura			**Contornatura finitura**				Rampa		Elicoidale			Foratura	
Dritto																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% di DC)	f_z	a_p	a_p	f_z	f_z	a_p/360º (% di DC)	foro Ø (≥ % di DC)	f_z	a_p (% di DC)
										≤ 5° *						
JH40																
LV2	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
LV3	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
										≤ 45° *						
JH410																
LV2	100	100	100	100	100	125	2	25	100	100	67	67	40	130	67	80
LV2 (ML)	75	60	80	60	100	125	2	25	100	60	40	40	40	130	40	50
LV2 (TL)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV2 (RS)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV3 (RS)	95	95	80	100	100	100	2	100	100	50	50	50	40	130	75	40
										≤ 45° *						
JH421																
LV2	100	100	100	100	100	100	4	35	100	100	100	100	25	130	45	80
										≤ 30° *						
JH440																
LV2	100	100	100	100	100	125	3	40	100	100	100	100	5	130	X	X
										≤ 5° *						
JHP750																
LV1	115	120	115	115	100	100	2	145	100	100	120	120	3	130	10	70
LV2	100	100	100	100	100	100	2	145	100	100	100	100	3	130	10	60
										≤ 5° *						
JHP951																
LV2	100	100	100	100	100	158	2	50	113	20	100	125	3	130	6	20
										≤ 10° *						
JHP993																
LV2	100	100	100	100	100	X	X	X	X	30	100	100	3	130	4	40
LV3	80	80	80	80	80	X	X	X	X	20	80	80	3	130	3	30
										≤ X° *						
JS520																
LV2	X	X	100	100	100	133	2	65	100	X	X	X	X	X	X	X
LV3	X	X	X	X	X	133	2	65	175	X	X	X	X	X	X	X
										≤ X° *						
JS522																
LV4	X	X	100	100	100	129	2	140	100	X	X	X	X	X	X	X
JS720																
LV2	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
LV3	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
JS754																
LV1	100	100	100	100	100	110	3	55	150	100	100	100	3	130		
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	55	250	50	50	60	3	130		
JS755																
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	100	110	3	55	250	50	50	60	3	130		

*Massimo angolo di entrata in rampa
Tutti i valori sono percentuali dei parametri di taglio originali (100%).

Ricalcolo

Usare la versione standard contornatura sgrossaturaparametri di taglio e poi ricalcolare i parametri!										Usare con versione standard contornatura parametri di taglio e poi ricalcolare i parametri!						
	Scanalatura		Contornatura sgrossatura			**Contornatura finitura**				Rampa		Elicoidale			Foratura	
Dritto																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% di DC)	f_z	a_p	a_p	f_z	f_z	a_p/360º (% di DC)	foro Ø (**≥ % di** DC)	f_z	a_p (% di DC)
										≤ X°						
JME542-JME562-JME564																
LV1	100	100	100	100	100	125	2	150	5	X	X	X	X	X	X	X
LV2	63	100	100	100	65	125	2	150	3	X	X	X	X	X	X	X
LV3	25	100	100	100	25	125	2	150	1	X	X	X	X	X	X	X
LV4 (TL)	18	100	100	100	20	125	2	150	1	X	X	X	X	X	X	X
LV4 (XL)	12	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV5	10	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV6	4	100	100	100	5	125	2	150	1	X	X	X	X	X	X	X
LV7	2	100	100	100	2	125	2	150	1	X	X	X	X	X	X	X
										≤ X°						
JME142-JME144																
LV1	100	100	100	100	100	100	2	150	5	X	X	X	X	X	X	X
LV2	85	85	100	100	63	100	2	150	3	X	X	X	X	X	X	X
LV3	75	75	100	100	25	100	2	150	1	X	X	X	X	X	X	X
LV4	60	60	100	100	20	100	2	150	1	X	X	X	X	X	X	X
LV5	50	50	100	100	10	100	2	150	1	X	X	X	X	X	X	X
LV6	40	40	100	100	5	100	2	150	1	X	X	X	X	X	X	X
										≤ X° *						
JM403-JM404-JM406																
LV1	100	100	100	100	100	X	X	X	X	X	X	X	X	X	X	X
LV2	100	75	100	75	100	X	X	X	X	X	X	X	X	X	X	X
LV3 (L)	100	75	100	75	90	X	X	X	X	X	X	X	X	X	X	X
LV3 (TL)	90	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (XL)	75	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (SL)	75	75	100	75	45	X	X	X	X	X	X	X	X	X	X	X
LV5	50	50	100	50	30	X	X	X	X	X	X	X	X	X	X	X
JME642																
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
										≤2						
JC898																
LV3	X	X	100	100	100	X	X	X	X	X	50	80	3	130-160	X	X
										≤5º						
JC899																
LV3	X	X	100	100	100	100	3	50	100	X	X	X	X	X	X	X

*Massimo angolo di entrata in rampa
Tutti i valori sono percentuali dei parametri di taglio originali (100%).

Ricalcolo

Usare la versione standard contornatura sgrossaturaparametri di taglio e poi ricalcolare i parametri!										Usare la versione standard parametri di taglio con versione standard scanalatura parametri di taglio e poi ricalcolare i parametri!						
	Scanalatura		Contornatura sgrossatura			**Contornatura finitura**				Rampa		Elicoidale			Foratura	
Dritto																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% di DC)	f_z	a_p	a_p	f_z	f_z	a_p/360º (% di DC)	foro Ø (≥ % di DC)	f_z	a_p (% di DC)
										≤ 1°						
JHP170																
LV2	100	100	100	100	100	130	3	175	80	100	100	100	2	130	X	X
										≤ 30°						
JHP490																
LV2	100	100	100	100	100	X	X	X	X	50	50	35	5	130	30	50
LV2 (E-Forma)	100	75	100	100	100	X	X	X	X	50	50	35	5	130	30	50
LV3	100	75	80	100	100	X	X	X	X	50	50	35	5	130	30	50
LV4	150	75	80	100	100	X	X	X	X	50	50	35	5	130	30	50
										≤ 5°						
JHP760																
LV2	100	100	100	100	100	140	2	125	15	30	100	100	3	130	10	50
LV3	50	50	100	50	50	140	2	125	15	15	50	50	3	130	5	25
										≤ 15°						
JHP770																
LV2	100	100	100	100	100	170	3	125	100	100	40	40	3	130	X	X
										≤ 5°						
JHP780																
LV1	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
LV2	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
JD620																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	20	100	60	100	60	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD630																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD640																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X

*Massimo angolo di entrata in rampa
Tutti i valori sono percentuali dei parametri di taglio originali (100%).

Ricalcolo

Usare la versione standard contornatura sgrossaturaparametri di taglio e poi ricalcolare i parametri!										Usare la versione standard parametri di taglio con versione standard scanalatura parametri di taglio e poi ricalcolare i parametri!								
	Scanalatura		Contornatura sgrossatura			**Contornatura finitura**				Rampa		Elicoidale			Penetrazione assiale			
Dritto																		
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% di DC)	f_z	a_p	a_p	f_z	f_z	a_p/360º (% di DC)	foro Ø (**≥ % di** DC)	v_c	a_e (% di DC)	f_z	a_e-sd (% di DC)
JHF181																		
LV1	100	100	100	100	100	X	X	X	X	X	X	100	3,4	130	X	X	X	X
LV2	80	85	100	85	80	X	X	X	X	X	X	85	3,0	130	X	X	X	X
LV3	60	70	100	70	60	X	X	X	X	X	X	70	2,5	130	X	X	X	X
										≤ 1,5° *								
JHF980																		
LV1	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV2	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV3	80	85	80	85	80	X	X	X	X	80	85	85	3	130	70	30	33	200
LV4	50	70	50	70	60	X	X	X	X	60	70	70	3	130	70	30	33	200

*Massimo angolo di entrata in rampa
Tutti i valori sono percentuali dei parametri di taglio originali (100%).

Ricalcolo

Usare i parametri di taglio con versione standard e poi ricalcolare i parametri!										Usare la versione standard parametri di taglio con versione standard scanalatura parametri di taglio e poi ricalcolare i parametri!									
	Scanalatura		Contornatura sgrossatura			**Contornatura finitura**				Copiatura sgrossatura			**Copiatura finitura**				Elicoidale		
SFERA																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% di DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% di DC)	f_z	a_p	f_z	a_p/360º (% di DC)	foro Ø (≥ % di DC)
JSB512																			
LV2	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	100	5	130
JS532																			
LV1	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV2	X	X	70	100	70	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV3	X	X	X	X	X	125	3	125	10	X	X	X	X	X	X	X	X	X	X
JS533																			
LV1	X	X	100	100	100	125	3	125	15	X	X	X	X	X	X	X	75	5	130
LV2	X	X	75	75	75	125	3	125	15	X	X	X	X	X	X	X	75	5	130
JS534																			
LV1	X	X	100	100	100	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV2	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV3	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
JHB970																			
LV1	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV2	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV3	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
JHB720																			
LV2	X	X	100	100	100	125	2	90	75	X	X	X	X	X	X	X	40	3	130
JH112																			
LV1	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV2	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV3	X	X	100	100	100	110	1,6	55	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	130	1,4	55	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	130	1,4	50	100	X	X	X	X	X	X	X	X	X	X
LV6	X	X	100	100	100	130	1	35	100	X	X	X	X	X	X	X	X	X	X
JH150																			
LV2	X	X	100	100	100	165	1	90	35	X	X	X	X	X	X	X	30	2	130

*Massimo angolo di entrata in rampa

Tutti i valori sono percentuali dei parametri di taglio originali (100%).

Ricalcolo

Usare la versione standard contornatura sgrossaturaparametri di taglio e poi ricalcolare i parametri!										Usare la versione standard parametri di taglio con versione standard scanalatura parametri di taglio e poi ricalcolare i parametri!									
	Scanalatura		Contornatura sgrossatura			**Contornatura finitura**				Copiatura sgrossatura			**Copiatura finitura**				Elicoidale		
SFERA																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% di DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% di DC)	f_z	a_p	f_z	a_p/360º (% di DC)	foro Ø (≥ % di DC)
JH160																			
Standard (2)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
JH450																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	45	5	130
JH460																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	X	X	X
JMB542-JMB562-JMB563																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	125	2	150	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	100	100	63	125	2	150	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	100	100	25	125	2	150	1	X	X	X
LV4 (TL)	20	100	X	X	X	X	X	X	X	100	100	19	125	2	150	1	X	X	X
LV4 (XL)	12	100	X	X	X	X	X	X	X	100	100	12	125	2	150	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	100	100	10	125	2	150	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	100	100	4	125	2	150	1	X	X	X
LV7	2	100	X	X	X	X	X	X	X	100	100	2	125	2	150	1	X	X	X
JMB112																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	118	2	120	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	64	85	85	118	2	120	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	56	75	75	118	2	120	1	X	X	X
LV4	20	100	X	X	X	X	X	X	X	45	60	60	118	2	120	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	38	50	50	118	2	120	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	30	40	40	118	2	120	1	X	X	X
JM413-JM416																			
LV1	X	X	100	100	100	100	5	40	35	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	60	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	80	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	60	75	100	5	40	10	X	X	X	X	X	X	X	X	X	X
JMB642																			
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
										≤2									
JD660																			
LV1	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X

*Massimo angolo di entrata in rampa
Tutti i valori sono percentuali dei parametri di taglio originali (100%).

Terminologia e formule

Giri al minuto

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_c} \quad \text{(giri/min)}$$

Velocità di taglio

$$v_c = \frac{n \cdot \pi \cdot D_c}{1000} \quad \text{(m/min)}$$

Velocità di avanzamento

$$v_f = n \cdot z_n \cdot f_z \quad \text{(mm/min)}$$

Avanzamento per giro

$$f = z_n \cdot f_z \quad \text{(mm/giro)}$$

Volume di truciolo asportato

$$Q = \frac{a_e \cdot a_p \cdot v_f}{1000} \quad \text{(cm}^3\text{/min)}$$

Velocità di taglio e numero di giri/min in operazioni di copiatura

$$v_c = \frac{n \cdot \pi \cdot D_w}{1000} \quad \text{(m/min)}$$

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_w} \quad \text{(Numero di giri al minuto)}$$

$$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)} \quad \text{(mm)}$$

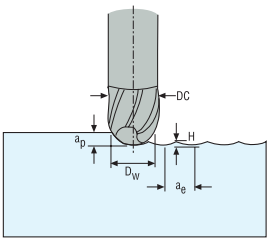
Calcolo di a_p in rapporto alla sporgenza della fresa:
Se la sporgenza (XS) supera il valore di 4 x DC e viene impiegato un attacco cilindrico, è importante adottare un'altra profondità di taglio (a_p) rispetto ai valori della tabella.
Utilizzare la seguente formula per calcolare il nuovo valore di a_p

$$a_p\text{nuovo} = a_p \times (4 \times DC/XS)^2$$

Altezza profilo

$$H = \frac{D_c}{2} - \frac{\sqrt{D_c^2 - a_e^2}}{2}$$

$$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)} \quad \text{(mm)}$$



Altezza profilo H (um)

DC	Passo a_e (µm)						
	0,06	0,08	0,11	0,15	0,20	0,3	0,45
1	0,90	1,60	3,00	5,70	10,0	23,0	53,0
2	0,45	0,80	1,50	2,80	5,0	11,0	26,0
4	0,23	0,40	0,76	1,40	2,5	5,60	13,0
6	0,15	0,27	0,50	0,94	1,7	3,80	8,40
8	0,11	0,20	0,38	0,70	1,3	2,80	6,30
10	0,09	0,16	0,30	0,56	1,0	2,30	5,10
12	0,08	0,13	0,25	0,47	0,83	1,90	4,20

a_p = Profondità di taglio / profondità di taglio assiale (mm)
a_e = Larghezza di taglio / profondità di taglio radiale (mm)
DC = Diametro fresa
f = Avanzamento al giro (mm/giro)
f_z = Avanzamento al dente (mm/dente)
z_n = Numero di denti
n = Giri al minuto (giri/min)
Q = Volume di truciolo asportato (cm^3/min)
v_c = Velocità di taglio (m/min)
v_f = Velocità di avanzamento (mm/min)
D_w = Diametro di taglio

Raccomandazioni per l’uso

Metodo di entrata in rampa
La tabella seguente mostra la percentuale della velocità di avanzamento in relazione all’angolo di entrata in rampa

Diametro del foro raccomandato per interpolazione elicoidale

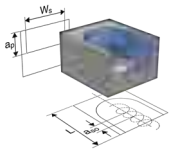
Diametro fresa DC	Diametro del foro
1-2,5	1,4 x DC
3-6	1,3 x DC
8-12	1,2 x DC
16-32	1,15 x DC



Metodo trocoidale
L’immagine seguente mostra un metodo spesso denominato fresatura trocoidale

Larghezza raccomandata della cava

Diametro fresa DC	Larghezza della cava
1-2,5	1,8 x DC
3-6	1,6 x DC
8-12	1,4 x DC
16-32	1,2 x DC





MINIMASTER™

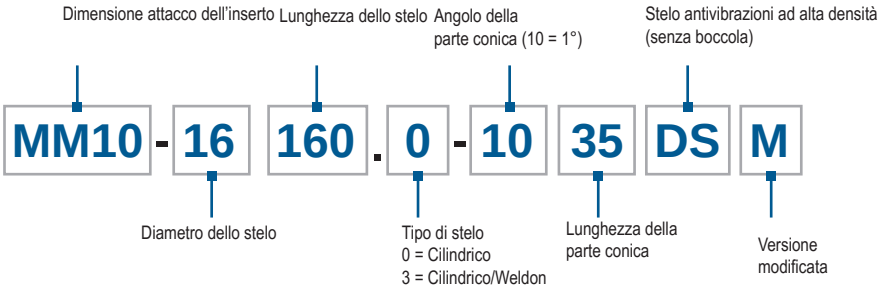
Minimaster™ è un sistema di fresatura esclusivo e versatile in grado di combinare differenti soluzioni offrendo ottima accessibilità in combinazione con le massime stabilità e sicurezza.

Il disegno flessibile a due pezzi combina steli e testine per risparmiare tempo e contenere i costi, creando un utensile versatile in grado di soddisfare praticamente qualsiasi applicazione: ridurre al minimo la sporgenza, ottenere la massima stabilità e altro ancora.

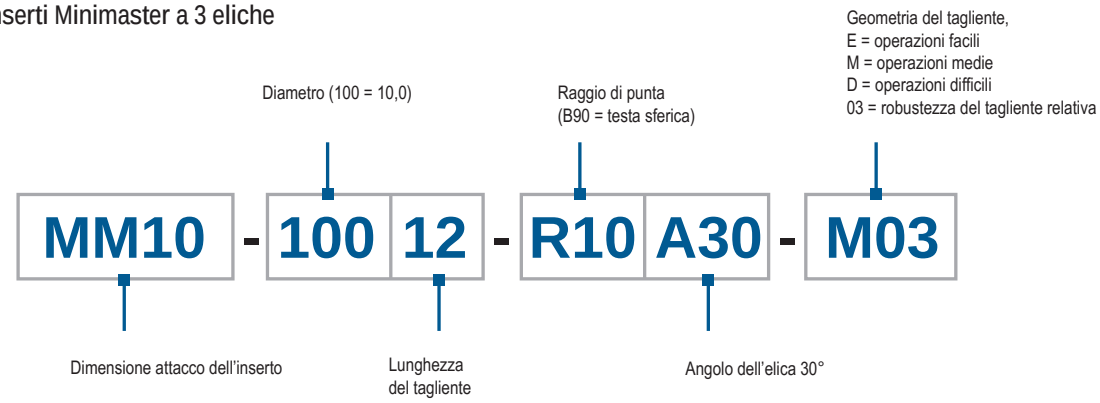
- Gamma a spallamento retto: 6-20 mm (0,25 - 0,75 pollici)
- Gamma a testa sferica: 6-20 mm (0,25 - 0,75 pollici)
- Gamma per centraggio/smussatura: 6-19,05 mm (0,25 - 0,750 pollici)
- Gamma a elevato avanzamento: 8-12 mm (0,375 - 0,625 pollici)
- Gamma per penetrazione assiale: 6-16 mm (0,25 - 0,625 pollici)
- Gamma per raggio concavo: 12 mm (0,472 pollici)

Chiavi di codifica

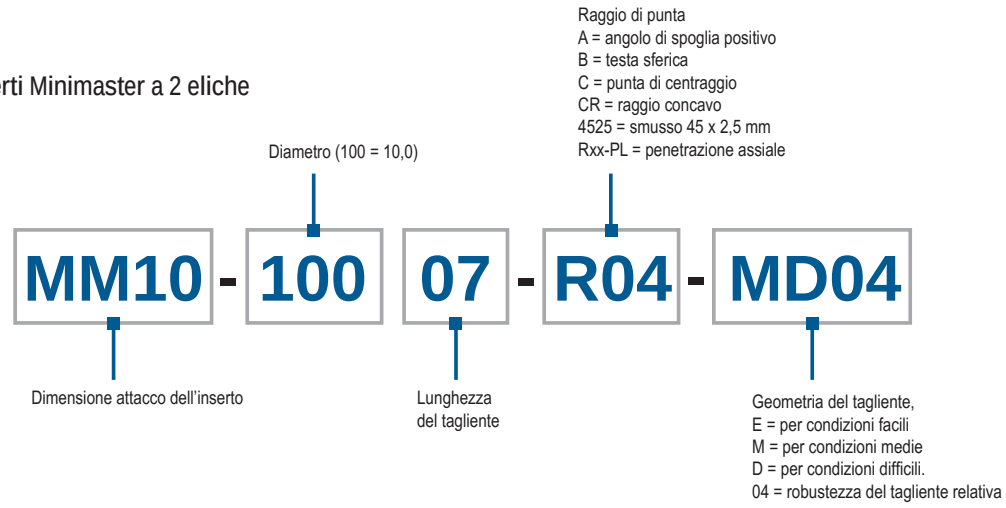
Steli



Inserti Minimaster a 3 eliche



Inserti Minimaster a 2 eliche

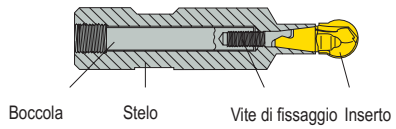
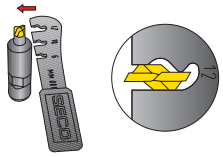
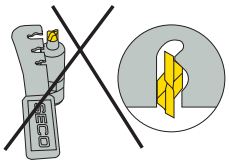
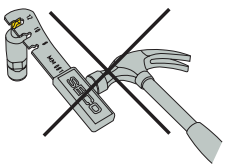
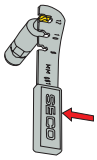


Nota: le parti del codice possono variare in base ai diversi tipi di inserto o di stelo

Adduzione refrigerante interna



Istruzioni di montaggio per Minimaster a 2 eliche

Chiave dinamometrica	
	La boccola deve essere serrata saldamente nello stelo prima di montare la vite di fissaggio e l'inserto. Se non è possibile utilizzare la chiave per sostituire l'inserto (se l'inserto è rotto o incastrato nello stelo), è possibile rilasciare la boccola, che a sua volta libera l'inserto. Utilizzare la chiave a brugola (ruotandola in senso antiorario) per arretrare la boccola fino a liberare l'inserto. Serrare nuovamente la boccola nello stelo prima di montare la vite di fissaggio e il nuovo inserto. Per Minimaster a 3 eliche è necessario utilizzare un'altra chiave (MM0416) (sede della chiave sulla parte esagonale dell'inserto).
	Assicurarsi che la chiave sia utilizzata correttamente
	Se la chiave è utilizzata sul lato sbagliato, causerà dei danni
	Non applicare una forza eccessiva
	La normale forza manuale è più che sufficiente

Guida alla scelta

1. Selezionare la dimensione attacco
Il design del pezzo in lavorazione e le operazioni di lavorazione determinano la dimensione attacco idonea. Selezionare la dimensione attacco più grande possibile per ottenere la migliore robustezza e stabilità.

2. Selezionare l'inserto
a. Utilizzare le tabelle che iniziano a pagina 676 per classificare il materiale da lavorare in un gruppo materiale Seco.
b. Cercare le pagine per la dimensione inserto selezionata e scegliere un inserto adatto nella tabella di selezione degli inserti.

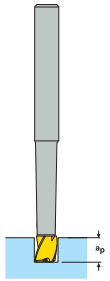
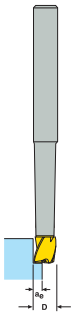
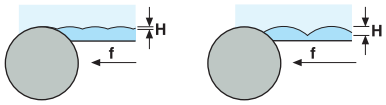
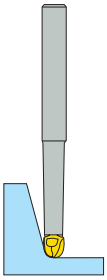
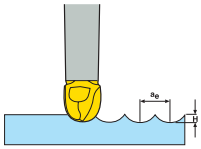
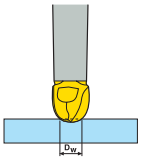
3. Selezionare lo stelo
a. Cercare le pagine per la dimensione attacco selezionata e scegliere uno stelo adatto nella tabella dei dati dell'utensile.
b. Scegliere sempre lo stelo più corto possibile per ottenere la migliore stabilità possibile.

4. Selezionare i parametri di taglio
a. Le raccomandazioni relative alla velocità di taglio sono riportate nelle tabelle dei parametri di taglio per ogni dimensione attacco selezionata. Le raccomandazioni sui
parametri di taglio si basano su condizioni stabili e potrebbero quindi essere regolate in base alla stabilità dell'
applicazione (utensili, macchina e fissaggio del pezzo in lavorazione). La regola generale per l'ap massimo nella scanalatura è DC*0,3 = Max APMXS. (Vedere la figura 1)
b. Le raccomandazioni sulle velocità di avanzamento e di taglio sono riportate nella tabella di conversione dei parametri di taglio.
c. I giri al minuto massimi che per motivi di sicurezza non devono mai essere superati sono indicati a pagina N/A.
d. Se la fresa non è completamente impegnata, l'avanzamento al dente e la velocità di taglio devono essere aumentati rispetto alle
raccomandazioni per una fresa completamente impegnata. Il motivo è quello di mantenere lo spessore medio del truciolo e la
temperatura di esercizio nella zona di taglio.
e. Dividere la profondità di taglio radiale per il diametro per ottenere l'effettiva percentuale di impegno della fresa (a_e/DC%); per le frese a testa sferica utilizzare il diametro effettivo di lavoro D_w invece di DC (vedere le figure 2 e 6).
f. Utilizzare la percentuale per ottenere il corretto avanzamento al dente e la velocità di taglio consigliata per l'effettivo impegno della fresa.

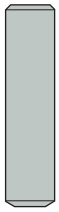
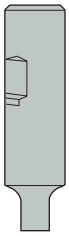
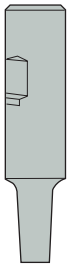
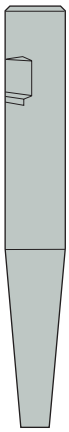
5. Generale
- Durante la fresatura di angoli e fondi di cavità, l'avanzamento deve essere ridotto a causa dell'aumento dello spessore medio del truciolo. Utilizzare le raccomandazioni per l'avanzamento al dente per una fresa completamente impegnata.
- Per la copiatura in spinta a forte inclinazione con un angolo maggiore di 40° o la copiatura in tirata con un angolo maggiore di 30° in combinazione con piccole profondità di taglio, utilizzare il diametro (DC) come diametro di lavoro invece di Dw.
- Durante il calcolo dell'avanzamento per giro e della velocità di avanzamento, utilizzare sempre il valore ZEFP. Questo è il numero effettivo di denti da utilizzare per il calcolo dei parametri di taglio. Il valore ZEFP si trova nella tabella di selezione dell'inserto.

Nota! Si verificherà un deterioramento della finitura superficiale del pezzo in lavorazione quando l'avanzamento aumenta. (Vedere le figure 3 e 5)

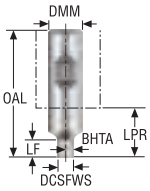
Figure Minimaster

Figura 1	Figura 2
	
Figura 3	**Figura 4**
	
Figura 5	**Figura 6**
	

Design dello stelo

Versione 1, Stelo chiavetta	Versione 2, Estremità posteriore cilindrica/Weldon e anteriore 90°
	
Versione 3, Estremità posteriore cilindrica/Weldon, anteriore conica 87°/89°	**Versione 4, Estremità posteriore cilindrica/Weldon, anteriore conica 80°/85°/87°**
	
Versione 5, Estremità posteriore cilindrica doppia estremità anteriore conica 89°/85°	
	

MM06 Stelo – In mm

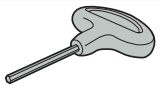




Codice di ordinazione	Codice prodotto	Tipo di attacco	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Disegno		RPMX	Peso	Codice ricambio
			mm	mm	mm	mm	mm					kg	
MM06-12070.3-0005	75080695	Weldon	5,75	12,0	70,0	5,0	25,0	0,0	2	✓	80000	0,1	1
MM06-16075.3-3009	75080696	Weldon	5,75	16,0	75,0	9,0	27,0	3,0	3	✓	80000	0,1	1
MM06-16110.3-5058	75080697	Weldon	5,75	16,0	110,0	58,6	62,0	5,0	4	✓	80000	0,1	4
MM06-10040.0-0007	00094747	Cilindrico	5,75	10,0	40,0	7,0	7,0	0,0	2	✓	80000	0,1	2
MM06-12065.0-0000	75080694	Cilindrico	5,7	12,0	65,0	0,0	15,0	60,0	1	✓	80000	0,1	1
MM06-16140.0-1020M	00027102	Cilindrico	5,75	16,0	140,0	20,0	92,0	1,0	3	✓	80000	0,2	5
MM06-16140.0-1035M	00027103	Cilindrico	5,75	16,0	140,0	35,0	92,0	1,0	3	✓	80000	0,2	6
MM06-16140.0-1050M	00094748	Cilindrico	5,75	16,0	140,0	50,0	92,0	1,0	3	✓	80000	0,2	6
MM06-10050.0-0007DS	02580666	Cilindrico	5,75	10,0	50,0	7,0	7,0	0,0	2	✓	80000	0,1	3
MM06-10075.0-3041DS	02580701	Cilindrico	5,75	10,0	75,0	40,5	35,0	3,0	4	✓	80000	0,1	3
MM06-10100.0-1035DS	02580713	Cilindrico	5,75	10,0	100,0	35,0	60,0	1,0	3	✓	80000	0,1	3
MM06-12120.0-1050DS	02580714	Cilindrico	5,75	12,0	120,0	50,0	75,0	1,0	3	✓	80000	0,2	3
MM06-16090.0-0012DS	02580670	Cilindrico	5,75	16,0	90,0	12,0	42,0	0,0	2	✓	80000	0,3	3
MM06-16095.0-0024DS	02580673	Cilindrico	5,75	16,0	95,0	24,0	47,0	0,0	2	✓	80000	0,3	3
MM06-16140.0-1050DS	02580717	Cilindrico	5,75	16,0	140,0	50,0	92,0	1,0	3	✓	80000	0,3	3
MM06-16140.0-1035DS	02580716	Cilindrico	5,75	16,0	140,0	35,0	92,0	1,0	3	✓	80000	0,4	3
MM06-20250.0-1035DS	02580718	Cilindrico	5,75	20,0	250,0	35,0	190,0	1,0	5	✓	80000	0,9	3

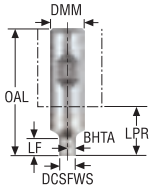
Parti di ricambio, comprese nella fornitura

Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
1	MM-035046	MM06-03518	H05-4
4	MM-035091	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4
3	–	MM06-03518	–

MM06 Stelo – pollici

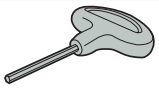




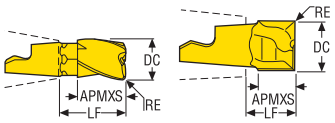
Codice di ordinazione	Codice prodotto	Tipo di attacco	DCSFMS	DMM	OAL	LF	LPR	BHTA°	Disegno		RPMX	Peso	Codice ricambio
			inch	inch	inch	inch	inch					lb	
MM06-0.50-2.8-3-0002	00096108	Weldon	0.224	0.500	2.756	0.197	0.984	0,0	2	✓	80000	0.220	1
MM06-0.62-3.0-3-3003	00096116	Weldon	0.224	0.625	2.953	0.354	1.063	3,0	1	✓	80000	0.220	1
MM06-0.62-4.3-3-5022	00096117	Weldon	0.224	0.625	4.331	2.291	2.441	5,0	2	✓	80000	0.440	4
MM06-0.38-1.6-0-0002	00096107	Cilindrico	0.224	0.375	1.575	0.276	0.276	0,0	2	✓	80000	0.220	2
MM06-0.50-2.6-0-0000	00096106	Cilindrico	0.224	0.500	2.559	0	0.787	60,0	1	✓	80000	0.220	1
MM06-0.62-5.5-0-1007	00096111	Cilindrico	0.224	0.625	5.512	0.787	3.622	1,0	3	✓	80000	0.440	5
MM06-0.62-5.5-0-1013	00096112	Cilindrico	0.224	0.625	5.512	1.378	3.622	1,0	3	✓	80000	0.440	6
MM06-0.62-5.5-0-1019	00096114	Cilindrico	0.224	0.625	5.512	1.969	3.622	1,0	3	✓	80000	0.440	6
MM06-0.62-3.5-0-0004DS	02593394	Cilindrico	0.224	0.625	3.543	0.472	1.654	0,0	2	✓	80000	0.660	3
MM06-0.62-3.7-0-0009DS	02593395	Cilindrico	0.224	0.625	3.740	0.945	1.850	0,0	2	✓	80000	0.660	3
MM06-0.62-5.5-0-1013DS	02593396	Cilindrico	0.224	0.625	5.512	1.378	3.622	1,0	3	✓	80000	0.880	3
MM06-0.62-5.5-0-1019DS	02593397	Cilindrico	0.224	0.625	5.512	1.969	3.622	1,0	3	✓	80000	0.660	3
MM06-0.75-10.0-0-1013DS	02593399	Cilindrico	0.224	0.750	9.843	1.378	7.874	1,0	5	✓	80000	1.980	3

Parti di ricambio, comprese nella fornitura

Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
1	MM-035046	MM06-03518	H05-4
4	MM-035091	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4
3	–	MM06-03518	–

Scanalatura/fresatura a spallamento retto



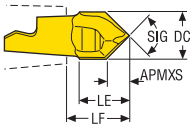


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*								T60M	F15M	F30M	F40M
MM06-05804T-R02-D02	5,8 *0.228*	4,1 *0.161*	0,2 *0.008*	5,1 *0.201*	15,0	7,2	11,0	0	2	MM0612		■			
MM06-05807-R02A30-M02	5,8 *0.228*	7,5 *0.295*	0,2 *0.008*	9,9 *0.390*	15,0	7,2	11,0	30	3	MM0612	✓				■
MM06-06004-M02	6,0 *0.236*	4,1 *0.161*	0,0 –	5,1 *0.201*	15,0	7,4	11,8	0	2	MM0612		■			
MM06-06004-R04-MD02	6,0 *0.236*	4,1 *0.161*	0,4 *0.016*	5,1 *0.201*	15,0	7,4	11,0	0	2	MM0612		■		■	
MM06-06004-R10-MD02	6,0 *0.236*	4,1 *0.161*	1,0 *0.039*	5,1 *0.201*	15,0	7,4	9,8	0	2	MM0612				■	
MM06-06007-A30-E02	6,0 *0.236*	7,5 *0.295*	0,0 –	9,9 *0.390*	15,0	7,4	11,8	30	3	MM0416	✓			■	
MM06-06007-R05A30-M02	6,0 *0.236*	7,5 *0.295*	0,5 *0.020*	9,9 *0.390*	15,0	7,4	10,8	30	3	MM0416	✓				■
MM06-06007-R10A30-D02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓			■	
MM06-06007-R10A30-E02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓			■	
MM06-06007-R10A30-M02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓				■
MM06-06007-R20A30-M02	6,0 *0.236*	7,5 *0.295*	2,0 *0.079*	9,9 *0.390*	15,0	7,4	7,8	30	3	MM0416	✓				■
MM06-06407-A30-E02	6,35 *0.250*	7,5 *0.295*	0,0 –	9,9 *0.390*	15,0	7,8	12,5	30	3	MM0416	✓			■	
MM06-06407-R04A30-M02	6,35 *0.250*	7,5 *0.295*	0,4 *0.016*	9,9 *0.390*	15,0	7,8	11,7	30	3	MM0416	✓				■
MM06-06407-R08A30-M02	6,35 *0.250*	7,5 *0.295*	0,8 *0.031*	9,9 *0.390*	15,0	7,8	10,9	30	3	MM0416	✓				■

Punta di centratura



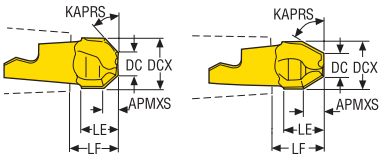


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	LE	LF	SIG°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM06-06003-C120-M02	6,0 *0.236*	1,6 *0.063*	6,27 *0.247*	7,19 *0.283*	120,0	2	MM0612	■			
MM06-06003-C90-M02	6,0 *0.236*	2,86 *0.113*	6,0 *0.236*	7,12 *0.280*	90,0	2	MM0612	■			

Smussatura

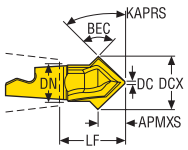




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM06-06004-4515-E02	6,0 *0.236*	1,8 *0.071*	2,1 *0.083*	4,0 *0.157*	5,1 *0.201*	45,0	2	MM0612	■			
MM06-06004-6015-E02	6,0 *0.236*	3,14 *0.124*	2,4 *0.094*	4,6 *0.181*	5,75 *0.226*	60,0	2	MM0612	■			

Doppia smussatura

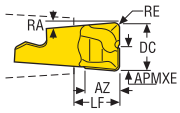




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DCX	DC	APMXS	LF	DN	BEC°	KAPRS°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM06-08008-D4510P-M02	8,0 *0.315*	0,6 *0.024*	3,7 *0.146*	8,5 *0.335*	6,0 *0.236*	90,0	45,0	2	MM0612		■		

Penetrazione assiale



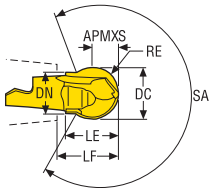


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM06-06004-R10-PL-MD02	6,0 *0.236*	3,0 *0.118*	1,0 *0.039*	4,3 *0.169*	5,08 *0.200*	5,0	2	MM0612			■	

Inserti di precisione per la semi-finitura in tutti i materiali



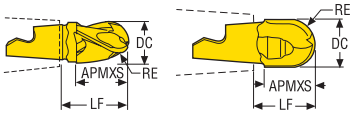


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LE	LF	DN	SA	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM06-08008-B120PF-M01	8,0 *0.315*	4,0 *0.157*	4,0 *0.157*	8,0 *0.315*	8,73 *0.344*	6,0 *0.236*	263,0	2	MM0612		■		
MM06-08008-B120P-M03	8,0 *0.315*	4,0 *0.157*	4,0 *0.157*	8,0 *0.315*	8,73 *0.344*	6,0 *0.236*	263,0	2	MM0612			■	

Copiatura





• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	FHA	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM06-06006-B90-MD02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*	0,0	2	MM0612		■		■	
MM06-06006-B90PF-M01	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*	0,0	2	MM0612			■		
MM06-06006-B90P-M02	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*	0,0	2	MM0612				■	
MM06-06006-B90S-E02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*	0,0	2	MM0612				■	
MM06-06007-B90A30-E02	6,0 *0.236*	7,4 *0.291*	3,0 *0.118*	9,85 *0.388*	30,0	3	MM0416	✓			■	
MM06-06007-B90A30-M02	6,0 *0.236*	7,4 *0.291*	3,0 *0.118*	9,85 *0.388*	30,0	3	MM0416	✓				■
MM06-06406-B90P-M02	6,35 *0.250*	5,4 *0.213*	3,175 *0.125*	7,22 *0.284*	0,0	2	MM0612				■	
MM06-06406-B90S-E02	6,35 *0.250*	6,3 *0.248*	3,175 *0.125*	7,24 *0.285*	0,0	2	MM0612				■	

MM06 - Scanalatura e contornatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
P2	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
P3	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,046 *0.0018*
P4	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
P5	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P6	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P7	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P8	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,046 *0.0018*
P11	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P12	MM06-06007-R05A30-M02 F40M	1,0 *0.040*	0,020 *0.00080*	0,020 *0.00080*	0,022 *0.00085*	0,030 *0.0012*
M1	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
M2	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
M3	MM06-06007-R05A30-M02 F40M	1,0 *0.040*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,036 *0.0014*
M4	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 *0.00085*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
M5	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 *0.00085*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
K1	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,038 *0.0015*	0,050 *0.0020*
K2	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K3	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K4	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K5	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
K6	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K7	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
N1	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
N2	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
N3	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
N11	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
S1	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,028 *0.0011*	0,026 *0.0010*	0,025 *0.0010*	0,032 *0.0013*
S2	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,028 *0.0011*	0,026 *0.0010*	0,025 *0.0010*	0,032 *0.0013*
S3	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,026 *0.0010*	0,025 *0.0010*	0,024 *0.00095*	0,028 *0.0012*
S11	MM06-06007-R05A30-M02 F40M	0,90 *0.036*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,036 *0.0014*
S12	MM06-06007-R05A30-M02 F40M	0,90 *0.036*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,036 *0.0014*
S13	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 *0.00085*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
H5	MM06-06007-R10A30-D02 F30M	1,0 *0.040*	0,025 *0.0010*	0,024 *0.00095*	0,024 *0.00095*	0,030 *0.0012*
H8	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 *0.00080*	0,019 *0.00075*	0,018 *0.00070*	0,024 *0.00095*
H11	MM06-06007-R10A30-D02 F30M	1,0 *0.040*	0,025 *0.0010*	0,024 *0.00095*	0,024 *0.00095*	0,030 *0.0012*
H12	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 *0.00080*	0,019 *0.00075*	0,018 *0.00070*	0,024 *0.00095*
H21	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 *0.00080*	0,019 *0.00075*	0,018 *0.00070*	0,024 *0.00095*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM06 - Scanalatura e contornatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	280 *920*	350 *1150*	395 *1300*	435 *1425*	270 *890*	335 *1100*	375 *1225*	415 *1350*	220 *720*	270 *890*	300 *980*	330 *1075*
P2	275 *900*	340 *1125*	380 *1250*	420 *1375*	260 *850*	325 *1075*	365 *1200*	400 *1300*	210 *690*	260 *850*	295 *970*	320 *1050*
P3	240 *790*	295 *970*	330 *1075*	365 *1200*	225 *740*	285 *940*	315 *1025*	350 *1150*	185 *610*	230 *750*	255 *840*	280 *920*
P4	210 *690*	260 *850*	295 *970*	320 *1050*	200 *660*	250 *820*	280 *920*	305 *1000*	160 *520*	200 *660*	225 *740*	245 *800*
P5	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	295 *970*	155 *510*	190 *620*	215 *710*	235 *770*
P6	225 *740*	285 *940*	315 *1025*	345 *1125*	215 *710*	270 *890*	300 *980*	330 *1075*	175 *570*	215 *710*	240 *790*	265 *870*
P7	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	255 *840*	285 *940*	310 *1025*	165 *540*	205 *670*	230 *750*	250 *820*
P8	200 *660*	250 *820*	280 *920*	305 *1000*	190 *620*	240 *790*	265 *870*	290 *950*	155 *510*	190 *620*	215 *710*	235 *770*
P11	210 *690*	260 *850*	290 *950*	320 *1050*	200 *660*	245 *800*	275 *900*	305 *1000*	160 *520*	200 *660*	220 *720*	245 *800*
P12	130 *425*	160 *520*	175 *570*	195 *640*	125 *410*	150 *490*	170 *560*	185 *610*	100 *330*	125 *410*	135 *445*	150 *490*
M1	— —	— —	— —	— —	210 *690*	265 *870*	295 *970*	320 *1050*	170 *560*	210 *690*	235 *770*	260 *850*
M2	— —	— —	— —	— —	175 *570*	215 *710*	240 *790*	265 *870*	140 *460*	170 *560*	195 *640*	210 *690*
M3	— —	— —	— —	— —	135 *445*	165 *540*	190 *620*	205 *670*	110 *360*	135 *445*	150 *490*	165 *540*
M4	— —	— —	— —	— —	105 *345*	130 *425*	145 *475*	155 *510*	85 *280*	105 *345*	115 *375*	125 *410*
M5	— —	— —	— —	— —	85 *280*	105 *345*	120 *395*	130 *425*	70 *230*	85 *280*	95 *310*	105 *345*
K1	215 *710*	270 *890*	305 *1000*	335 *1100*	205 *670*	260 *850*	290 *950*	315 *1025*	165 *540*	210 *690*	230 *750*	255 *840*
K2	190 *620*	235 *770*	265 *870*	295 *970*	180 *590*	225 *740*	255 *840*	280 *920*	150 *490*	180 *590*	205 *670*	225 *740*
K3	160 *520*	200 *660*	225 *740*	250 *820*	155 *510*	190 *620*	215 *710*	235 *770*	125 *410*	155 *510*	175 *570*	190 *620*
K4	155 *510*	190 *620*	215 *710*	235 *770*	145 *475*	180 *590*	205 *670*	225 *740*	120 *395*	145 *475*	165 *540*	180 *590*
K5	95 *310*	115 *375*	130 *425*	145 *475*	90 *295*	110 *360*	125 *410*	135 *445*	70 *230*	90 *295*	100 *330*	110 *360*
K6	135 *445*	170 *560*	190 *620*	210 *690*	130 *425*	160 *520*	180 *590*	200 *660*	105 *345*	130 *425*	145 *475*	160 *520*
K7	120 *395*	150 *490*	165 *540*	180 *590*	115 *375*	140 *460*	160 *520*	175 *570*	90 *295*	115 *375*	125 *410*	140 *460*
N1	1650 *5425*	2050 *6725*	2325 *7625*	2525 *8275*	1575 *5175*	1975 *6475*	2200 *7225*	2400 *7875*	1275 *4175*	1575 *5175*	1775 *5825*	1950 *6400*
N2	670 *2200*	830 *2725*	930 *3050*	1025 *3375*	640 *2100*	790 *2600*	890 *2925*	970 *3175*	510 *1675*	640 *2100*	710 *2325*	790 *2600*
N3	445 *1450*	560 *1825*	620 *2025*	680 *2225*	425 *1400*	530 *1750*	590 *1925*	650 *2125*	340 *1125*	425 *1400*	475 *1550*	530 *1750*
N11	510 *1675*	630 *2075*	710 *2325*	780 *2550*	485 *1600*	600 *1975*	680 *2225*	740 *2425*	390 *1275*	485 *1600*	540 *1775*	600 *1975*
S1	50 *165*	65 *215*	70 *230*	75 *245*	49 *160*	60 *195*	65 *215*	75 *245*	39 *130*	49 *160*	55 *180*	60 *195*
S2	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	32 *105*	39 *130*	44 *145*	48 *155*
S3	36 *120*	44 *145*	49 *160*	55 *180*	34 *110*	42 *140*	47 *155*	50 *165*	27 *90*	34 *110*	38 *125*	41 *135*
S11	— —	— —	— —	— —	70 *230*	85 *280*	95 *310*	105 *345*	55 *180*	70 *230*	75 *245*	85 *280*
S12	— —	— —	— —	— —	48 *155*	60 *195*	65 *215*	70 *245*	38 *125*	48 *155*	55 *180*	60 *195*
S13	— —	— —	— —	— —	27 *90*	34 *110*	38 *125*	41 *135*	22 *70*	27 *90*	30 *100*	33 *110*
H5	43 *140*	55 *180*	60 *195*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	33 *110*	41 *135*	45 *150*	50 *165*
H8	44 *145*	55 *180*	60 *195*	65 *215*	42 *140*	50 *165*	60 *195*	65 *215*	34 *110*	42 *140*	47 *155*	50 *165*
H11	55 *180*	65 *215*	75 *245*	85 *280*	50 *165*	65 *215*	70 *230*	80 *260*	42 *140*	50 *165*	60 *195*	65 *215*
H12	80 *260*	95 *310*	110 *360*	120 *395*	75 *245*	90 *295*	105 *345*	115 *375*	60 *195*	75 *245*	85 *280*	90 *295*
H21	44 *145*	55 *180*	60 *195*	65 *215*	42 *140*	50 *165*	60 *195*	65 *215*	34 *110*	42 *140*	47 *155*	50 *165*

MM06 Z3-Copiatura – Selezione dell'inserto – Sgrossatura – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P2	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P3	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,046 *0.0018*
P4	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P5	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P6	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P7	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P8	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,046 *0.0018*
P11	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P12	MM06-06007-B90A30-M02 F40M	1,0 *0.040*	0,024 *0.00095*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0012*
M1	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
M2	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
M3	MM06-06007-B90A30-M02 F40M	1,0 *0.040*	0,028 *0.0011*	0,026 *0.0010*	0,028 *0.0011*	0,036 *0.0014*
M4	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
M5	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
K1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
K2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K5	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
K6	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K7	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
N1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
S1	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
S2	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
S3	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,024 *0.00095*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0012*
S11	MM06-06007-B90A30-M02 F40M	0,90 *0.036*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,036 *0.0014*
S12	MM06-06007-B90A30-M02 F40M	0,90 *0.036*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,036 *0.0014*
S13	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
H5	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,024 *0.00095*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0012*
H8	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 *0.00070*	0,018 *0.00070*	0,018 *0.00070*	0,022 *0.00095*
H11	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,024 *0.00095*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0012*
H12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 *0.00070*	0,018 *0.00070*	0,018 *0.00070*	0,022 *0.00095*
H21	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 *0.00070*	0,018 *0.00070*	0,018 *0.00070*	0,022 *0.00095*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM06 Z3-Copiatura – Selezione dell'inserto – Finitura – In mm/ *In pollici*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P5	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P6	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P7	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P8	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P12	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
M1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
M2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
M3	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,080 *0.0032*
M4	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
M5	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
K1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
K2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K5	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,090 *0.0036*
K6	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K7	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,090 *0.0036*
N1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
S1	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S2	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S3	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,025 *0.0010*	0,028 *0.0012*	0,040 *0.0016*	0,065 *0.0026*
S11	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,080 *0.0032*
S12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,080 *0.0032*
S13	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
H5	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H8	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H11	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H21	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM06 Z3-Copiatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	295 *970*	350 *1150*	370 *1225*	405 *1325*	400 *1300*	280 *920*	330 *1075*	355 *1175*	385 *1275*	380 *1250*
P2	285 *940*	340 *1125*	360 *1175*	395 *1300*	390 *1275*	275 *900*	325 *1075*	345 *1125*	375 *1225*	370 *1225*
P3	250 *820*	295 *970*	315 *1025*	340 *1125*	340 *1125*	235 *770*	280 *920*	300 *980*	320 *1050*	325 *1075*
P4	220 *720*	260 *850*	275 *900*	300 *980*	300 *980*	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*
P5	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	275 *900*	270 *890*
P6	235 *770*	275 *900*	295 *970*	320 *1050*	320 *1050*	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*
P7	225 *740*	260 *850*	280 *920*	305 *1000*	300 *980*	210 *690*	250 *820*	265 *870*	290 *950*	285 *940*
P8	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P11	215 *710*	255 *840*	270 *890*	295 *970*	295 *970*	205 *670*	240 *790*	260 *850*	280 *920*	280 *920*
P12	135 *445*	160 *520*	165 *560*	180 *590*	180 *590*	125 *410*	150 *490*	160 *520*	170 *560*	170 *560*
M1	230 *750*	275 *900*	290 *950*	315 *1025*	315 *1025*	220 *720*	260 *850*	280 *920*	300 *980*	300 *980*
M2	190 *620*	220 *720*	240 *790*	260 *850*	255 *840*	180 *590*	210 *690*	225 *740*	245 *800*	245 *800*
M3	150 *490*	180 *590*	185 *610*	200 *660*	200 *660*	140 *460*	170 *560*	175 *590*	190 *620*	190 *620*
M4	105 *345*	145 *475*	140 *490*	150 *490*	150 *490*	100 *330*	135 *445*	135 *460*	145 *475*	145 *475*
M5	85 *280*	120 *395*	115 *410*	125 *410*	125 *410*	85 *280*	115 *375*	110 *395*	120 *395*	120 *395*
K1	230 *750*	270 *890*	285 *940*	310 *1025*	310 *1025*	215 *710*	255 *840*	275 *900*	295 *970*	295 *970*
K2	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
K3	170 *560*	200 *660*	210 *690*	230 *750*	230 *750*	160 *520*	190 *620*	200 *660*	220 *720*	220 *720*
K4	160 *520*	190 *620*	205 *670*	220 *720*	220 *720*	155 *510*	180 *590*	195 *640*	210 *690*	210 *690*
K5	95 *310*	115 *375*	120 *395*	130 *425*	130 *425*	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*
K6	140 *460*	165 *540*	180 *590*	195 *640*	190 *620*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
K7	125 *410*	145 *475*	155 *510*	170 *560*	170 *560*	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*
N1	1750 *5750*	2075 *6800*	2200 *7225*	2375 *7800*	2375 *7800*	1675 *5500*	1975 *6475*	2100 *6900*	2275 *7475*	2250 *7375*
N2	710 *2325*	830 *2725*	890 *2925*	960 *3150*	950 *3125*	670 *2200*	790 *2600*	850 *2800*	920 *3025*	910 *2975*
N3	470 *1550*	560 *1825*	590 *1925*	640 *2100*	640 *2100*	450 *1475*	530 *1750*	570 *1875*	610 *2000*	610 *2000*
N11	540 *1775*	630 *2075*	680 *2225*	730 *2400*	730 *2400*	510 *1675*	600 *1975*	650 *2125*	700 *2300*	690 *2275*
S1	49 *160*	65 *215*	65 *230*	70 *230*	70 *230*	46 *150*	65 *215*	65 *215*	70 *230*	65 *215*
S2	39 *130*	55 *180*	55 *180*	55 *180*	55 *180*	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*
S3	34 *110*	47 *155*	46 *155*	50 *165*	49 *160*	32 *105*	44 *145*	44 *150*	47 *155*	47 *155*
S11	75 *245*	95 *310*	95 *310*	100 *330*	100 *330*	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*
S12	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*
S13	27 *90*	38 *125*	37 *130*	40 *130*	40 *130*	26 *85*	36 *120*	35 *120*	38 *125*	38 *125*
H5	44 *145*	55 *180*	55 *180*	60 *195*	60 *195*	42 *140*	50 *165*	55 *180*	55 *180*	55 *180*
H8	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*
H11	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	55 *180*	65 *215*	65 *230*	70 *230*	75 *245*
H12	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*
H21	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*

MM06 Z2-Copiatura – Selezione dell'inserto – Sgrossatura – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,030 *0.0012*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
P4	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*
P5	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
P6	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P7	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P8	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
P11	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P12	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 *0.00080*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
M1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
M2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
M3	MM06-06006-B90S-E02 F30M	2,0 *0.080*	0,024 *0.00095*	0,024 *0.00095*	0,028 *0.0011*	0,036 *0.0014*
M4	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
M5	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
K1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
K2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K4	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K5	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,026 *0.0010*	0,026 *0.0010*	0,030 *0.0012*	0,040 *0.0016*
K6	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K7	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,026 *0.0010*	0,026 *0.0010*	0,030 *0.0012*	0,040 *0.0016*
N1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N11	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
S1	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
S2	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
S3	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,020 *0.00080*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0012*
S11	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,025 *0.0010*	0,024 *0.00095*	0,028 *0.0011*	0,036 *0.0014*
S12	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,025 *0.0010*	0,024 *0.00095*	0,028 *0.0011*	0,036 *0.0014*
S13	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
H5	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 *0.00080*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
H8	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 *0.00065*	0,016 *0.00065*	0,018 *0.00070*	0,022 *0.00095*
H11	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 *0.00080*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
H12	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 *0.00065*	0,016 *0.00065*	0,018 *0.00070*	0,022 *0.00095*
H21	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 *0.00065*	0,016 *0.00065*	0,018 *0.00070*	0,022 *0.00095*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM06 Z2-Copiatura – Selezione dell'inserto – Finitura – In mm/ *In pollici*

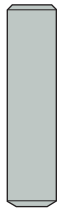
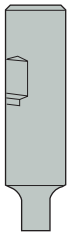
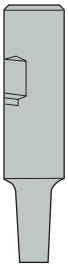
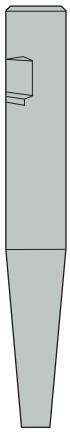
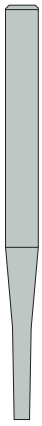
SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
P2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
P3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
P4	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,032 *0.0013*	0,050 *0.0020*
P5	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P6	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P7	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P8	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
P11	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P12	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
M1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
M2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
M3	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,015 *0.00060*	0,018 *0.00070*	0,025 *0.0010*	0,038 *0.0015*
M4	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
M5	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
K1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
K2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K4	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K5	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
K6	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K7	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
N1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
N2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
N3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
N11	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
S1	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S2	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S3	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,013 *0.00050*	0,014 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
S11	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,015 *0.00060*	0,018 *0.00070*	0,025 *0.0010*	0,038 *0.0015*
S12	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,015 *0.00060*	0,018 *0.00070*	0,025 *0.0010*	0,038 *0.0015*
S13	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
H5	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H8	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 *0.00040*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H11	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H12	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 *0.00040*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H21	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 *0.00040*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM06 Z2-Copiatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

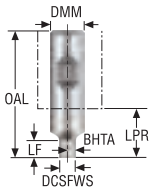
SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	325 *1075*	415 *1350*	430 *1400*	470 *1550*	465 *1525*	275 *900*	345 *1125*	375 *1225*	405 *1325*	405 *1325*	225 *740*	280 *920*	305 *1000*	330 *1075*	325 *1075*
P2	320 *1050*	400 *1300*	420 *1375*	455 *1500*	455 *1500*	265 *870*	335 *1100*	365 *1200*	395 *1300*	395 *1300*	215 *710*	270 *890*	295 *970*	320 *1050*	320 *1050*
P3	275 *900*	345 *1125*	360 *1175*	395 *1300*	395 *1300*	230 *750*	290 *950*	315 *1025*	340 *1125*	340 *1125*	190 *620*	235 *770*	255 *840*	275 *900*	275 *900*
P4	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	205 *670*	255 *840*	280 *920*	305 *1000*	300 *980*	165 *540*	205 *670*	225 *740*	245 *800*	245 *800*
P5	230 *750*	290 *950*	305 *1000*	330 *1075*	330 *1075*	195 *640*	245 *800*	265 *870*	290 *950*	290 *950*	160 *520*	200 *660*	215 *710*	235 *770*	235 *770*
P6	260 *850*	330 *1075*	345 *1125*	370 *1225*	370 *1225*	220 *720*	275 *900*	300 *980*	325 *1075*	325 *1075*	180 *590*	225 *740*	245 *800*	265 *870*	260 *850*
P7	245 *800*	310 *1025*	325 *1075*	350 *1150*	350 *1150*	210 *690*	260 *850*	285 *940*	305 *1000*	305 *1000*	170 *560*	210 *690*	230 *750*	250 *820*	245 *800*
P8	230 *750*	290 *950*	305 *1000*	330 *1075*	330 *1075*	195 *640*	245 *800*	265 *870*	285 *940*	290 *950*	160 *520*	200 *660*	215 *710*	230 *750*	235 *770*
P11	240 *790*	300 *980*	315 *1025*	340 *1125*	340 *1125*	200 *660*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*
P12	145 *475*	185 *610*	190 *620*	205 *670*	205 *670*	130 *425*	160 *520*	170 *560*	180 *590*	180 *590*	105 *345*	130 *425*	135 *445*	145 *475*	145 *475*
M1	255 *840*	325 *1075*	340 *1125*	365 *1200*	365 *1200*	215 *710*	270 *890*	295 *970*	320 *1050*	315 *1025*	175 *570*	220 *720*	240 *790*	260 *850*	255 *840*
M2	210 *690*	265 *870*	275 *900*	300 *980*	300 *980*	175 *570*	220 *720*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
M3	165 *540*	210 *690*	210 *710*	230 *750*	230 *750*	140 *460*	180 *590*	185 *620*	205 *670*	200 *660*	115 *375*	145 *475*	150 *510*	165 *540*	165 *540*
M4	125 *410*	160 *520*	160 *560*	170 *560*	170 *560*	110 *360*	140 *460*	140 *490*	155 *510*	155 *510*	90 *295*	115 *375*	115 *395*	125 *410*	125 *410*
M5	105 *345*	135 *445*	130 *475*	145 *475*	145 *475*	95 *310*	120 *395*	120 *410*	130 *425*	130 *425*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*
K1	250 *820*	320 *1050*	335 *1100*	360 *1175*	360 *1175*	210 *690*	265 *870*	290 *950*	315 *1025*	310 *1025*	170 *560*	215 *710*	235 *770*	255 *840*	250 *820*
K2	220 *720*	275 *900*	290 *950*	315 *1025*	315 *1025*	185 *610*	230 *750*	255 *840*	275 *900*	275 *900*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
K3	185 *610*	235 *770*	245 *800*	265 *870*	265 *870*	160 *520*	195 *640*	215 *710*	230 *750*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	185 *610*
K4	175 *570*	225 *740*	235 *770*	255 *840*	255 *840*	150 *490*	185 *610*	205 *670*	220 *720*	220 *720*	120 *395*	150 *490*	165 *540*	180 *590*	180 *590*
K5	105 *345*	135 *445*	140 *460*	150 *490*	150 *490*	90 *295*	115 *375*	125 *410*	135 *445*	135 *445*	75 *245*	90 *295*	100 *330*	110 *360*	105 *345*
K6	155 *510*	195 *640*	205 *670*	225 *740*	225 *740*	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*	105 *345*	135 *445*	145 *475*	160 *520*	155 *510*
K7	135 *445*	170 *560*	180 *590*	195 *640*	195 *640*	115 *375*	145 *475*	155 *510*	170 *560*	170 *560*	95 *310*	115 *375*	125 *410*	140 *460*	140 *460*
N1	1975 *6475*	2475 *8125*	2600 *8525*	2800 *9175*	2800 *9175*	1625 *5325*	2050 *6725*	2225 *7300*	2400 *7875*	2375 *7800*	1325 *4350*	1650 *5425*	1800 *5900*	1950 *6400*	1925 *6325*
N2	790 *2600*	1000 *3275*	1050 *3450*	1125 *3700*	1125 *3700*	660 *2175*	820 *2700*	900 *2950*	970 *3175*	960 *3150*	530 *1750*	670 *2200*	730 *2400*	790 *2600*	780 *2550*
N3	530 *1750*	670 *2200*	700 *2300*	760 *2500*	750 *2450*	440 *1450*	550 *1800*	600 *1975*	650 *2125*	640 *2100*	355 *1175*	445 *1450*	485 *1600*	520 *1700*	520 *1700*
N11	600 *1975*	760 *2500*	800 *2625*	860 *2825*	860 *2825*	500 *1650*	630 *2075*	680 *2225*	740 *2425*	730 *2400*	405 *1325*	510 *1675*	550 *1800*	600 *1975*	590 *1925*
S1	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*	50 *165*	65 *215*	65 *230*	70 *230*	70 *230*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*
S2	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	43 *140*	43 *150*	47 *155*	47 *155*
S3	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*	36 *120*	46 *150*	46 *160*	50 *165*	50 *165*	29 *95*	37 *120*	38 *130*	40 *130*	40 *130*
S11	85 *280*	105 *345*	105 *360*	115 *375*	115 *375*	75 *245*	95 *310*	95 *310*	105 *345*	100 *330*	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*
S12	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	41 *135*	55 *180*	55 *180*	55 *180*	55 *180*
S13	33 *110*	42 *140*	42 *150*	45 *150*	45 *150*	29 *95*	37 *120*	37 *130*	40 *130*	40 *130*	24 *80*	30 *100*	30 *105*	33 *110*	33 *110*
H5	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	43 *140*	45 *150*	49 *160*	49 *160*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	46 *155*	50 *165*	50 *165*
H11	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	65 *215*	80 *260*	85 *280*	90 *295*	90 *295*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	46 *155*	50 *165*	50 *165*

Design dello stelo

Versione 1, Stelo chiavetta	Versione 2, Estremità posteriore cilindrica/Weldon e anteriore 90°
	
Versione 3, Estremità posteriore cilindrica/Weldon, anteriore conica 87°/89°	**Design 4, Estremità posteriore cilindrica/Weldon, anteriore conica 80°/85°/87°**
	
Versione 5, Estremità posteriore cilindrica doppia estremità anteriore conica 89°/85°	
	

MM08 Stelo

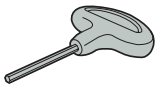




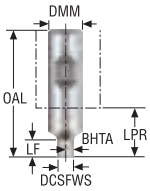
Codice di ordinazione	Codice prodotto	Tipo di attacco	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Disegno		RPMX	Peso	Codice ricambio
			mm	mm	mm	mm	mm					kg	
MM08-16070.3-0007	75034241	Weldon	7,6	16,0	70,0	7,6	22,0	0,0	2	✓	80000	0,1	1
MM08-16075.3-3012	75034242	Weldon	7,6	16,0	75,0	12,0	27,0	3,0	3	✓	80000	0,1	1
MM08-16120.3-5048M	00042863	Weldon	7,6	16,0	120,0	48,0	72,0	5,0	4	✓	80000	0,2	5
MM08-10040.0-0007	00083980	Cilindrico	7,6	10,0	40,0	7,0	7,0	0,0	2	✓	80000	0,1	2
MM08-12065.0-0000	75034240	Cilindrico	7,6	12,0	65,0	0,0	20,0	60,0	1	✓	80000	0,1	1
MM08-16150.0-1030M	00094751	Cilindrico	7,6	16,0	150,0	30,0	102,0	1,0	3	✓	80000	0,2	5
MM08-16150.0-1050M	00094752	Cilindrico	7,6	16,0	150,0	50,0	102,0	1,0	3	✓	80000	0,2	4
MM08-16150.0-1070M	00094754	Cilindrico	7,6	16,0	150,0	70,0	102,0	1,0	3	✓	80000	0,2	4
MM08-10050.0-0007DS	02580665	Cilindrico	7,6	10,0	50,0	7,0	10,0	0,0	2	✓	80000	0,1	3
MM08-10080.0-3023DS	02580702	Cilindrico	7,6	10,0	80,0	22,9	40,0	3,0	4	✓	80000	0,1	3
MM08-12100.0-1035DS	02580719	Cilindrico	7,6	12,0	100,0	35,0	55,0	1,0	3	✓	80000	0,2	3
MM08-12120.0-1050DS	02580720	Cilindrico	7,6	12,0	120,0	50,0	75,0	1,0	3	✓	80000	0,2	3
MM08-16085.0-0016DS	02580675	Cilindrico	7,6	16,0	85,0	16,0	37,0	0,0	2	✓	80000	0,3	3
MM08-16100.0-0032DS	02580687	Cilindrico	7,6	16,0	100,0	32,0	52,0	0,0	2	✓	80000	0,3	3
MM08-16150.0-1050DS	02580722	Cilindrico	7,6	16,0	150,0	50,0	102,0	1,0	3	✓	80000	0,4	3
MM08-16150.0-1070DS	02580727	Cilindrico	7,6	16,0	150,0	70,0	102,0	1,0	3	✓	80000	0,3	3

Parti di ricambio, comprese nella fornitura

Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
1	MM-05044	MM08-0524	H05-4
5	MM-05044	MM08-0543	H05-4
2	MM-05019	MM08-0524	H05-4
4	MM-05044	MM08-0582	H05-4
3	–	MM08-0524	–

MM08 Stelo – pollici





Codice di ordinazione	Codice prodotto	Tipo di attacco	DCSFMS	DMM	OAL	LF	LPR	BHTA°	Disegno		RPMX	Peso	Codice ricambio
			inch	inch	inch	inch	inch					lb	
MM08-0.62-2.8-3-0003	75054600	Weldon	0.299	0.625	2.756	0.299	0.866	0,0	2	✓	80000	0.220	1
MM08-0.62-3.0-3-3004	75054601	Weldon	0.299	0.625	2.953	0.472	1.063	3,0	3	✓	80000	0.220	1
MM08-0.62-4.7-3-5018	75054602	Weldon	0.299	0.625	4.724	1.850	2.835	5,0	4	✓	80000	0.440	2
MM08-0.38-1.6-0-0002	00096119	Cilindrico	0.299	0.375	1.575	0.276	0.276	0,0	2	✓	80000	0.220	3
MM08-0.50-2.6-0-0000	75054599	Cilindrico	0.299	0.500	2.559	0	0.787	60,0	1	✓	80000	0.220	1
MM08-0.62-5.9-0-1011	75054604	Cilindrico	0.299	0.625	5.906	1.181	4.016	1,0	3	✓	80000	0.440	2
MM08-0.62-3.3-0-0006DS	02593402	Cilindrico	0.299	0.625	3.346	0.630	1.457	0,0	2	✓	80000	0.660	4
MM08-0.62-4.0-0-0012DS	02593403	Cilindrico	0.299	0.625	3.937	1.260	2.047	0,0	2	✓	80000	0.660	4
MM08-0.62-5.9-0-1019DS	02593407	Cilindrico	0.299	0.625	5.906	1.969	4.016	1,0	3	✓	80000	0.880	4
MM08-0.62-5.9-0-1027DS	02593410	Cilindrico	0.299	0.625	5.906	2.756	4.016	1,0	3	✓	80000	0.660	4
MM08-0.75-10.0-0-1019DS	02593413	Cilindrico	0.299	0.750	9.843	1.969	7.874	1,0	5	✓	80000	1.980	4

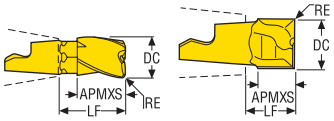
Parti di ricambio, comprese nella fornitura

Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
1	MM-05044	MM08-0524	H05-4
2	MM-05044	MM08-0543	H05-4
3	MM-05019	MM08-0524	H05-4
4	–	MM08-0524	–

Scanalatura/fresatura a spallamento retto

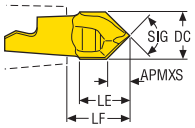




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*								T60M	F15M	F30M	F40M
MM08-07805T-R02-D03	7,8 *0.307*	5,4 *0.213*	0,2 *0.008*	6,8 *0.268*	15,0	9,6	15,0	0	2	MM0612		■			
MM08-07809-R02A30-M03	7,8 *0.307*	10,0 *0.394*	0,2 *0.008*	13,0 *0.512*	15,0	9,6	15,0	30	3	MM0416	✓				■
MM08-08005-M03	8,0 *0.315*	5,5 *0.217*	0,0 –	6,8 *0.268*	15,0	9,8	15,8	0	2	MM0612		■			
MM08-08005-R04A8-E03	8,0 *0.315*	5,4 *0.213*	0,4 *0.016*	6,7 *0.264*	15,0	9,8	15,0	8	2	MM0612		■		■	
MM08-08005-R04-MD03	8,0 *0.315*	5,5 *0.217*	0,4 *0.016*	6,8 *0.268*	15,0	9,8	15,0	0	2	MM0612		■		■	
MM08-08005-R04P-M02	8,0 *0.315*	5,4 *0.213*	0,4 *0.016*	6,7 *0.264*	15,0	9,8	15,0	0	2	MM0612				■	
MM08-08005-R10-MD03	8,0 *0.315*	5,4 *0.213*	1,0 *0.039*	6,8 *0.268*	15,0	9,8	13,8	0	2	MM0612				■	
MM08-08009-A30-E03	8,0 *0.315*	10,0 *0.394*	0,0 –	13,0 *0.512*	15,0	9,8	15,0	30	3	MM0416	✓			■	
MM08-08009-R05A30-M03	8,0 *0.315*	10,0 *0.394*	0,5 *0.020*	13,0 *0.512*	15,0	9,8	14,8	30	3	MM0416	✓				■
MM08-08009-R10A30-D03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓			■	
MM08-08009-R10A30-E03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓			■	
MM08-08009-R10A30-M03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓				■
MM08-08009-R20A30-M03	8,0 *0.315*	10,0 *0.394*	2,0 *0.079*	13,0 *0.512*	15,0	9,8	11,8	30	3	MM0416	✓				■
MM08-08009-R30A30-M03	8,0 *0.315*	10,0 *0.394*	3,0 *0.118*	13,0 *0.512*	15,0	9,8	9,8	30	3	MM0416	✓				■

Punta di centratura

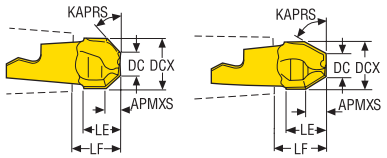




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	LE	LF	SIG°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM08-08004-C90-M03	8,0 *0.315*	3,79 *0.149*	8,0 *0.315*	9,5 *0.374*	90,0	2	MM0612	■			
MM08-08006-C120-M03	8,0 *0.315*	2,15 *0.085*	8,32 *0.328*	9,46 *0.372*	120,0	2	MM0612	■			

Smussatura



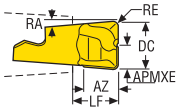


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM08-08005-4520-E03	8,0 *0.315*	3,87 *0.152*	2,1 *0.083*	5,5 *0.217*	6,7 *0.264*	45,0	2	MM0612	■			
MM08-08006-6030-E03	8,0 *0.315*	4,19 *0.165*	3,3 *0.130*	6,45 *0.254*	7,66 *0.302*	60,0	2	MM0612	■			

Penetrazione assiale



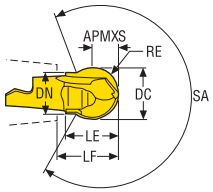


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM08-08005-R10-PL-MD03	8,0 *0.315*	4,0 *0.157*	1,0 *0.039*	5,7 *0.224*	6,78 *0.267*	5,0	2	MM0612			■	

Inserti di precisione per la semi-finitura in tutti i materiali

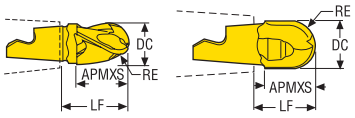




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LE	LF	DN	SA	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM08-10010-B120PF-M02	10,0 *0.394*	5,0 *0.197*	5,0 *0.197*	10,0 *0.394*	10,97 *0.432*	8,0 *0.315*	254,0	2	MM0612		■		
MM08-10010-B120P-M04	10,0 *0.394*	5,0 *0.197*	5,0 *0.197*	10,0 *0.394*	10,97 *0.432*	8,0 *0.315*	254,0	2	MM0612			■	

Copiatura

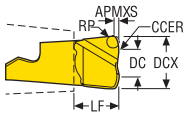




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	FHA	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM08-08008-B90-MD03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*	0,0	2	MM0612		■		■	
MM08-08008-B90PF-M01	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*	0,0	2	MM0612			■		
MM08-08008-B90P-M03	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*	0,0	2	MM0612				■	
MM08-08008-B90S-E03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*	0,0	2	MM0612				■	
MM08-08009-B90A30-E03	8,0 *0.315*	10,0 *0.394*	4,0 *0.157*	13,0 *0.512*	30,0	3	MM0416	✓			■	
MM08-08009-B90A30-M03	8,0 *0.315*	10,0 *0.394*	4,0 *0.157*	13,0 *0.512*	30,0	3	MM0416	✓				■

Elevato avanzamento





• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							T60M	F15M	F30M	F40M
MM08-08.40-HF-MD06	8,0 *0.315*	4,0 *0.157*	0,37 *0.015*	0,88 *0.035*	4,0 *0.157*	6,84 *0.269*	5,0	9,8	14,6	2	MM0612				■	

MM08 - Scanalatura e contornatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
P2	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*
P3	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P4	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P5	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P6	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P7	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P8	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P11	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P12	MM08-08009-R05A30-M03 F40M	1,4 *0.055*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
M1	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*
M2	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
M3	MM08-08009-R05A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
M4	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
M5	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
K1	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,050 *0.0020*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
K2	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K3	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K4	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K5	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
K6	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K7	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N1	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S2	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S3	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,036 *0.0014*	0,034 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM08-08009-R05A30-M03 F40M	1,2 *0.048*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
S12	MM08-08009-R05A30-M03 F40M	1,2 *0.048*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
S13	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
H5	MM08-08009-R10A30-E03 F30M	1,4 *0.055*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H8	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 *0.0010*	0,025 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H11	MM08-08009-R10A30-E03 F30M	1,4 *0.055*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H12	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 *0.0010*	0,025 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H21	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 *0.0010*	0,025 *0.0010*	0,026 *0.0010*	0,034 *0.0013*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM08 - Scanalatura e contornatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	265 *870*	330 *1075*	370 *1225*	410 *1350*	255 *840*	315 *1025*	350 *1150*	385 *1275*	205 *670*	250 *820*	280 *920*	310 *1025*
P2	255 *840*	320 *1050*	360 *1175*	390 *1275*	245 *800*	305 *1000*	340 *1125*	375 *1225*	195 *640*	245 *800*	275 *900*	300 *980*
P3	225 *740*	280 *920*	315 *1025*	340 *1125*	215 *710*	265 *870*	295 *970*	325 *1075*	170 *560*	210 *690*	240 *790*	260 *850*
P4	195 *640*	245 *800*	275 *900*	300 *980*	190 *620*	235 *770*	260 *850*	290 *950*	150 *490*	185 *610*	210 *690*	230 *750*
P5	190 *620*	235 *770*	265 *870*	290 *950*	180 *590*	225 *740*	250 *820*	275 *900*	145 *475*	180 *590*	200 *660*	220 *720*
P6	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	255 *840*	280 *920*	310 *1025*	160 *520*	200 *660*	225 *740*	250 *820*
P7	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	290 *950*	155 *510*	190 *620*	215 *710*	235 *770*
P8	190 *620*	235 *770*	265 *870*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	145 *475*	180 *590*	200 *660*	220 *720*
P11	195 *640*	245 *800*	270 *890*	300 *980*	185 *610*	230 *750*	260 *850*	285 *940*	150 *490*	185 *610*	210 *690*	230 *750*
P12	120 *395*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	95 *310*	115 *375*	130 *425*	145 *475*
M1	— —	— —	— —	— —	200 *660*	245 *800*	275 *900*	305 *1000*	160 *520*	195 *640*	220 *720*	240 *790*
M2	— —	— —	— —	— —	165 *540*	200 *660*	225 *740*	250 *820*	130 *425*	160 *520*	180 *590*	200 *660*
M3	— —	— —	— —	— —	130 *425*	160 *520*	175 *570*	195 *640*	105 *345*	130 *425*	145 *475*	155 *510*
M4	— —	— —	— —	— —	100 *330*	120 *395*	135 *445*	150 *490*	80 *260*	100 *330*	110 *360*	120 *395*
M5	— —	— —	— —	— —	80 *260*	100 *330*	115 *375*	125 *410*	65 *215*	85 *280*	90 *295*	100 *330*
K1	205 *670*	255 *840*	285 *940*	310 *1025*	195 *640*	240 *790*	270 *890*	300 *980*	155 *510*	195 *640*	215 *710*	235 *770*
K2	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	135 *445*	170 *560*	190 *620*	210 *690*
K3	155 *510*	190 *620*	210 *690*	235 *770*	145 *475*	180 *590*	200 *660*	220 *720*	115 *375*	145 *475*	160 *520*	180 *590*
K4	145 *475*	180 *590*	200 *660*	225 *740*	140 *460*	170 *560*	190 *620*	210 *690*	110 *360*	140 *460*	155 *510*	170 *560*
K5	90 *295*	110 *360*	120 *395*	135 *445*	85 *280*	105 *345*	115 *375*	125 *410*	65 *215*	85 *280*	95 *310*	100 *330*
K6	130 *425*	160 *520*	180 *590*	195 *640*	120 *395*	150 *490*	170 *560*	185 *610*	95 *310*	120 *395*	135 *445*	150 *490*
K7	115 *375*	140 *460*	155 *510*	170 *560*	110 *360*	135 *445*	150 *490*	165 *540*	85 *280*	105 *345*	120 *395*	130 *425*
N1	1550 *5075*	1950 *6400*	2150 *7050*	2350 *7700*	1475 *4850*	1850 *6075*	2025 *6650*	2250 *7375*	1175 *3850*	1475 *4850*	1625 *5325*	1800 *5900*
N2	630 *2075*	780 *2550*	870 *2850*	950 *3125*	600 *1975*	750 *2450*	820 *2700*	910 *2975*	475 *1550*	590 *1925*	660 *2175*	720 *2350*
N3	420 *1375*	520 *1700*	580 *1900*	630 *2075*	400 *1300*	495 *1625*	550 *1800*	610 *2000*	315 *1025*	395 *1300*	440 *1450*	485 *1600*
N11	480 *1575*	600 *1975*	660 *2175*	720 *2350*	455 *1500*	570 *1875*	630 *2075*	690 *2275*	360 *1175*	455 *1500*	500 *1650*	550 *1800*
S1	48 *155*	60 *195*	65 *215*	75 *245*	46 *150*	55 *180*	65 *215*	70 *230*	37 *120*	46 *150*	50 *165*	55 *180*
S2	39 *130*	48 *155*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	30 *100*	37 *120*	41 *135*	45 *150*
S3	34 *110*	42 *140*	47 *155*	50 *165*	32 *105*	40 *130*	45 *150*	49 *160*	26 *85*	32 *105*	36 *120*	39 *130*
S11	— —	— —	— —	— —	65 *215*	80 *260*	90 *295*	100 *330*	50 *165*	65 *215*	75 *245*	80 *260*
S12	— —	— —	— —	— —	45 *150*	55 *180*	60 *195*	70 *230*	36 *120*	45 *150*	50 *165*	55 *180*
S13	— —	— —	— —	— —	26 *85*	32 *105*	36 *120*	39 *130*	21 *70*	26 *85*	29 *95*	31 *100*
H5	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	31 *100*	39 *130*	43 *140*	47 *155*
H8	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	33 *110*	40 *130*	45 *150*	49 *160*
H11	50 *165*	65 *215*	70 *230*	80 *260*	49 *160*	60 *195*	70 *230*	75 *245*	39 *130*	49 *160*	55 *180*	60 *195*
H12	75 *245*	95 *310*	105 *345*	115 *375*	70 *230*	90 *295*	100 *330*	110 *360*	60 *195*	70 *230*	80 *260*	90 *295*
H21	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	33 *110*	40 *130*	45 *150*	49 *160*

MM08 Z3 – Copiatura – Selezione dell'inserto – Sgrossatura – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
P2	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
P3	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P4	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P5	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P6	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P7	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P8	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P11	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P12	MM08-08009-B90A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
M1	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
M2	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
M3	MM08-08009-B90A30-M03 F40M	1,4 *0.055*	0,040 *0.0016*	0,040 *0.0016*	0,040 *0.0016*	0,055 *0.0022*
M4	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
M5	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
K1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
K2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K5	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
K6	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K7	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
N2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
N3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
N11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
S1	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S2	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S3	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,036 *0.0014*	0,034 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM08-08009-B90A30-M03 F40M	1,2 *0.048*	0,042 *0.0017*	0,040 *0.0016*	0,042 *0.0017*	0,055 *0.0022*
S12	MM08-08009-B90A30-M03 F40M	1,2 *0.048*	0,042 *0.0017*	0,040 *0.0016*	0,042 *0.0017*	0,055 *0.0022*
S13	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
H5	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
H8	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H11	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
H12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H21	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM08 Z3 – Copiatura – Selezione dell'inserto – Finitura – In mm/ *In pollici*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,17 *0.0065*
P3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
P4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,15 *0.0060*
P5	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P6	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P7	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P8	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
P11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P12	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
M1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,17 *0.0065*
M2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
M3	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
M4	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
M5	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
K1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,17 *0.0065*
K2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K5	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
K6	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K7	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
N1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
N2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
N3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
N11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
S1	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S2	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S3	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,038 *0.0015*	0,042 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
S11	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S13	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H5	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
H8	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H11	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
H12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H21	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM08 Z3 – Copiatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	280 *920*	330 *1075*	355 *1175*	380 *1250*	380 *1250*	265 *870*	315 *1025*	335 *1100*	360 *1175*	360 *1175*
P2	270 *890*	325 *1075*	345 *1125*	370 *1225*	365 *1200*	260 *850*	310 *1025*	325 *1075*	350 *1150*	350 *1150*
P3	235 *770*	280 *920*	295 *970*	320 *1050*	320 *1050*	225 *740*	270 *890*	280 *920*	305 *1000*	300 *980*
P4	210 *690*	250 *820*	265 *870*	280 *920*	280 *920*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P5	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
P6	225 *740*	265 *870*	280 *920*	305 *1000*	305 *1000*	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*
P7	210 *690*	250 *820*	265 *870*	290 *950*	285 *940*	200 *660*	240 *790*	255 *840*	275 *900*	270 *890*
P8	200 *660*	235 *770*	250 *820*	270 *890*	265 *870*	190 *620*	225 *740*	235 *770*	255 *840*	255 *840*
P11	205 *670*	245 *800*	260 *850*	280 *920*	275 *900*	195 *640*	230 *750*	245 *800*	265 *870*	265 *870*
P12	130 *425*	155 *510*	160 *520*	175 *570*	175 *570*	125 *410*	150 *490*	155 *510*	165 *540*	165 *540*
M1	220 *720*	260 *850*	275 *900*	300 *980*	295 *970*	210 *690*	250 *820*	265 *870*	285 *940*	280 *920*
M2	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*	170 *560*	205 *670*	215 *710*	235 *770*	230 *750*
M3	145 *475*	170 *560*	175 *570*	190 *620*	190 *620*	135 *445*	165 *540*	170 *560*	180 *590*	180 *590*
M4	100 *330*	135 *445*	135 *475*	145 *475*	145 *475*	95 *310*	130 *425*	130 *445*	140 *460*	140 *460*
M5	80 *260*	115 *375*	115 *395*	120 *395*	120 *395*	80 *260*	110 *360*	105 *375*	115 *375*	115 *375*
K1	215 *710*	255 *840*	270 *890*	295 *970*	290 *950*	205 *670*	245 *800*	260 *850*	280 *920*	275 *900*
K2	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
K3	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*
K4	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*	145 *475*	175 *570*	185 *610*	200 *660*	195 *640*
K5	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*
K6	135 *445*	160 *520*	170 *560*	185 *610*	180 *590*	130 *425*	150 *490*	160 *520*	175 *570*	175 *570*
K7	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*	110 *360*	135 *445*	140 *460*	155 *510*	155 *510*
N1	1625 *5325*	1950 *6400*	2075 *6800*	2225 *7300*	2200 *7225*	1550 *5075*	1850 *6075*	1975 *6475*	2125 *6975*	2100 *6900*
N2	660 *2175*	790 *2600*	830 *2725*	900 *2950*	890 *2925*	630 *2075*	750 *2450*	790 *2600*	850 *2800*	840 *2750*
N3	440 *1450*	520 *1700*	560 *1825*	600 *1975*	590 *1925*	420 *1375*	500 *1650*	530 *1750*	570 *1875*	560 *1825*
N11	500 *1650*	600 *1975*	640 *2100*	680 *2225*	670 *2200*	480 *1575*	570 *1875*	610 *2000*	650 *2125*	640 *2100*
S1	46 *150*	65 *215*	65 *215*	70 *230*	70 *230*	44 *145*	60 *195*	60 *215*	65 *215*	65 *215*
S2	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	49 *160*	48 *165*	50 *165*	50 *165*
S3	32 *105*	45 *150*	44 *155*	48 *155*	48 *155*	31 *100*	43 *140*	42 *150*	45 *150*	45 *150*
S11	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*
S12	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
S13	26 *85*	36 *120*	35 *125*	38 *125*	38 *125*	25 *80*	34 *110*	34 *120*	36 *120*	37 *120*
H5	43 *140*	50 *165*	55 *180*	60 *195*	55 *180*	41 *135*	49 *160*	50 *165*	55 *180*	55 *180*
H8	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*
H11	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	50 *165*	60 *195*	65 *215*	70 *230*	70 *230*
H12	75 *245*	95 *310*	100 *330*	105 *345*	105 *345*	75 *245*	95 *310*	95 *310*	100 *330*	100 *330*
H21	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*

MM08 Z2 – Copiatura – Selezione dell'inserto – Sgrossatura – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*
P2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
P3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,046 *0.0018*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P4	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P5	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P6	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P7	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P8	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,046 *0.0018*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P11	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0018*
M1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
M2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
M3	MM08-08008-B90S-E03 F30M	2,5 *0.10*	0,036 *0.0014*	0,036 *0.0014*	0,040 *0.0016*	0,055 *0.0022*
M4	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
M5	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
K1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
K2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K4	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K5	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,040 *0.0016*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
K6	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K7	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,040 *0.0016*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
N1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
S2	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
S3	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,032 *0.0013*	0,030 *0.0012*	0,034 *0.0013*	0,042 *0.0017*
S11	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,036 *0.0014*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*
S12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,036 *0.0014*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*
S13	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
H5	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0018*
H8	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H11	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0018*
H12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H21	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM08 Z2 – Copiatura – Selezione dell'inserto – Finitura – In mm/ *In pollici*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
P2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
P3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,032 *0.0013*	0,050 *0.0020*
P4	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P5	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P6	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 *0.00070*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P7	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 *0.00070*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P8	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,032 *0.0013*	0,050 *0.0020*
P11	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 *0.00070*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P12	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
M1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
M2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
M3	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,015 *0.00060*	0,018 *0.00070*	0,024 *0.00095*	0,038 *0.0015*
M4	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
M5	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
K1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
K2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K4	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K5	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
K6	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K7	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
N1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
N2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
N3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
N11	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
S1	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S2	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S3	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,014 *0.00060*	0,020 *0.00080*	0,030 *0.0012*
S11	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,015 *0.00060*	0,018 *0.00070*	0,024 *0.00095*	0,038 *0.0015*
S12	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,015 *0.00060*	0,018 *0.00070*	0,024 *0.00095*	0,038 *0.0015*
S13	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
H5	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H8	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 *0.00040*	0,011 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H11	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H12	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 *0.00040*	0,011 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H21	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 *0.00040*	0,011 *0.00048*	0,016 *0.00065*	0,025 *0.0010*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM08 Z2 – Copiatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	320 *1050*	405 *1325*	430 *1400*	465 *1525*	465 *1525*	265 *870*	330 *1075*	360 *1175*	385 *1275*	385 *1275*	215 *710*	265 *870*	290 *950*	315 *1025*	310 *1025*
P2	315 *1025*	395 *1300*	420 *1375*	450 *1475*	450 *1475*	260 *850*	320 *1050*	345 *1125*	375 *1225*	370 *1225*	210 *690*	260 *850*	280 *920*	305 *1000*	300 *980*
P3	270 *890*	340 *1125*	360 *1175*	390 *1275*	390 *1275*	225 *740*	280 *920*	300 *980*	325 *1075*	325 *1075*	180 *590*	225 *740*	245 *800*	265 *870*	260 *850*
P4	240 *790*	300 *980*	320 *1050*	345 *1125*	345 *1125*	200 *660*	245 *800*	265 *870*	285 *940*	285 *940*	160 *520*	200 *660*	215 *710*	230 *750*	230 *750*
P5	225 *740*	285 *940*	305 *1000*	330 *1075*	330 *1075*	190 *620*	235 *770*	255 *840*	275 *900*	275 *900*	155 *510*	190 *620*	205 *670*	220 *720*	220 *720*
P6	255 *840*	320 *1050*	340 *1125*	370 *1225*	370 *1225*	210 *690*	265 *870*	285 *940*	310 *1025*	305 *1000*	170 *560*	215 *710*	230 *750*	250 *820*	250 *820*
P7	240 *790*	300 *980*	320 *1050*	350 *1150*	350 *1150*	200 *660*	250 *820*	270 *890*	295 *970*	290 *950*	160 *520*	200 *660*	220 *720*	235 *770*	235 *770*
P8	225 *740*	285 *940*	305 *1000*	330 *1075*	330 *1075*	190 *620*	235 *770*	250 *820*	275 *900*	270 *890*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
P11	235 *770*	295 *970*	315 *1025*	340 *1125*	340 *1125*	195 *640*	240 *790*	260 *850*	285 *940*	280 *920*	160 *520*	195 *640*	210 *690*	230 *750*	230 *750*
P12	145 *475*	185 *610*	185 *620*	200 *660*	200 *660*	125 *410*	155 *510*	165 *540*	175 *570*	175 *570*	100 *330*	125 *410*	130 *445*	145 *475*	140 *460*
M1	250 *820*	315 *1025*	335 *1100*	365 *1200*	365 *1200*	210 *690*	260 *850*	280 *920*	305 *1000*	300 *980*	170 *560*	210 *690*	225 *740*	245 *800*	240 *790*
M2	205 *670*	255 *840*	275 *900*	295 *970*	295 *970*	170 *560*	210 *690*	230 *750*	245 *800*	245 *800*	140 *460*	170 *560*	185 *610*	200 *660*	200 *660*
M3	165 *540*	205 *670*	210 *710*	225 *740*	225 *740*	135 *445*	175 *570*	180 *590*	195 *640*	195 *640*	110 *360*	140 *460*	145 *475*	155 *510*	155 *510*
M4	125 *410*	160 *520*	160 *560*	170 *560*	170 *560*	110 *360*	140 *460*	135 *475*	150 *490*	150 *490*	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*
M5	105 *345*	135 *445*	130 *460*	140 *460*	140 *460*	90 *295*	115 *375*	115 *395*	125 *410*	125 *410*	75 *245*	95 *310*	90 *330*	100 *330*	100 *330*
K1	250 *820*	310 *1025*	330 *1075*	360 *1175*	355 *1175*	205 *670*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*
K2	215 *710*	270 *890*	290 *950*	310 *1025*	310 *1025*	180 *590*	225 *740*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
K3	180 *590*	230 *750*	245 *800*	265 *870*	265 *870*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*	125 *410*	155 *510*	165 *540*	180 *590*	180 *590*
K4	175 *570*	220 *720*	235 *770*	250 *820*	250 *820*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*	115 *375*	145 *475*	160 *520*	170 *560*	170 *560*
K5	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*	90 *295*	110 *360*	120 *395*	125 *410*	125 *410*	70 *230*	90 *295*	95 *310*	105 *345*	105 *345*
K6	155 *510*	190 *620*	205 *670*	220 *720*	220 *720*	130 *425*	160 *520*	170 *560*	185 *610*	185 *610*	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*
K7	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*	110 *360*	140 *460*	150 *490*	165 *540*	165 *540*	90 *295*	110 *360*	120 *395*	130 *425*	130 *425*
N1	1925 *6325*	2425 *7950*	2575 *8450*	2800 *9175*	2775 *9100*	1550 *5075*	1925 *6325*	2075 *6800*	2250 *7375*	2225 *7300*	1250 *4100*	1550 *5075*	1675 *5500*	1825 *6000*	1800 *5900*
N2	780 *2550*	980 *3225*	1050 *3450*	1125 *3700*	1125 *3700*	630 *2075*	780 *2550*	840 *2750*	910 *2975*	900 *2950*	510 *1675*	630 *2075*	680 *2225*	740 *2425*	730 *2400*
N3	520 *1700*	650 *2125*	700 *2300*	750 *2450*	750 *2450*	420 *1375*	520 *1700*	560 *1825*	610 *2000*	600 *1975*	340 *1125*	420 *1375*	455 *1500*	490 *1600*	485 *1600*
N11	590 *1925*	740 *2425*	800 *2625*	860 *2825*	860 *2825*	480 *1575*	590 *1925*	640 *2100*	700 *2300*	690 *2275*	390 *1275*	480 *1575*	520 *1700*	560 *1825*	560 *1825*
S1	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*	50 *165*	65 *215*	65 *230*	70 *230*	70 *230*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*
S2	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *145*	45 *150*	45 *150*
S3	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	45 *150*	45 *155*	48 *155*	48 *155*	28 *90*	36 *120*	36 *125*	39 *130*	39 *130*
S11	85 *280*	105 *345*	105 *360*	115 *375*	115 *375*	70 *230*	90 *295*	90 *310*	100 *330*	100 *330*	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*
S12	60 *195*	75 *245*	75 *245*	80 *260*	80 *260*	48 *155*	60 *195*	65 *215*	70 *230*	70 *230*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
S13	33 *110*	42 *140*	42 *150*	45 *150*	45 *150*	28 *90*	36 *120*	36 *125*	39 *130*	39 *130*	23 *75*	29 *95*	29 *100*	31 *100*	32 *105*
H5	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	60 *195*	33 *110*	42 *140*	44 *145*	47 *155*	47 *155*
H8	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	44 *145*	45 *150*	48 *155*	48 *155*
H11	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	75 *245*	100 *330*	100 *345*	105 *345*	105 *345*	60 *195*	80 *260*	80 *280*	85 *280*	85 *280*
H21	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	44 *145*	45 *150*	48 *155*	48 *155*

MM08 Per elevato avanzamento – Selezione dell'inserto – In mm/ *In pollici*

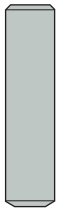
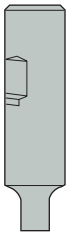
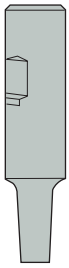
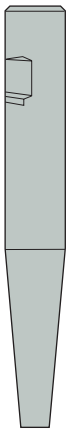
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
P2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
P3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
P4	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,48 *0.019*
P5	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
P6	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,28 *0.011*	0,38 *0.015*	0,46 *0.018*
P7	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,28 *0.011*	0,38 *0.015*	0,46 *0.018*
P8	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
P11	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,28 *0.011*	0,38 *0.015*	0,46 *0.018*
P12	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*	0,30 *0.012*
M1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
M2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
M3	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
M4	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
M5	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
K1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
K2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K4	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K5	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,26 *0.010*	0,26 *0.010*	0,34 *0.013*	0,42 *0.017*
K6	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K7	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,26 *0.010*	0,26 *0.010*	0,34 *0.013*	0,42 *0.017*
N1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
N2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
N3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
N11	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
S1	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
S2	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
S3	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*	0,30 *0.012*
S11	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
S12	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
S13	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
H5	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*	0,30 *0.012*
H8	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 *0.0065*	0,15 *0.0060*	0,19 *0.0075*	0,24 *0.0095*
H11	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*	0,30 *0.012*
H12	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 *0.0065*	0,15 *0.0060*	0,19 *0.0075*	0,24 *0.0095*
H21	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 *0.0065*	0,15 *0.0060*	0,19 *0.0075*	0,24 *0.0095*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

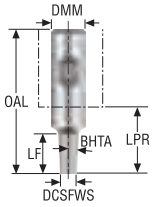
MM08 Per elevato avanzamento Parametri di taglio

SMG	F30M			
	100%	70%	30%	20%
P1	250 *820*	305 *1000*	350 *1150*	375 *1225*
P2	245 *800*	300 *980*	345 *1125*	365 *1200*
P3	215 *710*	260 *850*	300 *980*	315 *1025*
P4	190 *620*	230 *750*	265 *870*	275 *900*
P5	180 *590*	220 *720*	255 *840*	265 *870*
P6	205 *670*	250 *820*	285 *940*	300 *980*
P7	190 *620*	235 *770*	270 *890*	285 *940*
P8	180 *590*	220 *720*	250 *820*	265 *870*
P11	185 *610*	230 *750*	260 *850*	275 *900*
P12	120 *395*	145 *475*	165 *540*	175 *570*
M1	195 *640*	240 *790*	275 *900*	295 *970*
M2	165 *540*	195 *640*	230 *750*	240 *790*
M3	130 *425*	155 *510*	180 *590*	190 *620*
M4	100 *330*	120 *395*	140 *460*	145 *475*
M5	85 *280*	100 *330*	115 *375*	120 *395*
K1	195 *640*	235 *770*	270 *890*	290 *950*
K2	170 *560*	210 *690*	240 *790*	255 *840*
K3	145 *475*	175 *570*	205 *670*	215 *710*
K4	140 *460*	170 *560*	195 *640*	205 *670*
K5	85 *280*	105 *345*	120 *395*	125 *410*
K6	125 *410*	150 *490*	170 *560*	180 *590*
K7	110 *360*	130 *425*	150 *490*	160 *520*
N1	1475 *4850*	1800 *5900*	2050 *6725*	2125 *6975*
N2	590 *1925*	720 *2350*	820 *2700*	860 *2825*
N3	395 *1300*	480 *1575*	550 *1800*	570 *1875*
N11	450 *1475*	550 *1800*	630 *2075*	650 *2125*
S1	48 *155*	55 *180*	65 *215*	70 *230*
S2	39 *130*	46 *150*	50 *165*	55 *180*
S3	33 *110*	40 *130*	46 *150*	48 *155*
S11	65 *215*	80 *260*	90 *295*	95 *310*
S12	46 *150*	55 *180*	65 *215*	65 *215*
S13	27 *90*	32 *105*	36 *120*	38 *125*
H5	40 *130*	47 *155*	55 *180*	60 *195*
H8	41 *135*	50 *165*	55 *180*	60 *195*
H11	50 *165*	60 *195*	70 *230*	75 *245*
H12	75 *245*	90 *295*	100 *330*	105 *345*
H21	41 *135*	50 *165*	55 *180*	60 *195*

Design dello stelo

Versione 1, Stelo chiavetta	Versione 2, Estremità posteriore cilindrica/Weldon e anteriore 90°
	
Versione 3, Estremità posteriore cilindrica/Weldon, anteriore conica 87°/89°	**Design 4, Estremità posteriore cilindrica/Weldon, anteriore conica 80°/85°/87°**
	
Versione 5, Estremità posteriore cilindrica doppia estremità anteriore conica 89°/85°	
	

MM10 Stelo





Codice di ordinazione	Codice prodotto	Tipo di attacco	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Disegno		RPMX	Peso	Codice ricambio
			mm	mm	mm	mm	mm					kg	
MM10-20075.3-0010	75012787	Weldon	9,5	20,0	75,0	10,0	25,0	0,0	2	✓	80000	0,2	4
MM10-20085.3-3023	75012788	Weldon	9,5	20,0	85,0	23,0	35,0	3,0	3	✓	80000	0,2	4
MM10-20140.3-5060	75012789	Weldon	9,5	20,0	140,0	60,0	90,0	5,0	4	✓	80000	0,3	5
MM10-10045.0-0007	00083979	Cilindrico	9,6	10,0	45,0	7,0	7,0	0,0	2	✓	80000	0,1	2
MM10-16065.0-0000	75004925	Cilindrico	9,5	16,0	65,0	0,0	17,0	60,0	1	✓	80000	0,1	1
MM10-16160.0-1035M	00094757	Cilindrico	9,5	16,0	160,0	35,0	112,0	1,0	3	✓	80000	0,2	6
MM10-16160.0-1055M	00094758	Cilindrico	9,5	16,0	160,0	55,0	112,0	1,0	3	✓	80000	0,2	7
MM10-16160.0-1075M	00094760	Cilindrico	9,5	16,0	160,0	75,0	112,0	1,0	3	✓	80000	0,2	7
MM10-32250.0-10063	75069366	Cilindrico	9,5	32,0	250,0	63,8	190,0	10,0	4	✓	80000	1,3	5
MM10-12060.0-0007DS	02580667	Cilindrico	9,6	12,0	60,0	7,0	15,0	0,0	2	✓	76300	0,1	3
MM10-12085.0-3024DS	02580704	Cilindrico	9,5	12,0	85,0	23,8	40,0	3,0	4	✓	76300	0,2	3
MM10-12100.0-1035DS	02580733	Cilindrico	9,5	12,0	100,0	35,0	55,0	1,0	3	✓	76300	0,2	3
MM10-14120.0-1050DS	02580736	Cilindrico	9,5	14,0	120,0	50,0	75,0	1,0	3	✓	76300	0,3	3
MM10-16085.0-0020DS	02580688	Cilindrico	9,5	16,0	85,0	20,0	37,0	0,0	2	✓	76300	0,3	3
MM10-16105.0-0040DS	02580689	Cilindrico	9,5	16,0	105,0	40,0	57,0	0,0	2	✓	76300	0,3	3
MM10-16160.0-1055DS	02580748	Cilindrico	9,5	16,0	160,0	55,0	112,0	1,0	3	✓	76300	0,4	3
MM10-16160.0-1075DS	02580749	Cilindrico	9,5	16,0	160,0	75,0	112,0	1,0	3	✓	76300	0,4	3
MM10-20250.0-1055DS	02580750	Cilindrico	9,5	20,0	250,0	55,0	200,0	1,0	5	✓	76300	1,0	3

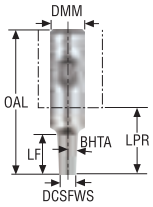
Parti di ricambio, comprese nella fornitura

Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
4	MM-06048	MM10-0627	–
5	MM-06116	MM10-0627	–
2	MM-06020	MM10-0627	H05-4
1	MM-06032	MM10-0627	–
6	MM-06048	MM10-0651	–
7	MM-06032	MM10-0688	–
3	–	MM10-061027	–

MM10 Stelo – pollici

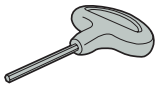




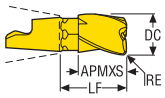
Codice di ordinazione	Codice prodotto	Tipo di attacco	DCSFMS	DMM	OAL	LF	LPR	BHTA°	Disegno		RPMX	Peso	Codice ricambio
			inch	inch	inch	inch	inch					lb	
MM10-0.75-3.0-3-0004	75015052	Weldon	0.360	0.750	2.953	0.394	0.984	0,0	2	✓	80000	0.440	3
MM10-0.75-3.3-3-3009	75015053	Weldon	0.374	0.750	3.346	0.906	1.378	3,0	3	✓	80000	0.440	3
MM10-0.75-5.5-3-5021	75015054	Weldon	0.374	0.750	5.512	2.150	3.543	5,0	4	✓	80000	0.660	5
MM10-0.38-1.8-0-0002	00096126	Cilindrico	0.360	0.375	1.772	0.276	0.276	0,0	2	✓	80000	0.220	2
MM10-0.62-2.6-0-0000	75005069	Cilindrico	0.374	0.625	2.559	0	0.669	60,0	1	✓	80000	0.220	1
MM10-0.62-6.3-0-1021	75054608	Cilindrico	0.360	0.625	6.299	2.165	4.409	1,0	3	✓	80000	0.440	7
MM10-1.25-10.0-0-10024	00096132	Cilindrico	0.374	1.250	9.843	2.484	7.480	10,0	4	✓	80000	2.870	5
MM10-0.75-10.0-0-1021DS	02593420	Cilindrico	0.360	0.750	9.843	2.165	7.874	1,0	5	✓	76300	1.980	4
MM10-0.75-4.1-0-0015DS	02593422	Cilindrico	0.360	0.750	4.134	1.575	2.165	0,0	2	✓	76300	0.660	4

Parti di ricambio, comprese nella fornitura

Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
3	MM-06048	MM10-0627	–
5	MM-06116	MM10-0627	–
2	MM-06020	MM10-0627	H05-4
1	MM-06032	MM10-0627	–
7	MM-06032	MM10-0688	–
4	–	MM10-061027	–

Scanalatura/fresatura a spallamento retto



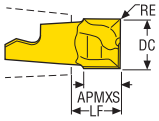


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*								T60M	F15M	F30M	F40M
MM10-09512-A30-E03	9,525 *0.375*	11,8 *0.465*	0,0 –	15,72 *0.619*	15,0	11,6	18,8	30	3	MM0416	✓			■	
MM10-09512-R03A30-M03	9,525 *0.375*	11,8 *0.465*	0,3 *0.012*	15,72 *0.619*	15,0	11,6	18,2	30	3	MM0416	✓				■
MM10-09512-R04A30-M03	9,525 *0.375*	11,8 *0.465*	0,4 *0.016*	15,72 *0.619*	15,0	11,6	18,0	30	3	MM0416	✓				■
MM10-09512-R08A30-M03	9,525 *0.375*	11,8 *0.465*	0,8 *0.031*	15,72 *0.619*	15,0	11,6	17,2	30	3	MM0416	✓				■
MM10-09512-R16A30-M03	9,525 *0.375*	11,8 *0.465*	1,6 *0.063*	15,72 *0.619*	15,0	11,6	15,6	30	3	MM0416	✓				■
MM10-10012-A30-E03	10,0 *0.394*	11,8 *0.465*	0,0 –	15,72 *0.619*	15,0	12,2	19,8	30	3	MM0416	✓			■	
MM10-10012-R05A30-M03	10,0 *0.394*	11,8 *0.465*	0,5 *0.020*	15,72 *0.619*	15,0	12,2	18,8	30	3	MM0416	✓				■
MM10-10012-R10A30-D03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓			■	
MM10-10012-R10A30-E03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓			■	
MM10-10012-R10A30-M03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓				■
MM10-10012-R20A30-M03	10,0 *0.394*	11,8 *0.465*	2,0 *0.079*	15,72 *0.619*	15,0	12,2	15,8	30	3	MM0416	✓				■
MM10-10012-R30A30-M03	10,0 *0.394*	11,8 *0.465*	3,0 *0.118*	15,72 *0.619*	15,0	12,2	13,8	30	3	MM0416	✓				■

Scanalatura/fresatura a spallamento retto

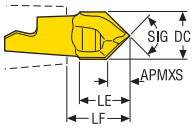




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							T60M	F15M	F30M	F40M
MM10-09510-M03	9,525 *0.375*	6,8 *0.268*	0,0 –	8,5 *0.335*	15,0	11,6	18,8	0	2	MM0612	■			
MM10-09510-R04-MD04	9,525 *0.375*	6,8 *0.268*	0,4 *0.016*	8,49 *0.334*	15,0	11,6	18,0	0	2	MM0612	■			
MM10-09510-R08A8-E03	9,525 *0.375*	6,6 *0.260*	0,8 *0.031*	8,37 *0.330*	15,0	11,6	17,2	8	2	MM0612			■	
MM10-09807T-R03-D04	9,8 *0.386*	6,8 *0.268*	0,3 *0.012*	8,49 *0.334*	15,0	11,9	18,8	0	2	MM0612	■			
MM10-10007-M03	10,0 *0.394*	6,9 *0.272*	0,0 –	8,5 *0.335*	15,0	12,2	19,8	0	2	MM0612	■			
MM10-10007-R04A8-E03	10,0 *0.394*	6,6 *0.260*	0,4 *0.016*	8,44 *0.332*	15,0	12,2	19,0	8	2	MM0612	■		■	
MM10-10007-R04-MD04	10,0 *0.394*	6,8 *0.268*	0,4 *0.016*	8,49 *0.334*	15,0	12,2	19,0	0	2	MM0612	■		■	
MM10-10007-R04P-M03	10,0 *0.394*	6,7 *0.264*	0,4 *0.016*	8,38 *0.330*	15,0	12,2	19,0	0	2	MM0612			■	
MM10-10007-R10-MD04	10,0 *0.394*	6,8 *0.268*	1,0 *0.039*	8,48 *0.334*	15,0	12,2	17,8	0	2	MM0612	■		■	
MM10-10007-R20-MD04	10,0 *0.394*	6,8 *0.268*	2,0 *0.079*	8,46 *0.333*	15,0	12,2	15,8	0	2	MM0612			■	
MM10-10007-R30-MD04	10,0 *0.394*	6,8 *0.268*	3,0 *0.118*	8,44 *0.332*	15,0	12,2	13,8	0	2	MM0612			■	

Punta di centratura

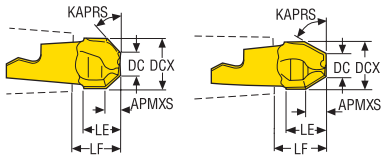




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	LE	LF	SIG°	ZEFP	Chiave	Qualità Rivestite T60M	F15M	F30M	F40M
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							
MM10-10005-C90-M03	10,0 *0.394*	4,69 *0.185*	10,0 *0.394*	11,8 *0.465*	90,0	2	MM0612	■			
MM10-10007-C120-M03	10,0 *0.394*	2,7 *0.106*	10,4 *0.409*	11,8 *0.465*	120,0	2	MM0612	■			

Smussatura



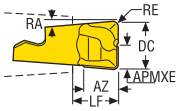


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Chiave	Qualità Rivestite T60M	F15M	F30M	F40M
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							
MM10-10007-4525-E03	10,0 *0.394*	4,82 *0.190*	2,6 *0.102*	6,94 *0.273*	8,48 *0.334*	45,0	2	MM0612	■			
MM10-10008-6040-E03	10,0 *0.394*	5,24 *0.206*	4,0 *0.157*	8,05 *0.317*	9,6 *0.378*	60,0	2	MM0612	■			

Penetrazione assiale



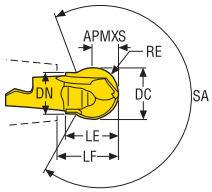


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM10-10007-R10-PL-MD04	10,0 *0.394*	5,0 *0.197*	1,0 *0.039*	7,1 *0.280*	8,48 *0.334*	5,0	2	MM0612			■	

Inserti di precisione per la semi-finitura in tutti i materiali

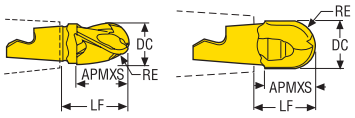




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LE	LF	DN	SA	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM10-12012-B120P-M05	12,0 *0.472*	6,0 *0.236*	6,0 *0.236*	12,0 *0.472*	13,2 *0.520*	10,0 *0.394*	247,0	2	MM0612			■	
MM10-12712-B120PF-M03	12,7 *0.500*	6,35 *0.250*	6,35 *0.250*	12,4 *0.488*	13,56 *0.534*	10,0 *0.394*	256,0	2	MM1420		■		
MM10-12712-B120P-M05	12,7 *0.500*	6,35 *0.250*	6,35 *0.250*	12,4 *0.488*	13,56 *0.534*	10,0 *0.394*	256,0	2	MM1420			■	

Copiatura

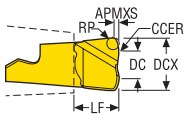




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	FHA	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM10-09510-B90P-M04	9,525 *0.375*	8,7 *0.343*	4,763 *0.188*	11,74 *0.462*	0,0	2	MM0612		■		■	
MM10-10010-B90-MD04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*	0,0	2	MM0612		■		■	
MM10-10010-B90PF-M02	10,0 *0.394*	8,73 *0.344*	5,0 *0.197*	11,74 *0.462*	0,0	2	MM0612			■		
MM10-10010-B90P-M04	10,0 *0.394*	8,73 *0.344*	5,0 *0.197*	11,74 *0.462*	0,0	2	MM0612				■	
MM10-10010-B90S-E04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*	0,0	2	MM0612				■	
MM10-10012-B90A30-D03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓			■	
MM10-10012-B90A30-E03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓			■	
MM10-10012-B90A30-M03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓				■

Elevato avanzamento





• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							T60M	F15M	F30M	F40M
MM10-10.50-HF-MD08	10,0 *0.394*	5,0 *0.197*	0,44 *0.017*	1,13 *0.044*	5,0 *0.197*	8,5 *0.335*	5,0	12,2	18,2	2	MM0612			■	■	

MM10 - Scanalatura e contornatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
P2	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
P3	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P4	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P5	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*
P6	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P7	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P8	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P11	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P12	MM10-10012-R05A30-M03 F40M	1,7 *0.065*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
M1	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
M2	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*
M3	MM10-10012-R05A30-M03 F40M	1,7 *0.065*	0,032 *0.0013*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*
M4	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
M5	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
K1	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
K2	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K3	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K4	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K5	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,040 *0.0016*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*
K6	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K7	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,040 *0.0016*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*
N1	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
S2	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
S3	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM10-10012-R05A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*
S12	MM10-10012-R05A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*
S13	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
H5	MM10-10012-R10A30-D03 F30M	1,7 *0.065*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*
H8	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 *0.0010*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H11	MM10-10012-R10A30-D03 F30M	1,7 *0.065*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*
H12	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 *0.0010*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H21	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 *0.0010*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM10 - Scanalatura e contornatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	265 *870*	330 *1075*	365 *1200*	405 *1325*	250 *820*	315 *1025*	345 *1125*	385 *1275*	190 *620*	240 *790*	270 *890*	295 *970*
P2	260 *850*	320 *1050*	360 *1175*	390 *1275*	245 *800*	305 *1000*	340 *1125*	375 *1225*	185 *610*	235 *770*	260 *850*	290 *950*
P3	225 *740*	280 *920*	315 *1025*	340 *1125*	215 *710*	265 *870*	295 *970*	325 *1075*	165 *540*	205 *670*	230 *750*	250 *820*
P4	200 *660*	245 *800*	275 *900*	305 *1000*	190 *620*	235 *770*	260 *850*	290 *950*	145 *475*	180 *590*	200 *660*	225 *740*
P5	190 *620*	235 *770*	265 *870*	290 *950*	180 *590*	225 *740*	250 *820*	275 *900*	140 *460*	175 *570*	195 *640*	215 *710*
P6	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	250 *820*	280 *920*	310 *1025*	155 *510*	195 *640*	220 *720*	240 *790*
P7	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	290 *950*	145 *475*	185 *610*	205 *670*	225 *740*
P8	190 *620*	235 *770*	265 *870*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	140 *460*	175 *570*	190 *620*	210 *690*
P11	195 *640*	245 *800*	270 *890*	300 *980*	185 *610*	230 *750*	260 *850*	285 *940*	140 *460*	180 *590*	200 *660*	220 *720*
P12	125 *410*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	90 *295*	115 *375*	125 *410*	140 *460*
M1	— —	— —	— —	— —	200 *660*	245 *800*	275 *900*	305 *1000*	150 *490*	190 *620*	210 *690*	235 *770*
M2	— —	— —	— —	— —	165 *540*	200 *660*	225 *740*	250 *820*	125 *410*	155 *510*	175 *570*	190 *620*
M3	— —	— —	— —	— —	130 *425*	160 *520*	175 *570*	195 *640*	100 *330*	125 *410*	140 *460*	155 *510*
M4	— —	— —	— —	— —	100 *330*	120 *395*	135 *445*	150 *490*	75 *245*	95 *310*	105 *345*	115 *375*
M5	— —	— —	— —	— —	80 *260*	100 *330*	115 *375*	125 *410*	65 *215*	80 *260*	90 *295*	95 *310*
K1	205 *670*	255 *840*	285 *940*	310 *1025*	195 *640*	240 *790*	270 *890*	300 *980*	150 *490*	185 *610*	205 *670*	230 *750*
K2	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	215 *710*	235 *770*	260 *850*	130 *425*	165 *540*	185 *610*	200 *660*
K3	150 *490*	190 *620*	210 *690*	235 *770*	145 *475*	180 *590*	200 *660*	220 *720*	110 *360*	140 *460*	155 *510*	170 *560*
K4	145 *475*	180 *590*	200 *660*	225 *740*	140 *460*	170 *560*	190 *620*	210 *690*	105 *345*	130 *425*	150 *490*	165 *540*
K5	90 *295*	110 *360*	125 *410*	135 *445*	85 *280*	105 *345*	115 *375*	125 *410*	65 *215*	80 *260*	90 *295*	100 *330*
K6	130 *425*	160 *520*	180 *590*	195 *640*	120 *395*	150 *490*	170 *560*	185 *610*	95 *310*	115 *375*	130 *425*	145 *475*
K7	110 *360*	140 *460*	155 *510*	170 *560*	105 *345*	135 *445*	150 *490*	165 *540*	85 *280*	105 *345*	115 *375*	125 *410*
N1	1550 *5075*	1925 *6325*	2150 *7050*	2350 *7700*	1475 *4850*	1825 *6000*	2025 *6650*	2250 *7375*	1125 *3700*	1400 *4600*	1550 *5075*	1725 *5650*
N2	630 *2075*	780 *2550*	870 *2850*	950 *3125*	600 *1975*	740 *2425*	820 *2700*	910 *2975*	450 *1475*	570 *1875*	630 *2075*	690 *2275*
N3	415 *1350*	520 *1700*	580 *1900*	630 *2075*	395 *1300*	495 *1625*	550 *1800*	610 *2000*	300 *980*	380 *1250*	420 *1375*	460 *1500*
N11	475 *1550*	590 *1925*	660 *2175*	720 *2350*	455 *1500*	570 *1875*	620 *2025*	690 *2275*	345 *1125*	430 *1400*	480 *1575*	530 *1750*
S1	48 *155*	60 *195*	65 *215*	75 *245*	46 *150*	55 *180*	65 *215*	70 *230*	36 *120*	45 *150*	50 *165*	55 *180*
S2	38 *125*	48 *155*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	29 *95*	36 *120*	40 *130*	44 *145*
S3	34 *110*	42 *140*	47 *155*	50 *165*	32 *105*	40 *130*	45 *150*	49 *160*	25 *80*	32 *105*	35 *115*	38 *125*
S11	— —	— —	— —	— —	65 *215*	80 *260*	90 *295*	100 *330*	50 *165*	65 *215*	70 *230*	75 *245*
S12	— —	— —	— —	— —	45 *150*	55 *180*	60 *195*	70 *230*	35 *115*	43 *140*	49 *160*	55 *180*
S13	— —	— —	— —	— —	26 *85*	32 *105*	36 *120*	39 *130*	20 *65*	25 *80*	28 *90*	30 *100*
H5	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	38 *125*	42 *140*	46 *150*
H8	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	31 *100*	39 *130*	44 *145*	48 *155*
H11	50 *165*	65 *215*	70 *230*	80 *260*	49 *160*	60 *195*	70 *230*	75 *245*	38 *125*	48 *155*	55 *180*	60 *195*
H12	75 *245*	95 *310*	105 *345*	115 *375*	70 *230*	90 *295*	100 *330*	110 *360*	55 *180*	70 *230*	80 *260*	85 *280*
H21	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	31 *100*	39 *130*	44 *145*	48 *155*

MM10 Z3 – Copiatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
P2	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,075 *0.0030*
P3	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P4	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P5	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P6	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P7	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P8	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P11	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P12	MM10-10012-B90A30-M03 F40M	1,7 *0.065*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
M1	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,075 *0.0030*
M2	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
M3	MM10-10012-B90A30-M03 F40M	1,7 *0.065*	0,042 *0.0017*	0,040 *0.0016*	0,042 *0.0017*	0,055 *0.0022*
M4	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
M5	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
K1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,075 *0.0030*
K2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K5	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
K6	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K7	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
N2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
N3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
N11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
S1	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S2	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S3	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,036 *0.0014*	0,034 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM10-10012-B90A30-M03 F40M	1,4 *0.055*	0,042 *0.0017*	0,042 *0.0017*	0,042 *0.0017*	0,055 *0.0022*
S12	MM10-10012-B90A30-M03 F40M	1,4 *0.055*	0,042 *0.0017*	0,042 *0.0017*	0,042 *0.0017*	0,055 *0.0022*
S13	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
H5	MM10-10012-B90A30-D03 F30M	1,7 *0.065*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H8	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H11	MM10-10012-B90A30-D03 F30M	1,7 *0.065*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H12	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H21	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM10 Z3 – Copiatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
P3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,15 *0.0060*
P5	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P6	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P7	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P8	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P12	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 *0.0015*	0,044 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
M1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
M2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
M3	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
M4	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
M5	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
K1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
K2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K5	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
K6	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K7	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
N1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
S1	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S2	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S3	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,038 *0.0015*	0,042 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
S11	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S12	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S13	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H5	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 *0.0015*	0,044 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H8	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H11	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 *0.0015*	0,044 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H12	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H21	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM10 Z3 – Copiatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	280 *920*	330 *1075*	355 *1175*	380 *1250*	380 *1250*	270 *890*	310 *1025*	335 *1100*	365 *1200*	360 *1175*
P2	275 *900*	320 *1050*	340 *1125*	370 *1225*	370 *1225*	260 *850*	305 *1000*	325 *1075*	355 *1175*	355 *1175*
P3	240 *790*	280 *920*	295 *970*	320 *1050*	320 *1050*	230 *750*	265 *870*	280 *920*	305 *1000*	305 *1000*
P4	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P5	200 *660*	235 *770*	250 *820*	275 *900*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	260 *850*
P6	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*	215 *710*	250 *820*	270 *890*	290 *950*	290 *950*
P7	215 *710*	250 *820*	265 *870*	290 *950*	285 *940*	205 *670*	235 *770*	255 *840*	275 *900*	275 *900*
P8	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	235 *770*	260 *850*	260 *850*
P11	205 *670*	240 *790*	260 *850*	280 *920*	280 *920*	195 *640*	230 *750*	245 *800*	265 *870*	265 *870*
P12	130 *425*	160 *520*	160 *520*	175 *570*	175 *570*	125 *410*	150 *490*	155 *510*	165 *540*	165 *540*
M1	220 *720*	255 *840*	275 *900*	300 *980*	300 *980*	210 *690*	245 *800*	260 *850*	285 *940*	285 *940*
M2	180 *590*	210 *690*	225 *740*	245 *800*	245 *800*	175 *570*	200 *660*	215 *710*	235 *770*	230 *750*
M3	145 *475*	175 *570*	175 *590*	190 *620*	190 *620*	135 *445*	165 *540*	170 *560*	185 *610*	180 *590*
M4	95 *310*	140 *460*	135 *475*	145 *475*	145 *475*	95 *310*	130 *425*	130 *445*	140 *460*	140 *460*
M5	80 *260*	115 *375*	115 *395*	120 *395*	120 *395*	75 *245*	110 *360*	105 *375*	115 *375*	115 *375*
K1	220 *720*	255 *840*	270 *890*	295 *970*	295 *970*	205 *670*	240 *790*	255 *840*	280 *920*	280 *920*
K2	190 *620*	220 *720*	240 *790*	260 *850*	255 *840*	180 *590*	210 *690*	230 *750*	245 *800*	245 *800*
K3	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	155 *510*	180 *590*	195 *640*	210 *690*	205 *670*
K4	155 *510*	180 *590*	195 *640*	210 *690*	205 *670*	145 *475*	170 *560*	185 *610*	200 *660*	195 *640*
K5	95 *310*	110 *360*	115 *375*	125 *410*	125 *410*	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*
K6	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*	130 *425*	150 *490*	160 *520*	175 *570*	175 *570*
K7	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*	115 *375*	130 *425*	140 *460*	155 *510*	155 *510*
N1	1650 *5425*	1925 *6325*	2050 *6725*	2225 *7300*	2200 *7225*	1575 *5175*	1825 *6000*	1950 *6400*	2125 *6975*	2100 *6900*
N2	670 *2200*	780 *2550*	830 *2725*	900 *2950*	890 *2925*	640 *2100*	740 *2425*	790 *2600*	860 *2825*	850 *2800*
N3	445 *1450*	520 *1700*	550 *1800*	600 *1975*	590 *1925*	425 *1400*	495 *1625*	530 *1750*	570 *1875*	560 *1825*
N11	510 *1675*	590 *1925*	630 *2075*	690 *2275*	680 *2225*	485 *1600*	560 *1825*	600 *1975*	650 *2125*	650 *2125*
S1	45 *150*	65 *215*	65 *215*	70 *230*	70 *230*	43 *140*	60 *195*	60 *215*	65 *215*	65 *215*
S2	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	49 *160*	48 *165*	50 *165*	50 *165*
S3	32 *105*	45 *150*	44 *155*	48 *155*	48 *155*	30 *100*	43 *140*	42 *150*	46 *150*	45 *150*
S11	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*
S12	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	45 *150*	60 *195*	60 *195*	65 *215*	65 *215*
S13	26 *85*	36 *120*	36 *125*	38 *125*	38 *125*	24 *80*	34 *110*	34 *120*	37 *120*	37 *120*
H5	43 *140*	55 *180*	55 *180*	60 *195*	55 *180*	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*
H8	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
H11	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*
H12	75 *245*	100 *330*	100 *330*	105 *345*	105 *345*	70 *230*	95 *310*	95 *310*	100 *330*	100 *330*
H21	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*

MM10 Z2 – Copiatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*
P3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
P4	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
P5	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P6	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P7	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P8	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
P11	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P12	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
M1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*
M2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
M3	MM10-10010-B90S-E04 F30M	3,5 *0.14*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*
M4	MM10-10010-B90-MD04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
M5	MM10-10010-B90-MD04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
K1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*
K2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K4	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K5	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*
K6	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K7	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*
N1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
N2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
N3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
N11	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
S1	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
S2	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
S3	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*	0,055 *0.0024*
S11	MM10-10010-B90S-E04 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*
S12	MM10-10010-B90S-E04 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*
S13	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
H5	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
H8	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H11	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
H12	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H21	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,046 *0.0018*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM10 Z2 – Copiatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
P3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P4	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P5	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P6	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P7	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P8	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P11	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P12	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
M1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
M2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
M3	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
M4	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
M5	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
K1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
K2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K4	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K5	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
K6	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K7	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
N1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N11	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
S1	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S2	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S3	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,025 *0.0010*	0,028 *0.0012*	0,040 *0.0016*	0,065 *0.0026*
S11	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
S12	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
S13	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
H5	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H8	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H11	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H12	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H21	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM10 Z2 – Copiatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	305 *1000*	390 *1275*	405 *1325*	440 *1450*	440 *1450*	250 *820*	320 *1050*	340 *1125*	370 *1225*	365 *1200*	205 *670*	260 *850*	275 *900*	300 *980*	295 *970*
P2	295 *970*	380 *1250*	395 *1300*	425 *1400*	425 *1400*	240 *790*	305 *1000*	330 *1075*	355 *1175*	355 *1175*	195 *640*	250 *820*	270 *890*	285 *940*	285 *940*
P3	260 *850*	330 *1075*	340 *1125*	370 *1225*	370 *1225*	210 *690*	265 *870*	285 *940*	310 *1025*	310 *1025*	170 *560*	215 *710*	235 *770*	250 *820*	250 *820*
P4	225 *740*	290 *950*	300 *980*	325 *1075*	325 *1075*	185 *610*	235 *770*	255 *840*	270 *890*	275 *900*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
P5	215 *710*	275 *900*	290 *950*	315 *1025*	310 *1025*	175 *570*	225 *740*	240 *790*	265 *870*	260 *850*	145 *475*	185 *610*	195 *640*	215 *710*	210 *690*
P6	245 *800*	310 *1025*	325 *1075*	350 *1150*	350 *1150*	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	235 *770*
P7	230 *750*	295 *970*	305 *1000*	330 *1075*	330 *1075*	190 *620*	240 *790*	260 *850*	280 *920*	275 *900*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
P8	215 *710*	275 *900*	290 *950*	310 *1025*	310 *1025*	175 *570*	225 *740*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
P11	225 *740*	285 *940*	295 *970*	325 *1075*	320 *1050*	185 *610*	235 *770*	250 *820*	270 *890*	270 *890*	150 *490*	190 *620*	205 *670*	220 *720*	215 *710*
P12	140 *460*	175 *570*	180 *610*	195 *640*	195 *640*	120 *395*	150 *490*	155 *510*	170 *560*	170 *560*	95 *310*	120 *395*	125 *410*	135 *445*	135 *445*
M1	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	195 *640*	245 *800*	265 *870*	285 *940*	285 *940*	160 *520*	200 *660*	215 *710*	230 *750*	230 *750*
M2	195 *640*	250 *820*	260 *850*	280 *920*	280 *920*	160 *520*	205 *670*	215 *710*	235 *770*	235 *770*	130 *425*	165 *540*	175 *570*	190 *620*	190 *620*
M3	155 *510*	200 *660*	200 *670*	220 *720*	220 *720*	130 *425*	165 *540*	175 *570*	185 *610*	185 *610*	105 *345*	135 *445*	140 *460*	150 *490*	150 *490*
M4	120 *395*	155 *510*	155 *560*	165 *540*	165 *540*	105 *345*	135 *445*	130 *460*	145 *475*	140 *460*	85 *280*	105 *345*	105 *375*	115 *375*	115 *375*
M5	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	70 *230*	90 *295*	90 *310*	95 *310*	95 *310*
K1	235 *770*	300 *980*	315 *1025*	335 *1100*	335 *1100*	190 *620*	245 *800*	260 *850*	280 *920*	280 *920*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
K2	205 *670*	265 *870*	275 *900*	295 *970*	295 *970*	170 *560*	215 *710*	230 *750*	250 *820*	250 *820*	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*
K3	175 *570*	225 *740*	230 *750*	250 *820*	250 *820*	140 *460*	180 *590*	195 *640*	210 *690*	210 *690*	115 *375*	150 *490*	155 *510*	170 *560*	170 *560*
K4	165 *540*	215 *710*	220 *720*	240 *790*	240 *790*	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*	110 *360*	140 *460*	150 *490*	165 *540*	160 *520*
K5	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*	85 *280*	105 *345*	110 *360*	120 *395*	120 *395*	70 *230*	85 *280*	90 *295*	100 *330*	100 *330*
K6	145 *475*	185 *610*	195 *640*	210 *690*	210 *690*	120 *395*	155 *510*	165 *540*	180 *590*	175 *570*	95 *310*	125 *410*	130 *425*	145 *475*	145 *475*
K7	130 *425*	165 *540*	170 *560*	185 *610*	185 *610*	105 *345*	135 *445*	145 *475*	155 *510*	155 *510*	85 *280*	110 *360*	115 *375*	125 *410*	125 *410*
N1	1800 *5900*	2300 *7550*	2425 *7950*	2600 *8525*	2600 *8525*	1450 *4750*	1825 *6000*	1975 *6475*	2150 *7050*	2100 *6900*	1175 *3850*	1475 *4850*	1600 *5250*	1725 *5650*	1700 *5575*
N2	730 *2400*	930 *3050*	970 *3175*	1050 *3450*	1050 *3450*	590 *1925*	740 *2425*	800 *2625*	870 *2850*	850 *2800*	475 *1550*	600 *1975*	650 *2125*	700 *2300*	680 *2225*
N3	485 *1600*	620 *2025*	650 *2125*	700 *2300*	700 *2300*	390 *1275*	495 *1625*	530 *1750*	580 *1900*	560 *1825*	315 *1025*	400 *1300*	435 *1425*	465 *1525*	455 *1500*
N11	550 *1800*	710 *2325*	740 *2425*	800 *2625*	800 *2625*	450 *1475*	570 *1875*	610 *2000*	660 *2175*	640 *2100*	360 *1175*	460 *1500*	495 *1625*	530 *1750*	520 *1700*
S1	55 *180*	70 *230*	70 *260*	80 *260*	75 *245*	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
S2	46 *150*	60 *195*	60 *215*	65 *215*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*	32 *105*	40 *130*	40 *140*	43 *140*	43 *140*
S3	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	34 *110*	43 *140*	43 *150*	47 *155*	46 *150*	27 *90*	35 *115*	35 *120*	38 *125*	38 *125*
S11	80 *260*	100 *330*	100 *360*	110 *360*	110 *360*	65 *215*	85 *280*	85 *295*	95 *310*	95 *310*	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*
S12	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	48 *155*	49 *165*	55 *180*	55 *180*
S13	32 *105*	41 *135*	40 *145*	44 *145*	43 *140*	27 *90*	35 *115*	35 *120*	37 *120*	37 *120*	22 *70*	28 *90*	28 *100*	30 *100*	30 *100*
H5	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	32 *105*	41 *135*	42 *140*	45 *150*	45 *150*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	33 *110*	43 *140*	43 *150*	47 *155*	47 *155*
H11	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	40 *130*	50 *165*	55 *180*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*	60 *195*	75 *245*	80 *260*	85 *280*	85 *280*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	33 *110*	43 *140*	43 *150*	47 *155*	47 *155*

MM10 Per elevato avanzamento Selezione dell'inserto – In mm/ *In pollici*

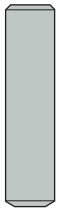
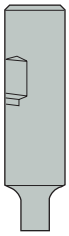
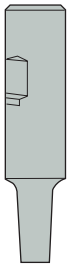
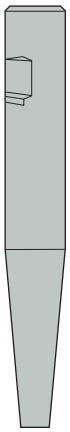
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,48 *0.019*	0,48 *0.019*	0,65 *0.026*	0,80 *0.032*
P2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P4	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P5	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P6	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,75 *0.030*
P7	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,75 *0.030*
P8	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P11	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,75 *0.030*
P12	MM10-10.50-HF-MD08 F30M	0,25 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
M1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
M2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
M3	MM10-10.50-HF-MD08 F30M	0,25 *0.010*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
M4	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
M5	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
K1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
K2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K4	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K5	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
K6	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K7	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
N1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
N2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
N3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
N11	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
S1	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
S2	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
S3	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
S11	MM10-10.50-HF-MD08 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
S12	MM10-10.50-HF-MD08 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
S13	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
H5	MM10-10.50-HF-MD08 F15M	0,25 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
H8	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
H11	MM10-10.50-HF-MD08 F15M	0,25 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
H12	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
H21	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

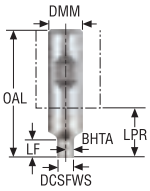
MM10 Per elevato avanzamento Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	—	—	—	—	230	280	325	340
	—	—	—	—	*750*	*920*	*1075*	*1125*
P2	—	—	—	—	225	270	315	330
	—	—	—	—	*740*	*890*	*1025*	*1075*
P3	—	—	—	—	195	240	275	290
	—	—	—	—	*640*	*790*	*900*	*950*
P4	—	—	—	—	170	210	240	255
	—	—	—	—	*560*	*690*	*790*	*840*
P5	—	—	—	—	165	200	230	240
	—	—	—	—	*540*	*660*	*750*	*790*
P6	—	—	—	—	185	225	260	270
	—	—	—	—	*610*	*740*	*850*	*890*
P7	—	—	—	—	175	215	245	255
	—	—	—	—	*570*	*710*	*800*	*840*
P8	—	—	—	—	165	200	230	240
	—	—	—	—	*540*	*660*	*750*	*790*
P11	—	—	—	—	170	210	240	250
	—	—	—	—	*560*	*690*	*790*	*820*
P12	—	—	—	—	110	135	150	160
	—	—	—	—	*360*	*445*	*490*	*520*
M1	—	—	—	—	180	220	255	265
	—	—	—	—	*590*	*720*	*840*	*870*
M2	—	—	—	—	150	180	210	220
	—	—	—	—	*490*	*590*	*690*	*720*
M3	—	—	—	—	120	145	165	175
	—	—	—	—	*395*	*475*	*540*	*570*
M4	—	—	—	—	95	110	130	135
	—	—	—	—	*310*	*360*	*425*	*445*
M5	—	—	—	—	80	95	110	115
	—	—	—	—	*260*	*310*	*360*	*375*
K1	190	230	270	280	175	215	250	260
	620	*750*	*890*	*920*	*570*	*710*	*820*	*850*
K2	170	205	235	245	160	190	220	230
	560	*670*	*770*	*800*	*520*	*620*	*720*	*750*
K3	145	175	200	210	135	160	185	195
	475	*570*	*660*	*690*	*445*	*520*	*610*	*640*
K4	135	165	190	200	125	155	175	185
	445	*540*	*620*	*660*	*410*	*510*	*570*	*610*
K5	85	100	115	125	75	95	105	115
	280	*330*	*375*	*410*	*245*	*310*	*345*	*375*
K6	120	145	170	175	110	135	155	165
	395	*475*	*560*	*570*	*360*	*445*	*510*	*540*
K7	105	130	150	155	100	120	140	145
	345	*425*	*490*	*510*	*330*	*395*	*460*	*475*
N1	—	—	—	—	1325	1600	1850	1925
	—	—	—	—	*4350*	*5250*	*6075*	*6325*
N2	—	—	—	—	530	650	750	780
	—	—	—	—	*1750*	*2125*	*2450*	*2550*
N3	—	—	—	—	355	430	500	520
	—	—	—	—	*1175*	*1400*	*1650*	*1700*
N11	—	—	—	—	405	495	570	590
	—	—	—	—	*1325*	*1625*	*1875*	*1925*
S1	—	—	—	—	45	50	60	65
	—	—	—	—	*150*	*165*	*195*	*215*
S2	—	—	—	—	36	42	49	50
	—	—	—	—	*120*	*140*	*160*	*165*
S3	—	—	—	—	31	37	42	45
	—	—	—	—	*100*	*120*	*140*	*150*
S11	—	—	—	—	60	75	85	90
	—	—	—	—	*195*	*245*	*280*	*295*
S12	—	—	—	—	43	50	60	60
	—	—	—	—	*140*	*165*	*195*	*195*
S13	—	—	—	—	25	29	34	36
	—	—	—	—	*80*	*95*	*110*	*120*
H5	40	48	55	60	37	44	50	55
	130	*155*	*180*	*195*	*120*	*145*	*165*	*180*
H8	42	50	55	60	39	46	55	55
	140	*165*	*180*	*195*	*130*	*150*	*180*	*180*
H11	50	60	70	75	47	55	65	70
	165	*195*	*230*	*245*	*155*	*180*	*215*	*230*
H12	75	90	105	110	70	85	95	100
	245	*295*	*345*	*360*	*230*	*280*	*310*	*330*
H21	42	50	55	60	39	46	55	55
	140	*165*	*180*	*195*	*130*	*150*	*180*	*180*

Design dello stelo

Versione 1, Stelo chiavetta	Versione 2, Estremità posteriore cilindrica/Weldon e anteriore 90°
	
Versione 3, Estremità posteriore cilindrica/Weldon, anteriore conica 87°/89°	**Design 4, Estremità posteriore cilindrica/Weldon, anteriore conica 80°/85°/87°**
	
Versione 5, Estremità posteriore cilindrica doppia estremità anteriore conica 89°/85°	
	

MM12 Stelo





Codice di ordinazione	Codice prodotto	Tipo di attacco	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Disegno		RPMX	Peso	Codice ricambio
			mm	mm	mm	mm	mm					kg	
MM12-20080.3-0012	75012864	Weldon	11,4	20,0	80,0	12,0	30,0	0,0	2	✓	80000	0,2	4
MM12-20095.3-3027	75012865	Weldon	11,4	20,0	95,0	27,0	45,0	3,0	3	✓	80000	0,2	4
MM12-20150.3-5049	75012866	Weldon	11,4	20,0	150,0	49,1	100,0	5,0	4	✓	80000	0,3	5
MM12-12055.0-0008	00083978	Cilindrico	11,5	12,0	55,0	8,5	10,0	0,0	2	✓	80000	0,1	2
MM12-16065.0-0000	75004926	Cilindrico	11,4	16,0	65,0	0,0	17,0	60,0	1	✓	80000	0,1	1
MM12-16170.0-1040	75034505	Cilindrico	11,4	16,0	170,0	40,0	122,0	1,0	3	✓	80000	0,2	5
MM12-16170.0-1060	75034506	Cilindrico	11,4	16,0	170,0	60,0	122,0	1,0	3	✓	80000	0,2	5
MM12-16170.0-1080	75034507	Cilindrico	11,4	16,0	170,0	80,0	122,0	1,0	3	✓	80000	0,2	5
MM12-12070.0-0008DS	02580668	Cilindrico	11,5	12,0	70,0	8,5	25,0	0,0	2	✓	63600	0,1	3
MM12-16095.0-0024DS	02580690	Cilindrico	11,4	16,0	95,0	24,0	47,0	0,0	2	✓	63600	0,3	3
MM12-16090.0-3044DS	02580705	Cilindrico	11,4	16,0	90,0	43,9	42,0	3,0	4	✓	63600	0,3	3
MM12-16120.0-1045DS	02580752	Cilindrico	11,4	16,0	120,0	45,0	72,0	1,0	3	✓	63600	0,3	3
MM12-16115.0-0048DS	02580691	Cilindrico	11,4	16,0	115,0	48,0	67,0	0,0	2	✓	63600	0,3	3
MM12-16170.0-1060DS	02580753	Cilindrico	11,4	16,0	170,0	60,0	122,0	1,0	3	✓	63600	0,5	3
MM12-16170.0-1080DS	02580755	Cilindrico	11,4	16,0	170,0	80,0	122,0	1,0	3	✓	63600	0,5	3
MM12-20250.0-1060DS	02580756	Cilindrico	11,4	20,0	250,0	60,0	200,0	1,0	5	✓	63600	1,0	3

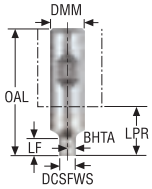
Parti di ricambio, comprese nella fornitura

Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
4	MM-06048	MM12-0637	–
5	MM-06116	MM12-0637	–
2	MM-06020	MM12-0637	H05-4
1	MM-06032	MM12-0637	–
3	–	MM12-061037	–

MM12 Stelo – pollici

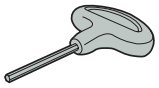




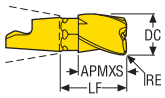
Codice di ordinazione	Codice prodotto	Tipo di attacco	DCSFMS	DMM	OAL	LF	LPR	BHTA°	Disegno		RPMX	Peso	Codice ricambio
			inch	inch	inch	inch	inch					lb	
MM12-0.75-3.1-3-0004	75015055	Weldon	0.449	0.750	3.150	0.472	1.181	0,0	2	✓	80000	0.440	3
MM12-0.75-3.7-3-3010	75015056	Weldon	0.449	0.750	3.740	1.063	1.772	3,0	3	✓	80000	0.440	3
MM12-0.75-5.9-3-5017	75015057	Weldon	0.449	0.750	5.906	1.720	3.937	5,0	4	✓	80000	0.660	5
MM12-0.50-2.2-0-0003	00096133	Cilindrico	0.453	0.500	2.165	0.335	0.394	0,0	2	✓	80000	0.220	2
MM12-0.62-2.6-0-0000	75005070	Cilindrico	0.449	0.625	2.559	0	0.669	60,0	1	✓	80000	0.220	1
MM12-0.62-6.7-0-1015	75054728	Cilindrico	0.449	0.625	6.693	1.575	4.803	1,0	3	✓	80000	0.440	5
MM12-0.62-6.7-0-1023	75054729	Cilindrico	0.449	0.625	6.693	2.362	4.803	1,0	3	✓	80000	0.440	5
MM12-0.62-6.7-0-1023DS	02593423	Cilindrico	0.449	0.625	6.693	2.362	4.803	1,0	3	✓	63600	1.100	4
MM12-0.62-6.7-0-1031DS	02593426	Cilindrico	0.449	0.625	6.693	3.150	4.803	1,0	3	✓	63600	0.880	4
MM12-0.75-10.0-0-1023DS	02593427	Cilindrico	0.449	0.750	9.843	2.362	7.874	1,0	5	✓	63600	1.980	4
MM12-0.75-3.8-0-0009DS	02593428	Cilindrico	0.449	0.750	3.740	0.945	1.772	0,0	2	✓	63600	0.880	4
MM12-0.75-4.5-0-0018DS	02593430	Cilindrico	0.449	0.750	4.528	1.890	2.559	0,0	2	✓	63600	0.880	4

Parti di ricambio, comprese nella fornitura

Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
3	MM-06048	MM12-0637	–
5	MM-06116	MM12-0637	–
2	MM-06020	MM12-0637	H05-4
1	MM-06032	MM12-0637	–
4	–	MM12-061037	–

Scanalatura/fresatura a spallamento retto



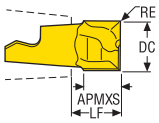


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*								T60M	F15M	F30M	F40M
MM12-11715-R03A30-M04	11,7 *0.461*	15,35 *0.604*	0,3 *0.012*	19,9 *0.783*	15,0	14,2	22,6	30	3	MM0416	✓				■
MM12-12015-A30-E04	12,0 *0.472*	15,35 *0.604*	0,0 –	19,9 *0.783*	15,0	14,6	23,8	30	3	MM0416	✓			■	
MM12-12015-R05A30-M04	12,0 *0.472*	15,35 *0.604*	0,5 *0.020*	19,9 *0.783*	15,0	14,6	22,8	30	3	MM0416	✓				■
MM12-12015-R10A30-E04	12,0 *0.472*	15,35 *0.604*	1,0 *0.039*	19,9 *0.783*	15,0	14,6	21,8	30	3	MM0416	✓			■	
MM12-12015-R10A30-M04	12,0 *0.472*	15,35 *0.604*	1,0 *0.039*	19,9 *0.783*	15,0	14,6	21,8	30	3	MM0416	✓				■
MM12-12015-R15A30-D04	12,0 *0.472*	15,35 *0.604*	1,5 *0.059*	19,9 *0.783*	15,0	14,6	20,8	30	3	MM0416	✓			■	
MM12-12015-R20A30-M04	12,0 *0.472*	15,35 *0.604*	2,0 *0.079*	19,9 *0.783*	15,0	14,6	19,8	30	3	MM0416	✓				■
MM12-12015-R30A30-E04	12,0 *0.472*	15,3 *0.602*	3,0 *0.118*	19,9 *0.783*	15,0	14,6	17,8	30	3	MM0416	✓			■	
MM12-12015-R30A30-M04	12,0 *0.472*	15,35 *0.604*	3,0 *0.118*	19,9 *0.783*	15,0	14,6	17,8	30	3	MM0416	✓				■
MM12-12015-R40A30-M04	12,0 *0.472*	15,35 *0.604*	4,0 *0.157*	19,9 *0.783*	15,0	14,6	15,8	30	3	MM0416	✓				■
MM12-12715-A30-E04	12,7 *0.500*	15,35 *0.604*	0,0 –	19,9 *0.783*	15,0	15,4	25,2	30	3	MM0416	✓			■	
MM12-12715-R08A30-M04	12,7 *0.500*	15,35 *0.604*	0,8 *0.031*	19,9 *0.783*	15,0	15,4	23,6	30	3	MM0416	✓				■
MM12-12715-R16A30-M04	12,7 *0.500*	15,35 *0.604*	1,6 *0.063*	19,9 *0.783*	15,0	15,4	22,0	30	3	MM0416	✓				■

Scanalatura/fresatura a spallamento retto

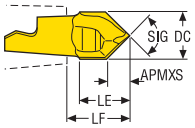




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							T60M	F15M	F30M	F40M
MM12-11708T-R03-D05	11,7 *0.461*	8,2 *0.323*	0,3 *0.012*	10,18 *0.401*	15,0	14,2	22,6	0	2	MM0612	■			
MM12-12008-M04	12,0 *0.472*	8,2 *0.323*	0,0 –	10,2 *0.402*	15,0	14,6	23,8	0	2	MM0612	■			
MM12-12008-R08A8-E04	12,0 *0.472*	8,1 *0.319*	0,8 *0.031*	10,15 *0.400*	15,0	14,6	22,2	8	2	MM0612	■			
MM12-12008-R08-MD05	12,0 *0.472*	8,2 *0.323*	0,8 *0.031*	10,18 *0.401*	15,0	14,6	22,2	0	2	MM0612	■		■	
MM12-12008-R08P-M04	12,0 *0.472*	8,1 *0.319*	0,8 *0.031*	10,05 *0.396*	15,0	14,6	22,2	0	2	MM0612			■	
MM12-12008-R20-MD05	12,0 *0.472*	8,2 *0.323*	2,0 *0.079*	10,16 *0.400*	15,0	14,6	19,8	0	2	MM0612			■	
MM12-12008-R30-MD05	12,0 *0.472*	8,2 *0.323*	3,0 *0.118*	10,14 *0.399*	15,0	14,6	17,8	0	2	MM0612			■	
MM12-12708-M04	12,7 *0.500*	9,3 *0.366*	0,0 –	11,25 *0.443*	15,0	15,4	25,2	0	2	MM1420	■			
MM12-12708-R08-MD05	12,7 *0.500*	9,3 *0.366*	0,8 *0.031*	11,23 *0.442*	15,0	15,4	23,6	0	2	MM1420	■			
MM12-12708-R08P-M04	12,7 *0.500*	9,3 *0.366*	0,8 *0.031*	11,23 *0.442*	15,0	15,4	23,6	0	2	MM1420			■	
MM12-13709T-R03-D05	13,7 *0.539*	9,3 *0.366*	0,3 *0.012*	11,25 *0.443*	15,0	16,6	26,6	0	2	MM1420	■			
MM12-14009-M04	14,0 *0.551*	9,3 *0.366*	0,0 –	11,26 *0.443*	15,0	17,0	27,8	0	2	MM1420	■			
MM12-14009-R08A8-E04	14,0 *0.551*	9,2 *0.362*	0,8 *0.031*	11,06 *0.435*	15,0	17,0	26,2	8	2	MM1420	■		■	
MM12-14009-R08-MD05	14,0 *0.551*	9,3 *0.366*	0,8 *0.031*	11,26 *0.443*	15,0	17,0	26,2	0	2	MM1420	■		■	

Punta di centratura

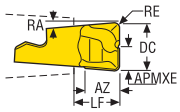




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	LE	LF	SIG°	ZEFP	Chiave	Qualità Rivestite T60M	F15M	F30M	F40M
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							
MM12-12006-C90-M04	12,0 *0.472*	5,65 *0.222*	12,65 *0.498*	14,64 *0.576*	90,0	2	MM0612	■			

Penetrazione assiale



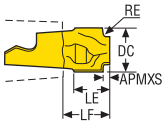


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Chiave	Qualità Rivestite T60M	F15M	F30M	F40M
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							
MM12-12008-R10-PL-MD05	12,0 *0.472*	6,0 *0.236*	1,0 *0.039*	8,5 *0.335*	10,2 *0.402*	5,0	2	MM0612			■	

Raggio concavo



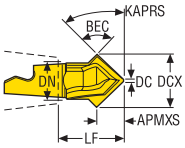


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*			T60M	F15M	F30M	F40M
MM12-12010-CR10-MD05	12,0 *0.472*	2,2 *0.087*	1,0 *0.039*	12,14 *0.478*	2	MM0612	■			
MM12-12010-CR20-MD05	12,0 *0.472*	2,4 *0.094*	2,0 *0.079*	12,25 *0.482*	2	MM0612	■			
MM12-12010-CR30-MD05	12,0 *0.472*	3,3 *0.130*	3,0 *0.118*	12,2 *0.480*	2	MM0612	■			

Smussatura

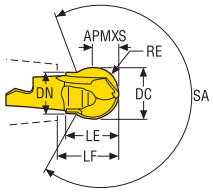




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DCX	DC	APMXS	LF	DN	BEC°	KAPRS°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM12-16016-D3020P-M02	16,0 *0.630*	1,0 *0.039*	4,3 *0.169*	15,2 *0.598*	11,5 *0.453*	60,0	30,0	2	MM1420		■		
MM12-16016-D4520P-M02	16,0 *0.630*	1,0 *0.039*	7,5 *0.295*	17,2 *0.677*	11,5 *0.453*	90,0	45,0	2	MM1420		■		

Inserti di precisione per la semi-finitura in tutti i materiali



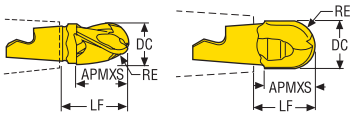


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LE	LF	DN	SA	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM12-14014-B120P-M05	14,0 *0.551*	7,0 *0.276*	7,0 *0.276*	14,0 *0.551*	15,45 *0.608*	12,0 *0.472*	242,0	2	MM1420			■	
MM12-16016-B120PF-M03	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	17,46 *0.687*	12,0 *0.472*	263,0	2	MM1420		■		
MM12-16016-B120P-M07	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	17,46 *0.687*	12,0 *0.472*	263,0	2	MM1420			■	

Copiatura



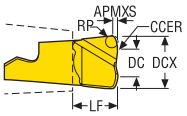


- Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	FHA	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM12-12012-B90-MD05	12,0 *0.472*	12,2 *0.480*	6,0 *0.236*	14,12 *0.556*	0,0	2	MM0612		■		■	
MM12-12012-B90PF-M02	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*	0,0	2	MM0612			■		
MM12-12012-B90P-M05	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*	0,0	2	MM0612				■	
MM12-12012-B90S-E05	12,0 *0.472*	12,3 *0.484*	6,0 *0.236*	14,12 *0.556*	0,0	2	MM0612				■	
MM12-12015-B90A30-E04	12,0 *0.472*	15,3 *0.602*	6,0 *0.236*	19,9 *0.783*	30,0	3	MM0416	✓			■	
MM12-12015-B90A30-M04	12,0 *0.472*	15,3 *0.602*	6,0 *0.236*	19,9 *0.783*	30,0	3	MM0416	✓				■
MM12-12713-B90P-M05	12,7 *0.500*	12,2 *0.480*	6,35 *0.250*	15,92 *0.627*	0,0	2	MM1420		■		■	
MM12-12715-B90A30-M04	12,7 *0.500*	15,3 *0.602*	6,35 *0.250*	19,75 *0.778*	30,0	3	MM0416	✓				■
MM12-14014-B90S-E05	14,0 *0.551*	14,1 *0.555*	7,0 *0.276*	15,92 *0.627*	0,0	2	MM1420				■	

Elevato avanzamento





- Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							T60M	F15M	F30M	F40M
MM12-12.60-HF-MD10	12,0 *0.472*	6,0 *0.236*	0,51 *0.020*	1,21 *0.048*	6,5 *0.256*	10,25 *0.404*	5,0	14,6	22,2	2	MM0612			■	■	

MM12 - Scanalatura e contornatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P2	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P3	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
P4	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P5	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P6	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P7	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P8	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
P11	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P12	MM12-12015-R05A30-M04 F40M	2,0 *0.080*	0,036 *0.0014*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*
M1	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
M2	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
M3	MM12-12015-R05A30-M04 F40M	2,0 *0.080*	0,042 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
M4	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
M5	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
K1	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
K2	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K3	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K4	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K5	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
K6	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*	0,090 *0.0036*
K7	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
N1	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
N2	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
N3	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
N11	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
S1	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S2	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S3	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,046 *0.0018*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0024*
S11	MM12-12015-R05A30-M04 F40M	1,9 *0.075*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
S12	MM12-12015-R05A30-M04 F40M	1,9 *0.075*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
S13	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
H5	MM12-12015-R15A30-D04 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H8	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H11	MM12-12015-R15A30-D04 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H12	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H21	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM12 - Scanalatura e contornatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	250 *820*	315 *1025*	350 *1150*	385 *1275*	240 *790*	300 *980*	335 *1100*	365 *1200*	185 *610*	225 *740*	255 *840*	280 *920*
P2	245 *800*	305 *1000*	340 *1125*	375 *1225*	235 *770*	290 *950*	325 *1075*	355 *1175*	175 *570*	220 *720*	250 *820*	275 *900*
P3	210 *690*	265 *870*	295 *970*	325 *1075*	200 *660*	250 *820*	280 *920*	310 *1025*	155 *510*	195 *640*	215 *710*	235 *770*
P4	190 *620*	235 *770*	260 *850*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	135 *445*	170 *560*	190 *620*	210 *690*
P5	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	215 *710*	240 *790*	260 *850*	130 *425*	160 *520*	180 *590*	200 *660*
P6	205 *670*	250 *820*	280 *920*	310 *1025*	195 *640*	240 *790*	270 *890*	295 *970*	150 *490*	185 *610*	205 *670*	225 *740*
P7	190 *620*	240 *790*	265 *870*	295 *970*	180 *590*	225 *740*	255 *840*	280 *920*	140 *460*	175 *570*	195 *640*	215 *710*
P8	175 *570*	220 *720*	245 *800*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	130 *425*	160 *520*	180 *590*	200 *660*
P11	185 *610*	230 *750*	260 *850*	285 *940*	175 *570*	220 *720*	245 *800*	270 *890*	135 *445*	170 *560*	190 *620*	210 *690*
P12	115 *375*	145 *475*	165 *540*	180 *590*	110 *360*	140 *460*	155 *510*	170 *560*	85 *280*	110 *360*	120 *395*	130 *425*
M1	200 *660*	245 *800*	275 *900*	300 *980*	190 *620*	235 *770*	260 *850*	285 *940*	140 *460*	180 *590*	200 *660*	220 *720*
M2	160 *520*	200 *660*	225 *740*	245 *800*	155 *510*	195 *640*	215 *710*	235 *770*	120 *395*	145 *475*	165 *540*	180 *590*
M3	130 *425*	160 *520*	175 *570*	195 *640*	125 *410*	150 *490*	170 *560*	185 *610*	95 *310*	120 *395*	135 *445*	145 *475*
M4	100 *330*	125 *410*	140 *460*	150 *490*	95 *310*	115 *375*	130 *425*	145 *475*	75 *245*	90 *295*	100 *330*	110 *360*
M5	80 *260*	100 *330*	115 *375*	125 *410*	80 *260*	95 *310*	110 *360*	120 *395*	60 *195*	75 *245*	85 *280*	95 *310*
K1	195 *640*	240 *790*	270 *890*	295 *970*	185 *610*	230 *750*	255 *840*	280 *920*	140 *460*	175 *570*	195 *640*	220 *720*
K2	170 *560*	215 *710*	240 *790*	260 *850*	165 *540*	205 *670*	225 *740*	245 *800*	125 *410*	155 *510*	175 *570*	190 *620*
K3	145 *475*	180 *590*	200 *660*	220 *720*	140 *460*	170 *560*	190 *620*	210 *690*	105 *345*	130 *425*	145 *475*	160 *520*
K4	140 *460*	170 *560*	190 *620*	210 *690*	130 *425*	165 *540*	185 *610*	200 *660*	100 *330*	125 *410*	140 *460*	155 *510*
K5	85 *280*	105 *345*	115 *375*	125 *410*	80 *260*	100 *330*	110 *360*	120 *395*	60 *195*	75 *245*	85 *280*	95 *310*
K6	120 *395*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	90 *295*	110 *360*	125 *410*	135 *445*
K7	105 *345*	135 *445*	150 *490*	165 *540*	100 *330*	125 *410*	140 *460*	155 *510*	80 *260*	100 *330*	110 *360*	120 *395*
N1	1450 *4750*	1800 *5900*	2025 *6650*	2225 *7300*	1375 *4500*	1725 *5650*	1925 *6325*	2125 *6975*	1050 *3450*	1300 *4275*	1450 *4750*	1600 *5250*
N2	580 *1900*	730 *2400*	820 *2700*	900 *2950*	560 *1825*	690 *2275*	780 *2550*	860 *2825*	420 *1375*	530 *1750*	590 *1925*	650 *2125*
N3	390 *1275*	485 *1600*	550 *1800*	600 *1975*	370 *1225*	460 *1500*	520 *1700*	570 *1875*	280 *920*	350 *1150*	395 *1300*	435 *1425*
N11	445 *1450*	550 *1800*	620 *2025*	690 *2275*	425 *1400*	530 *1750*	590 *1925*	650 *2125*	320 *1050*	405 *1325*	450 *1475*	495 *1625*
S1	46 *150*	55 *180*	65 *215*	70 *230*	44 *145*	55 *180*	60 *195*	65 *215*	34 *110*	43 *140*	47 *155*	50 *165*
S2	37 *120*	46 *150*	50 *165*	55 *180*	35 *115*	44 *145*	49 *160*	55 *180*	28 *90*	34 *110*	38 *125*	42 *140*
S3	32 *105*	40 *130*	45 *150*	50 *165*	31 *100*	38 *125*	43 *140*	47 *155*	24 *80*	30 *100*	33 *110*	37 *120*
S11	65 *215*	80 *260*	90 *295*	100 *330*	60 *195*	75 *245*	85 *280*	95 *310*	48 *155*	60 *195*	65 *215*	75 *245*
S12	45 *150*	55 *180*	60 *195*	70 *230*	43 *140*	55 *180*	60 *195*	65 *215*	33 *110*	41 *135*	47 *155*	50 *165*
S13	26 *85*	32 *105*	36 *120*	40 *130*	25 *80*	31 *100*	34 *110*	38 *125*	19 *60*	24 *80*	27 *90*	29 *95*
H5	39 *130*	49 *160*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	29 *95*	36 *120*	40 *130*	44 *145*
H8	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	37 *120*	42 *140*	46 *150*
H11	49 *160*	60 *195*	70 *230*	75 *245*	47 *155*	60 *195*	65 *215*	70 *230*	37 *120*	46 *150*	50 *165*	55 *180*
H12	75 *245*	90 *295*	100 *330*	110 *360*	70 *230*	85 *280*	95 *310*	105 *345*	55 *180*	65 *215*	75 *245*	85 *280*
H21	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	37 *120*	42 *140*	46 *150*

MM12 Z3 – Copiatura – Selezione dell'inserto – Sgrossatura – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,095 *0.0038*
P2	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*	0,095 *0.0038*
P3	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
P4	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
P5	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
P6	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
P7	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
P8	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
P11	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
P12	MM12-12015-B90A30-M04 F40M	2,0 *0.080*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
M1	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*	0,095 *0.0038*
M2	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
M3	MM12-12015-B90A30-M04 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
M4	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
M5	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
K1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*	0,095 *0.0038*
K2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K5	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
K6	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K7	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
N1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
N2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
N3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
N11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
S1	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S2	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S3	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,046 *0.0018*	0,046 *0.0018*	0,046 *0.0018*	0,055 *0.0024*
S11	MM12-12015-B90A30-M04 F40M	1,9 *0.075*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
S12	MM12-12015-B90A30-M04 F40M	1,9 *0.075*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
S13	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
H5	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H8	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0018*
H11	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0018*
H21	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0018*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM12 Z3 – Copiatura – Selezione dell'inserto – Finitura – In mm/ *In pollici*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
P5	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
P6	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*	0,19 *0.0075*
P7	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*	0,19 *0.0075*
P8	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*	0,19 *0.0075*
P12	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
M1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
M2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
M3	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
M4	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
M5	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
K1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
K2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K5	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
K6	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K7	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
N1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
N2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
N3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
N11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
S1	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
S2	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
S3	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,050 *0.0020*	0,055 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
S11	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
S12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
S13	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
H5	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
H8	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
H11	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
H12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
H21	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM12 Z3 – Copiatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	270 *890*	315 *1025*	335 *1100*	365 *1200*	360 *1175*	255 *840*	300 *980*	320 *1050*	345 *1125*	340 *1125*
P2	265 *870*	305 *1000*	325 *1075*	355 *1175*	350 *1150*	250 *820*	290 *950*	310 *1025*	335 *1100*	330 *1075*
P3	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*
P4	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	235 *770*	260 *850*	255 *840*
P5	195 *640*	225 *740*	240 *790*	260 *850*	255 *840*	185 *610*	215 *710*	225 *740*	245 *800*	245 *800*
P6	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*	205 *670*	240 *790*	255 *840*	275 *900*	275 *900*
P7	205 *670*	240 *790*	255 *840*	275 *900*	275 *900*	195 *640*	230 *750*	240 *790*	260 *850*	260 *850*
P8	190 *620*	225 *740*	240 *790*	255 *840*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
P11	200 *660*	235 *770*	245 *800*	265 *870*	265 *870*	190 *620*	220 *720*	235 *770*	255 *840*	255 *840*
P12	125 *410*	150 *490*	155 *510*	170 *560*	165 *540*	120 *395*	140 *460*	145 *490*	160 *520*	160 *520*
M1	210 *690*	245 *800*	265 *870*	285 *940*	280 *920*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
M2	175 *570*	205 *670*	215 *710*	235 *770*	230 *750*	165 *540*	195 *640*	205 *670*	220 *720*	220 *720*
M3	140 *460*	165 *540*	170 *560*	185 *610*	185 *610*	130 *425*	155 *510*	160 *540*	175 *570*	175 *570*
M4	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	95 *310*	125 *410*	125 *425*	135 *445*	135 *445*
M5	80 *260*	110 *360*	110 *375*	115 *375*	115 *375*	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*
K1	210 *690*	240 *790*	260 *850*	280 *920*	275 *900*	200 *660*	230 *750*	245 *800*	265 *870*	265 *870*
K2	185 *610*	215 *710*	225 *740*	245 *800*	245 *800*	175 *570*	205 *670*	215 *710*	235 *770*	230 *750*
K3	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*	145 *475*	175 *570*	180 *590*	200 *660*	195 *640*
K4	150 *490*	175 *570*	180 *590*	200 *660*	195 *640*	140 *460*	165 *540*	175 *570*	190 *620*	185 *610*
K5	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*	85 *280*	100 *330*	105 *345*	115 *375*	115 *375*
K6	130 *425*	155 *510*	160 *520*	175 *570*	175 *570*	125 *410*	145 *475*	155 *510*	165 *540*	165 *540*
K7	115 *375*	135 *445*	140 *460*	155 *510*	155 *510*	110 *360*	125 *410*	135 *445*	145 *475*	145 *475*
N1	1575 *5175*	1825 *6000*	1950 *6400*	2100 *6900*	2100 *6900*	1500 *4925*	1750 *5750*	1850 *6075*	2000 *6550*	2000 *6550*
N2	640 *2100*	740 *2425*	790 *2600*	850 *2800*	840 *2750*	610 *2000*	700 *2300*	750 *2450*	810 *2650*	800 *2625*
N3	425 *1400*	495 *1625*	530 *1750*	570 *1875*	560 *1825*	405 *1325*	470 *1550*	500 *1650*	540 *1775*	540 *1775*
N11	485 *1600*	560 *1825*	600 *1975*	650 *2125*	640 *2100*	460 *1500*	540 *1775*	570 *1875*	620 *2025*	610 *2000*
S1	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	60 *195*	60 *195*	65 *215*	60 *195*
S2	37 *120*	50 *165*	49 *165*	55 *180*	55 *180*	35 *115*	47 *155*	47 *165*	50 *165*	50 *165*
S3	32 *105*	43 *140*	43 *150*	46 *150*	46 *150*	31 *100*	41 *135*	41 *140*	44 *145*	44 *145*
S11	70 *230*	85 *280*	85 *295*	95 *310*	90 *295*	65 *215*	80 *260*	80 *280*	90 *295*	90 *295*
S12	48 *155*	60 *195*	60 *195*	65 *215*	65 *215*	46 *150*	55 *180*	55 *195*	60 *195*	60 *195*
S13	26 *85*	35 *115*	34 *120*	37 *120*	37 *120*	25 *80*	33 *110*	33 *115*	35 *115*	35 *115*
H5	42 *140*	50 *165*	50 *165*	55 *180*	55 *180*	40 *130*	47 *155*	49 *160*	55 *180*	55 *180*
H8	42 *140*	55 *180*	55 *180*	55 *180*	55 *180*	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*
H11	55 *180*	65 *215*	65 *215*	70 *230*	70 *230*	50 *165*	60 *195*	60 *195*	65 *215*	65 *215*
H12	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*	75 *245*	90 *295*	90 *310*	100 *330*	100 *330*
H21	42 *140*	55 *180*	55 *180*	55 *180*	55 *180*	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*

MM12 Z2 – Copiatura – Selezione dell'inserto – Sgrossatura – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
P2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
P3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
P4	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
P5	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
P6	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
P7	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
P8	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
P11	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
P12	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*
M1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
M2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
M3	MM12-12012-B90S-E05 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
M4	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
M5	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
K1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
K2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K4	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K5	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
K6	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K7	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
N1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
N2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
N3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
N11	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
S1	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
S2	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
S3	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,050 *0.0020*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0030*
S11	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
S12	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
S13	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
H5	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*
H8	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,055 *0.0024*
H11	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*
H12	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,055 *0.0024*
H21	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,055 *0.0024*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM12 Z2 – Copiatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
P3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P4	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P5	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P6	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P7	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P8	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P11	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P12	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
M1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
M2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
M3	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,030 *0.0012*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*
M4	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
M5	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
K1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
K2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K4	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K5	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
K6	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K7	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
N1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N11	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
S1	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
S2	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
S3	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,025 *0.0010*	0,028 *0.0012*	0,040 *0.0016*	0,065 *0.0026*
S11	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,030 *0.0012*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*
S12	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,030 *0.0012*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*
S13	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
H5	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H8	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H11	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H12	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H21	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM12 Z2 – Copiatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	310 *1025*	390 *1275*	410 *1350*	445 *1450*	440 *1450*	240 *790*	300 *980*	325 *1075*	350 *1150*	345 *1125*	195 *640*	240 *790*	265 *870*	285 *940*	280 *920*
P2	300 *980*	380 *1250*	400 *1300*	430 *1400*	430 *1400*	230 *750*	290 *950*	315 *1025*	340 *1125*	340 *1125*	185 *610*	235 *770*	255 *840*	275 *900*	275 *900*
P3	260 *850*	330 *1075*	345 *1125*	370 *1225*	370 *1225*	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	160 *520*	205 *670*	225 *740*	240 *790*	240 *790*
P4	230 *750*	290 *950*	305 *1000*	325 *1075*	330 *1075*	175 *570*	225 *740*	245 *800*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
P5	220 *720*	275 *900*	290 *950*	315 *1025*	315 *1025*	170 *560*	215 *710*	235 *770*	255 *840*	250 *820*	140 *460*	170 *560*	190 *620*	205 *670*	200 *660*
P6	245 *800*	310 *1025*	325 *1075*	355 *1175*	355 *1175*	190 *620*	240 *790*	260 *850*	285 *940*	280 *920*	155 *510*	195 *640*	210 *690*	230 *750*	225 *740*
P7	230 *750*	295 *970*	310 *1025*	335 *1100*	335 *1100*	180 *590*	230 *750*	245 *800*	270 *890*	265 *870*	145 *475*	185 *610*	200 *660*	215 *710*	215 *710*
P8	215 *710*	275 *900*	290 *950*	310 *1025*	315 *1025*	170 *560*	215 *710*	235 *770*	250 *820*	250 *820*	135 *445*	170 *560*	190 *620*	200 *660*	200 *660*
P11	225 *740*	285 *940*	300 *980*	325 *1075*	325 *1075*	175 *570*	220 *720*	240 *790*	260 *850*	255 *840*	140 *460*	180 *590*	195 *640*	210 *690*	210 *690*
P12	140 *460*	180 *590*	180 *610*	195 *640*	200 *660*	115 *375*	145 *475*	150 *510*	165 *540*	160 *520*	95 *310*	120 *395*	120 *410*	135 *445*	130 *425*
M1	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	185 *610*	235 *770*	255 *840*	275 *900*	270 *890*	150 *490*	190 *620*	205 *670*	225 *740*	220 *720*
M2	195 *640*	250 *820*	260 *850*	285 *940*	285 *940*	155 *510*	190 *620*	210 *690*	225 *740*	225 *740*	125 *410*	155 *510*	170 *560*	185 *610*	180 *590*
M3	155 *510*	200 *660*	205 *670*	220 *720*	220 *720*	125 *410*	160 *520*	165 *560*	180 *590*	180 *590*	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*
M4	120 *395*	155 *510*	155 *540*	165 *540*	165 *540*	100 *330*	130 *425*	130 *445*	135 *445*	140 *460*	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*
M5	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	85 *280*	110 *360*	105 *375*	115 *375*	115 *375*	70 *230*	85 *280*	85 *295*	95 *310*	95 *310*
K1	235 *770*	300 *980*	315 *1025*	340 *1125*	340 *1125*	180 *590*	230 *750*	250 *820*	270 *890*	270 *890*	145 *475*	185 *610*	205 *670*	220 *720*	215 *710*
K2	205 *670*	265 *870*	275 *900*	300 *980*	300 *980*	160 *520*	200 *660*	220 *720*	240 *790*	235 *770*	130 *425*	165 *540*	180 *590*	195 *640*	190 *620*
K3	175 *570*	225 *740*	235 *770*	255 *840*	255 *840*	135 *445*	170 *560*	185 *610*	205 *670*	200 *660*	110 *360*	140 *460*	150 *490*	165 *540*	165 *540*
K4	165 *540*	215 *710*	225 *740*	240 *790*	240 *790*	130 *425*	165 *540*	180 *590*	195 *640*	190 *620*	105 *345*	130 *425*	145 *475*	155 *510*	155 *510*
K5	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*	80 *260*	100 *330*	110 *360*	115 *375*	115 *375*	65 *215*	80 *260*	85 *280*	95 *310*	95 *310*
K6	145 *475*	185 *610*	195 *640*	215 *710*	215 *710*	115 *375*	145 *475*	155 *510*	170 *560*	170 *560*	95 *310*	115 *375*	125 *410*	140 *460*	135 *445*
K7	130 *425*	165 *540*	170 *560*	185 *610*	185 *610*	100 *330*	125 *410*	140 *460*	150 *490*	150 *490*	80 *260*	105 *345*	110 *360*	120 *395*	120 *395*
N1	1825 *6000*	2300 *7550*	2425 *7950*	2625 *8600*	2600 *8525*	1375 *4500*	1725 *5650*	1900 *6225*	2025 *6650*	2000 *6550*	1100 *3600*	1400 *4600*	1525 *5000*	1650 *5425*	1625 *5325*
N2	730 *2400*	930 *3050*	980 *3225*	1050 *3450*	1050 *3450*	550 *1800*	690 *2275*	760 *2500*	820 *2700*	810 *2650*	450 *1475*	560 *1825*	620 *2025*	660 *2175*	660 *2175*
N3	490 *1600*	620 *2025*	650 *2125*	710 *2325*	700 *2300*	370 *1225*	465 *1525*	510 *1675*	550 *1800*	540 *1775*	300 *980*	375 *1225*	410 *1350*	440 *1450*	440 *1450*
N11	560 *1825*	710 *2325*	750 *2450*	810 *2650*	800 *2625*	425 *1400*	530 *1750*	580 *1900*	620 *2025*	620 *2025*	340 *1125*	430 *1400*	470 *1550*	500 *1650*	500 *1650*
S1	55 *180*	70 *230*	70 *260*	80 *260*	80 *260*	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*
S2	45 *150*	60 *195*	60 *215*	65 *215*	65 *215*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*	31 *100*	39 *130*	39 *135*	42 *140*	42 *140*
S3	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	43 *140*	42 *145*	45 *150*	45 *150*	27 *90*	34 *110*	34 *120*	37 *120*	36 *120*
S11	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*
S12	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	45 *150*	60 *195*	60 *195*	65 *215*	60 *195*	37 *120*	47 *155*	47 *160*	50 *165*	50 *165*
S13	32 *105*	41 *135*	40 *145*	44 *145*	44 *145*	26 *85*	34 *110*	34 *120*	36 *120*	36 *120*	21 *70*	28 *90*	27 *95*	29 *95*	29 *95*
H5	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	48 *155*	50 *165*	55 *180*	55 *180*	31 *100*	39 *130*	41 *135*	44 *145*	44 *145*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *140*	46 *150*	45 *150*
H11	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*	49 *160*	60 *195*	65 *215*	70 *230*	70 *230*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	70 *230*	95 *310*	95 *310*	100 *330*	100 *330*	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *140*	46 *150*	45 *150*

MM12 Per elevato avanzamento Selezione dell'inserto – In mm/ *In pollici*

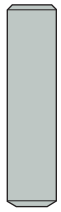
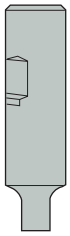
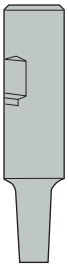
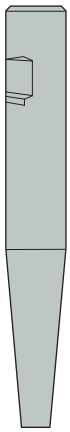
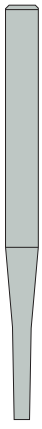
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,75 *0.030*	0,95 *0.038*
P2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *0.036*
P4	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *0.036*
P5	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
P6	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
P7	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
P8	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *0.036*
P11	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
P12	MM12-12.60-HF-MD10 F30M	0,28 *0.011*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
M1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
M2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
M3	MM12-12.60-HF-MD10 F30M	0,28 *0.011*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
M4	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
M5	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
K1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
K2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K4	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K5	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,48 *0.019*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
K6	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K7	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,48 *0.019*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
N1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
N2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
N3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
N11	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
S1	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
S2	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
S3	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,34 *0.013*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
S11	MM12-12.60-HF-MD10 F30M	0,25 *0.010*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
S12	MM12-12.60-HF-MD10 F30M	0,25 *0.010*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
S13	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
H5	MM12-12.60-HF-MD10 F15M	0,28 *0.011*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
H8	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*	0,42 *0.017*
H11	MM12-12.60-HF-MD10 F15M	0,28 *0.011*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
H12	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*	0,42 *0.017*
H21	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*	0,42 *0.017*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM12 Per elevato avanzamento Parametri di taglio v_c = (m/min)/*(sf/min)*

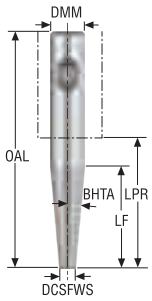
SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	— —	— —	— —	— —	225 *740*	275 *900*	315 *1025*	330 *1075*
P2	— —	— —	— —	— —	220 *720*	265 *870*	310 *1025*	320 *1050*
P3	— —	— —	— —	— —	190 *620*	230 *750*	270 *890*	280 *920*
P4	— —	— —	— —	— —	165 *540*	205 *670*	235 *770*	245 *800*
P5	— —	— —	— —	— —	165 *540*	195 *640*	225 *740*	240 *790*
P6	— —	— —	— —	— —	185 *610*	225 *740*	255 *840*	270 *890*
P7	— —	— —	— —	— —	170 *560*	210 *690*	240 *790*	255 *840*
P8	— —	— —	— —	— —	160 *520*	195 *640*	225 *740*	235 *770*
P11	— —	— —	— —	— —	165 *540*	205 *670*	235 *770*	245 *800*
P12	— —	— —	— —	— —	110 *360*	130 *425*	150 *490*	160 *520*
M1	— —	— —	— —	— —	175 *570*	215 *710*	250 *820*	260 *850*
M2	— —	— —	— —	— —	145 *475*	175 *570*	205 *670*	215 *710*
M3	— —	— —	— —	— —	120 *395*	140 *460*	165 *540*	175 *570*
M4	— —	— —	— —	— —	95 *310*	110 *360*	125 *410*	130 *425*
M5	— —	— —	— —	— —	80 *260*	90 *295*	105 *345*	110 *360*
K1	185 *610*	225 *740*	260 *850*	275 *900*	175 *570*	210 *690*	245 *800*	255 *840*
K2	165 *540*	200 *660*	230 *750*	245 *800*	155 *510*	185 *610*	215 *710*	225 *740*
K3	140 *460*	170 *560*	195 *640*	205 *670*	130 *425*	155 *510*	180 *590*	190 *620*
K4	135 *445*	160 *520*	185 *610*	195 *640*	125 *410*	150 *490*	175 *570*	185 *610*
K5	80 *260*	100 *330*	115 *375*	120 *395*	75 *245*	90 *295*	105 *345*	110 *360*
K6	120 *395*	140 *460*	165 *540*	175 *570*	110 *360*	130 *425*	155 *510*	160 *520*
K7	105 *345*	125 *410*	145 *475*	155 *510*	95 *310*	115 *375*	135 *445*	145 *475*
N1	— —	— —	— —	— —	1275 *4175*	1575 *5175*	1800 *5900*	1875 *6150*
N2	— —	— —	— —	— —	520 *1700*	630 *2075*	730 *2400*	750 *2450*
N3	— —	— —	— —	— —	345 *1125*	420 *1375*	485 *1600*	500 *1650*
N11	— —	— —	— —	— —	395 *1300*	480 *1575*	550 *1800*	570 *1875*
S1	— —	— —	— —	— —	44 *145*	50 *165*	60 *195*	60 *195*
S2	— —	— —	— —	— —	35 *115*	41 *135*	47 *155*	50 *165*
S3	— —	— —	— —	— —	31 *100*	36 *120*	42 *140*	44 *145*
S11	— —	— —	— —	— —	60 *195*	70 *230*	85 *280*	90 *295*
S12	— —	— —	— —	— —	42 *140*	50 *165*	55 *180*	60 *195*
S13	— —	— —	— —	— —	25 *80*	29 *95*	33 *110*	35 *115*
H5	39 *130*	46 *150*	55 *180*	55 *180*	36 *120*	43 *140*	50 *165*	55 *180*
H8	41 *135*	49 *160*	55 *180*	60 *195*	38 *125*	45 *150*	50 *165*	55 *180*
H11	49 *160*	60 *195*	70 *230*	70 *230*	46 *150*	55 *180*	65 *215*	65 *215*
H12	75 *245*	90 *295*	100 *330*	105 *345*	70 *230*	80 *260*	95 *310*	100 *330*
H21	41 *135*	49 *160*	55 *180*	60 *195*	38 *125*	45 *150*	50 *165*	55 *180*

Design dello stelo

Versione 1, Stelo chiavetta	Versione 2, Estremità posteriore cilindrica/Weldon e anteriore 90°
	
Versione 3, Estremità posteriore cilindrica/Weldon, anteriore conica 87°/89°	**Design 4, Estremità posteriore cilindrica/Weldon, anteriore conica 80°/85°/87°**
	
Versione 5, Estremità posteriore cilindrica doppia estremità anteriore conica 89°/85°	
	

MM16 Stelo



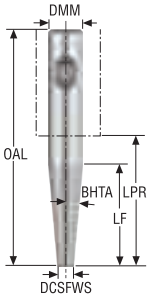


Codice di ordinazione	Codice prodotto	Tipo di attacco	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Disegno		RPMX	Peso	Codice ricambio
			mm	mm	mm	mm	mm					kg	
MM16-20115.3-3045	75014109	Weldon	15,2	20,0	115,0	45,8	65,0	3,0	4	✓	63600	0,2	3
MM16-25100.3-0019	75012790	Weldon	15,2	25,0	100,0	19,0	40,0	0,0	2	✓	63600	0,3	3
MM16-25115.3-3035	75012791	Weldon	15,2	25,0	115,0	35,0	59,0	3,0	3	✓	63600	0,3	3
MM16-25170.3-5056	75012792	Weldon	15,2	25,0	170,0	56,0	114,0	5,0	4	✓	63600	0,6	4
MM16-16070.0-0011M	00023547	Cilindrico	15,2	16,0	70,0	11,3	22,0	0,0	2	✓	63600	0,1	1
MM16-20070.0-0000	00023548	Cilindrico	15,2	20,0	70,0	0,0	20,0	60,0	1	✓	63600	0,2	1
MM16-20190.0-1055M	00094766	Cilindrico	15,2	20,0	190,0	55,0	140,0	1,0	3	✓	63600	0,4	5
MM16-20190.0-1075M	00094768	Cilindrico	15,2	20,0	190,0	75,0	140,0	1,0	3	✓	63600	0,4	5
MM16-20190.0-1095M	00094770	Cilindrico	15,2	20,0	190,0	95,0	140,0	1,0	3	✓	63600	0,4	6
MM16-25170.0-1060	00094767	Cilindrico	19,0	25,0	170,0	60,0	114,0	1,0	3	✓	63600	0,5	5
MM16-32250.0-10047	75069368	Cilindrico	15,2	32,0	250,0	47,6	190,0	10,0	4	✓	63600	1,3	4
MM16-16150.0-0080DS	02580692	Cilindrico	15,2	16,0	150,0	80,0	102,0	0,0	2	✓	47600	0,4	2
MM16-20080.0-0011DS	02580669	Cilindrico	15,2	20,0	80,0	11,3	30,0	0,0	2	✓	47600	0,3	2
MM16-20150.0-0038DS	02580695	Cilindrico	15,2	20,0	150,0	38,0	100,0	0,0	2	✓	47600	0,6	2
MM16-20160.0-0076DS	02580699	Cilindrico	15,2	20,0	160,0	76,0	110,0	0,0	2	✓	47600	0,6	2
MM16-20130.0-1045DS	02580757	Cilindrico	15,2	20,0	130,0	45,0	80,0	1,0	3	✓	47600	0,5	2
MM16-20190.0-1075DS	02580758	Cilindrico	15,2	20,0	190,0	75,0	140,0	1,0	3	✓	47600	0,8	2
MM16-20190.0-1095DS	02580760	Cilindrico	15,2	20,0	190,0	95,0	140,0	1,0	3	✓	47600	0,8	2
MM16-25250.0-1075DS	02580761	Cilindrico	15,2	25,0	250,0	75,0	194,0	1,0	5	✓	47600	1,5	2

Parti di ricambio, comprese nella fornitura

Per fresa	Tirante	Vite di fissaggio
		
3	MM-10062	MM16-1045
4	MM-10132	MM16-1045
1	MM-10030	MM16-1045
5	MM-10062	MM16-1093
6	MM-10062	MM16-10113
2	–	MM16-1045

MM16 Stelo – pollici





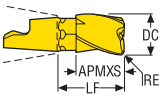
Codice di ordinazione	Codice prodotto	Tipo di attacco	DCSFMS	DMM	OAL	LF	LPR	BHTA°	Disegno		RPMX	Peso	Codice ricambio
			inch	inch	inch	inch	inch					lb	
MM16-0.75-4.5-3-3018	75054603	Weldon	0.598	0.750	4.528	1.445	2.559	3,0	3	✓	63600	0.440	4
MM16-1.00-3.9-3-0007	75015058	Weldon	0.598	1.000	3.937	0.748	1.732	0,0	2	✓	63600	0.660	4
MM16-1.00-4.5-3-3013	75015059	Weldon	0.598	1.000	4.528	1.378	2.323	3,0	3	✓	63600	0.660	4
MM16-1.00-6.7-3-5022	75015060	Weldon	0.598	1.000	6.693	2.295	4.488	5,0	4	✓	63600	1.320	5
MM16-0.62-2.8-0M-0004	00037209	Cilindrico	0.598	0.625	2.756	0.445	0.866	0,0	2	✓	63600	0.220	1
MM16-0.75-2.8-0-0000	00037175	Cilindrico	0.598	0.750	2.756	0	0.787	60,0	1	✓	63600	0.440	1
MM16-0.75-7.5-0-1021	75054731	Cilindrico	0.598	0.750	7.480	2.165	5.512	1,0	3	✓	63600	0.660	6
MM16-0.75-7.5-0-1037	75054733	Cilindrico	0.598	0.750	7.480	3.740	5.512	1,0	3	✓	63600	0.880	7
MM16-0.75-7.5-0-1029DS	02567719	Cilindrico	0.598	0.750	7.480	2.953	5.512	1,0	3	✓	47600	1.760	3
MM16-0.75-7.5-0-1037DS	02593431	Cilindrico	0.598	0.750	7.480	3.740	5.512	1,0	3	✓	47600	1.540	3
MM16-1.00-5.9-0-0015DS	02593433	Cilindrico	0.598	1.000	5.906	1.496	3.701	0,0	2	✓	47600	2.200	3
MM16-1.00-6.3-0-0030DS	02593434	Cilindrico	0.598	1.000	6.299	2.992	4.094	0,0	2	✓	47600	1.980	3

Parti di ricambio, comprese nella fornitura

Per fresa	Tirante	Vite di fissaggio
		
4	MM-10062	MM16-1045
5	MM-10132	MM16-1045
1	MM-10030	MM16-1045
6	MM-10062	MM16-1093
7	MM-10062	MM16-10113
3	–	MM16-1045

Scanalatura/fresatura a spallamento retto

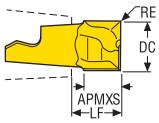




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*								T60M	F15M	F30M	F40M
MM16-15719-R03A30-M06	15,7 *0.618*	19,05 *0.750*	0,3 *0.012*	24,5 *0.965*	15,0	19,0	30,6	30	3	MM0416	✓				■
MM16-15919-R08A30-M06	15,875 *0.625*	19,05 *0.750*	0,8 *0.031*	24,5 *0.965*	15,0	19,2	29,9	30	3	MM0416	✓				■
MM16-16019-A30-E06	16,0 *0.630*	19,05 *0.750*	0,0 –	24,5 *0.965*	15,0	19,4	31,8	30	3	MM0416	✓			■	
MM16-16019-R05A30-M06	16,0 *0.630*	19,05 *0.750*	0,5 *0.020*	24,5 *0.965*	15,0	19,4	30,8	30	3	MM0416	✓				■
MM16-16019-R10A30-E06	16,0 *0.630*	19,05 *0.750*	1,0 *0.039*	24,5 *0.965*	15,0	19,4	29,8	30	3	MM0416	✓			■	
MM16-16019-R10A30-M06	16,0 *0.630*	19,05 *0.750*	1,0 *0.039*	24,5 *0.965*	15,0	19,4	29,8	30	3	MM0416	✓				■
MM16-16019-R20A30-M06	16,0 *0.630*	19,05 *0.750*	2,0 *0.079*	24,5 *0.965*	15,0	19,4	27,8	30	3	MM0416	✓				■
MM16-16019-R30A30-E06	16,0 *0.630*	19,05 *0.750*	3,0 *0.118*	24,5 *0.965*	15,0	19,4	25,8	30	3	MM0416	✓			■	
MM16-16019-R30A30-M06	16,0 *0.630*	19,05 *0.750*	3,0 *0.118*	24,5 *0.965*	15,0	19,4	25,8	30	3	MM0416	✓				■
MM16-16019-R40A30-M06	16,0 *0.630*	19,05 *0.750*	4,0 *0.157*	24,5 *0.965*	15,0	19,4	23,8	30	3	MM0416	✓				■
MM16-16019-R50A30-M06	16,0 *0.630*	19,05 *0.750*	5,0 *0.197*	24,5 *0.965*	15,0	19,4	21,8	30	3	MM0416	✓				■
MM16-16019-R60A30-M06	16,0 *0.630*	19,05 *0.750*	6,0 *0.236*	24,5 *0.965*	15,0	19,4	19,8	30	3	MM0416	✓				■
MM16-20015-A30-E06	20,0 *0.787*	15,0 *0.591*	0,0 –	20,15 *0.793*	15,0	24,2	39,8	30	3	MM0416	✓			■	
MM16-20015-R05A30-M06	20,0 *0.787*	15,0 *0.591*	0,5 *0.020*	20,15 *0.793*	15,0	24,2	38,8	30	3	MM0416	✓				■
MM16-20015-R10A30-M06	20,0 *0.787*	15,0 *0.591*	1,0 *0.039*	20,15 *0.793*	15,0	24,2	37,8	30	3	MM0416	✓				■
MM16-20015-R20A30-D06	20,0 *0.787*	15,0 *0.591*	2,0 *0.079*	20,15 *0.793*	15,0	24,2	35,8	30	3	MM0416	✓			■	
MM16-20015-R30A30-M06	20,0 *0.787*	15,0 *0.591*	3,0 *0.118*	20,15 *0.793*	15,0	24,2	33,8	30	3	MM0416	✓				■
MM16-20015-R50A30-M06	20,0 *0.787*	15,0 *0.591*	5,0 *0.197*	20,15 *0.793*	15,0	24,2	29,8	30	3	MM0416	✓				■

Scanalatura/fresatura a spallamento retto



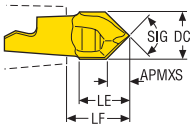


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							T60M	F15M	F30M	F40M
MM16-15711T-R03-D07	15,7 *0.618*	11,0 *0.433*	0,3 *0.012*	13,6 *0.535*	15,0	19,0	30,6	0	2	MM1420	■			
MM16-16011-M06	16,0 *0.630*	11,0 *0.433*	0,0 –	13,6 *0.535*	15,0	19,4	31,8	0	2	MM1420	■			
MM16-16011-R08A8-E06	16,0 *0.630*	10,5 *0.413*	0,8 *0.031*	13,62 *0.536*	15,0	19,4	30,2	8	2	MM1420	■		■	
MM16-16011-R08-MD07	16,0 *0.630*	11,0 *0.433*	0,8 *0.031*	13,58 *0.535*	15,0	19,4	30,2	0	2	MM1420	■		■	
MM16-16011-R08P-M05	16,0 *0.630*	10,8 *0.425*	0,8 *0.031*	13,41 *0.528*	15,0	19,4	30,2	0	2	MM1420			■	
MM16-16011-R20-MD07	16,0 *0.630*	10,9 *0.429*	2,0 *0.079*	13,55 *0.533*	15,0	19,4	27,8	0	2	MM1420			■	
MM16-16011-R30-MD07	16,0 *0.630*	10,9 *0.429*	3,0 *0.118*	13,54 *0.533*	15,0	19,4	25,8	0	2	MM1420			■	
MM16-16011-R40-MD07	16,0 *0.630*	10,9 *0.429*	4,0 *0.157*	13,52 *0.532*	15,0	19,4	23,8	0	2	MM1420	■			
MM16-16011-R50-MD07	16,0 *0.630*	10,9 *0.429*	5,0 *0.197*	13,5 *0.531*	15,0	19,4	21,8	0	2	MM1420	■			
MM16-19013-R08A8-E06	19,05 *0.750*	12,7 *0.500*	0,8 *0.031*	15,39 *0.606*	15,0	23,1	36,3	8	2	MM1420			■	
MM16-20013-R08A8-E06	20,0 *0.787*	12,7 *0.500*	0,8 *0.031*	15,42 *0.607*	15,0	24,2	38,2	8	2	MM1420	■		■	

Punta di centratura



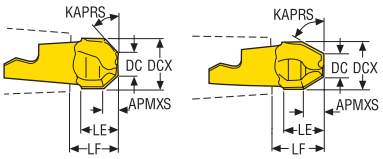


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	LE	LF	SIG°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM16-16008-C90-M06	16,0 *0.630*	7,53 *0.296*	16,7 *0.657*	19,2 *0.756*	90,0	2	MM1420	■			
MM16-16011-C120-M06	16,0 *0.630*	4,3 *0.169*	16,64 *0.655*	18,9 *0.744*	120,0	2	MM1420	■			
MM16-19019-C90	19,05 *0.750*	9,6 *0.378*	20,3 *0.799*	22,15 *0.872*	90,0	2	MM1420	■			

Smussatura

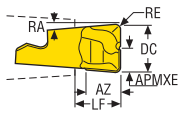




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM16-16011-4540-E06	16,0 *0.630*	7,69 *0.303*	3,9 *0.154*	10,9 *0.429*	13,25 *0.522*	45,0	2	MM1420	■			
MM16-16012-6060-E06	16,0 *0.630*	8,38 *0.330*	6,7 *0.264*	12,9 *0.508*	15,3 *0.602*	60,0	2	MM1420	■			

Penetrazione assiale

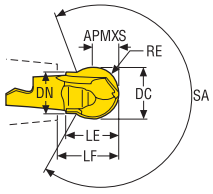




• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM16-16011-R10-PL-MD07	16,0 *0.630*	8,0 *0.315*	1,0 *0.039*	11,3 *0.445*	11,3 *0.445*	5,0	2	MM1420			■	
MM16-16011-R20-PL-MD07	16,0 *0.630*	8,0 *0.315*	2,0 *0.079*	11,3 *0.445*	11,3 *0.445*	5,0	2	MM1420			■	

Inserti di precisione per la semi-finitura in tutti i materiali



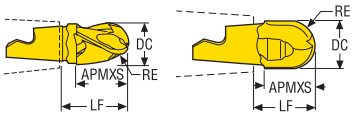


• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LE	LF	DN	SA	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM16-20020-B120PF-M04	20,0 *0.787*	10,0 *0.394*	10,0 *0.394*	20,0 *0.787*	21,94 *0.864*	15,9 *0.626*	254,0	2	MM1420		■		
MM16-20020-B120P-M07	20,0 *0.787*	10,0 *0.394*	10,0 *0.394*	20,0 *0.787*	21,94 *0.864*	15,9 *0.626*	254,0	2	MM1420			■	

Copiatura





• Per le chiavi dinamometriche e i valori di coppia, vedere pagina 673

Codice di ordinazione	DC	APMXS	RE	LF	FHA	ZEFP	Chiave		Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM16-15916-B90P-M07	15,875 *0.625*	13,8 *0.543*	7,938 *0.313*	18,4 *0.724*	0,0	2	MM1420				■	
MM16-16016-B90-MD07	16,0 *0.630*	16,2 *0.638*	8,0 *0.315*	18,4 *0.724*	0,0	2	MM1420		■		■	
MM16-16016-B90PF-M03	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*	0,0	2	MM1420			■		
MM16-16016-B90P-M07	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*	0,0	2	MM1420				■	
MM16-16019-B90A30-E06	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	24,5 *0.965*	30,0	3	MM1420	✓			■	
MM16-16019-B90A30-M06	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	24,5 *0.965*	30,0	3	MM1420	✓				■
MM16-19020-B90P-M07	19,05 *0.750*	7,4 *0.291*	9,525 *0.375*	22,12 *0.871*	0,0	2	MM1420		■			
MM16-20015-B90A30-E06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	30,0	3	MM1420	✓			■	
MM16-20015-B90A30-M06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	30,0	3	MM1420	✓				■
MM16-20020-B90-MD07	20,0 *0.787*	20,3 *0.799*	10,0 *0.394*	22,15 *0.872*	0,0	2	MM1420		■		■	
MM16-20020-B90P-M07	20,0 *0.787*	17,4 *0.685*	10,0 *0.394*	22,12 *0.871*	0,0	2	MM1420				■	

MM16 - Scanalatura e contornatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 *0.0034*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*
P2	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 *0.0034*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
P3	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
P4	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
P5	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
P6	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
P7	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
P8	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
P11	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
P12	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
M1	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 *0.0034*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
M2	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
M3	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*
M4	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
M5	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
K1	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
K2	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K3	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K4	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K5	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
K6	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K7	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
N1	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N2	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N3	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N11	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
S1	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
S2	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
S3	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
S11	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*
S12	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*
S13	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
H5	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
H8	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
H11	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
H12	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
H21	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM16 - Scanalatura e contornatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	230 *750*	285 *940*	315 *1025*	350 *1150*	215 *710*	270 *890*	300 *980*	335 *1100*	200 *660*	250 *820*	275 *900*	310 *1025*
P2	220 *720*	275 *900*	310 *1025*	345 *1125*	210 *690*	260 *850*	290 *950*	325 *1075*	195 *640*	240 *790*	270 *890*	295 *970*
P3	195 *640*	240 *790*	270 *890*	295 *970*	185 *610*	225 *740*	255 *840*	280 *920*	170 *560*	210 *690*	235 *770*	260 *850*
P4	170 *560*	215 *710*	240 *790*	265 *870*	160 *520*	205 *670*	225 *740*	250 *820*	150 *490*	185 *610*	205 *670*	225 *740*
P5	165 *540*	205 *670*	230 *750*	250 *820*	155 *510*	195 *640*	215 *710*	240 *790*	140 *460*	175 *570*	200 *660*	220 *720*
P6	185 *610*	230 *750*	260 *850*	285 *940*	175 *570*	215 *710*	245 *800*	270 *890*	160 *520*	200 *660*	220 *720*	245 *800*
P7	175 *570*	220 *720*	245 *800*	265 *870*	165 *540*	205 *670*	230 *750*	255 *840*	150 *490*	190 *620*	210 *690*	235 *770*
P8	160 *520*	205 *670*	230 *750*	250 *820*	155 *510*	190 *620*	215 *710*	235 *770*	140 *460*	175 *570*	200 *660*	215 *710*
P11	170 *560*	210 *690*	235 *770*	260 *850*	160 *520*	200 *660*	225 *740*	245 *800*	145 *475*	185 *610*	205 *670*	225 *740*
P12	110 *360*	135 *445*	150 *490*	165 *540*	105 *345*	130 *425*	145 *475*	155 *510*	95 *310*	120 *395*	130 *425*	145 *475*
M1	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	155 *510*	190 *620*	215 *710*	240 *790*
M2	150 *490*	185 *610*	205 *670*	225 *740*	140 *460*	175 *570*	195 *640*	215 *710*	125 *410*	160 *520*	180 *590*	200 *660*
M3	120 *395*	150 *490*	165 *540*	180 *590*	110 *360*	140 *460*	155 *510*	175 *570*	105 *345*	130 *425*	145 *475*	155 *510*
M4	90 *295*	115 *375*	130 *425*	140 *460*	85 *280*	110 *360*	120 *395*	135 *445*	80 *260*	100 *330*	110 *360*	120 *395*
M5	75 *245*	95 *310*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	110 *360*	65 *215*	85 *280*	95 *310*	100 *330*
K1	175 *570*	220 *720*	245 *800*	270 *890*	165 *540*	205 *670*	230 *750*	260 *850*	150 *490*	190 *620*	210 *690*	235 *770*
K2	155 *510*	195 *640*	215 *710*	240 *790*	145 *475*	185 *610*	205 *670*	225 *740*	135 *445*	170 *560*	190 *620*	210 *690*
K3	130 *425*	165 *540*	185 *610*	205 *670*	125 *410*	155 *510*	175 *570*	190 *620*	115 *375*	145 *475*	160 *520*	175 *570*
K4	125 *410*	160 *520*	175 *570*	195 *640*	120 *395*	150 *490*	165 *540*	185 *610*	110 *360*	135 *445*	150 *490*	170 *560*
K5	75 *245*	95 *310*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	110 *360*	65 *215*	80 *260*	95 *310*	100 *330*
K6	110 *360*	140 *460*	155 *510*	170 *560*	105 *345*	130 *425*	145 *475*	160 *520*	95 *310*	120 *395*	135 *445*	150 *490*
K7	100 *330*	120 *395*	135 *445*	150 *490*	95 *310*	115 *375*	130 *425*	140 *460*	85 *280*	105 *345*	120 *395*	130 *425*
N1	1325 *4350*	1650 *5425*	1825 *6000*	2025 *6650*	1225 *4025*	1550 *5075*	1725 *5650*	1925 *6325*	1125 *3700*	1425 *4675*	1575 *5175*	1750 *5750*
N2	530 *1750*	670 *2200*	730 *2400*	820 *2700*	500 *1650*	630 *2075*	690 *2275*	770 *2525*	455 *1500*	570 *1875*	640 *2100*	700 *2300*
N3	355 *1175*	445 *1450*	490 *1600*	540 *1775*	335 *1100*	420 *1375*	465 *1525*	520 *1700*	305 *1000*	385 *1275*	425 *1400*	470 *1550*
N11	405 *1325*	510 *1675*	560 *1825*	620 *2025*	380 *1250*	475 *1550*	530 *1750*	590 *1925*	345 *1125*	435 *1425*	485 *1600*	540 *1775*
S1	43 *140*	55 *180*	60 *195*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	38 *125*	46 *150*	50 *165*	55 *180*
S2	35 *115*	43 *140*	48 *155*	55 *180*	33 *110*	41 *135*	45 *150*	50 *165*	30 *100*	37 *120*	42 *140*	46 *150*
S3	30 *100*	38 *125*	42 *140*	46 *150*	29 *95*	35 *115*	40 *130*	44 *145*	27 *90*	33 *110*	37 *120*	40 *130*
S11	60 *195*	75 *245*	85 *280*	90 *295*	55 *180*	70 *230*	80 *260*	90 *295*	50 *165*	65 *215*	75 *245*	80 *260*
S12	42 *140*	50 *165*	60 *195*	65 *215*	39 *130*	49 *160*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*
S13	24 *80*	30 *100*	34 *110*	37 *120*	23 *75*	29 *95*	32 *105*	35 *115*	21 *70*	26 *85*	29 *95*	32 *105*
H5	36 *120*	45 *150*	50 *165*	55 *180*	34 *110*	43 *140*	48 *155*	50 *165*	31 *100*	39 *130*	44 *145*	48 *155*
H8	38 *125*	47 *155*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*	33 *110*	41 *135*	46 *150*	50 *165*
H11	46 *150*	60 *195*	65 *215*	70 *230*	43 *140*	55 *180*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*
H12	70 *230*	85 *280*	95 *310*	105 *345*	65 *215*	80 *260*	90 *295*	100 *330*	60 *195*	75 *245*	85 *280*	90 *295*
H21	38 *125*	47 *155*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*	33 *110*	41 *135*	46 *150*	50 *165*

MM16 Z3 – Copiatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*
P2	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*
P3	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,14 *0.0055*
P4	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P5	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P6	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P7	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P8	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,14 *0.0055*
P11	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P12	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
M1	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*
M2	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
M3	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 *0.0034*	0,080 *0.0032*	0,080 *0.0032*	0,11 *0.0044*
M4	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
M5	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
K1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*
K2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,090 *0.0036*	0,085 *0.0034*	0,090 *0.0036*	0,12 *0.0048*
K6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,090 *0.0036*	0,085 *0.0034*	0,090 *0.0036*	0,12 *0.0048*
N1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
N2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
N3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
N11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
S1	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
S2	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
S3	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0036*
S11	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 *0.0034*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S12	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 *0.0034*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S13	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
H5	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
H8	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
H11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
H12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
H21	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM16 Z3 – Copiatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*	0,32 *0.013*
P2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*	0,34 *0.013*
P3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,32 *0.013*
P4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,19 *0.0075*	0,30 *0.012*
P5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P8	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,32 *0.013*
P11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
M1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*	0,34 *0.013*
M2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
M3	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*	0,24 *0.0095*
M4	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
M5	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
K1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*	0,34 *0.013*
K2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
K6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
N1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
N2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
N3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
N11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
S1	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
S2	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
S3	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,075 *0.0030*	0,085 *0.0036*	0,12 *0.0048*	0,19 *0.0075*
S11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*	0,24 *0.0095*
S12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*	0,24 *0.0095*
S13	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
H5	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
H8	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
H11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
H12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
H21	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM16 Z3 – Copiatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	245 *800*	295 *970*	310 *1025*	335 *1100*	335 *1100*	235 *770*	280 *920*	295 *970*	320 *1050*	320 *1050*
P2	240 *790*	285 *940*	300 *980*	325 *1075*	320 *1050*	230 *750*	270 *890*	285 *940*	310 *1025*	305 *1000*
P3	210 *690*	250 *820*	260 *850*	285 *940*	280 *920*	200 *660*	240 *790*	250 *820*	270 *890*	265 *870*
P4	185 *610*	220 *720*	235 *770*	250 *820*	250 *820*	175 *570*	210 *690*	225 *740*	240 *790*	240 *790*
P5	175 *570*	210 *690*	225 *740*	240 *790*	240 *790*	170 *560*	200 *660*	215 *710*	230 *750*	230 *750*
P6	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
P7	190 *620*	225 *740*	235 *770*	255 *840*	255 *840*	180 *590*	210 *690*	225 *740*	245 *800*	240 *790*
P8	175 *570*	210 *690*	220 *720*	240 *790*	235 *770*	170 *560*	200 *660*	210 *690*	230 *750*	225 *740*
P11	185 *610*	215 *710*	230 *750*	250 *820*	245 *800*	175 *570*	205 *670*	220 *720*	235 *770*	235 *770*
P12	115 *375*	145 *475*	145 *475*	160 *520*	155 *510*	110 *360*	140 *460*	140 *460*	150 *490*	150 *490*
M1	195 *640*	230 *750*	240 *790*	265 *870*	260 *850*	185 *610*	220 *720*	230 *750*	250 *820*	245 *800*
M2	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	150 *490*	180 *590*	190 *620*	205 *670*	205 *670*
M3	130 *425*	160 *520*	160 *520*	170 *560*	170 *560*	120 *395*	150 *490*	150 *490*	165 *540*	165 *540*
M4	90 *295*	125 *410*	125 *425*	130 *425*	135 *445*	85 *280*	120 *395*	115 *410*	125 *410*	125 *410*
M5	75 *245*	105 *345*	100 *360*	110 *360*	110 *360*	70 *230*	100 *330*	100 *345*	105 *345*	105 *345*
K1	190 *620*	225 *740*	235 *770*	260 *850*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
K2	170 *560*	200 *660*	210 *690*	230 *750*	225 *740*	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*
K3	140 *460*	170 *560*	180 *590*	195 *640*	190 *620*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
K4	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*	130 *425*	155 *510*	165 *540*	175 *570*	175 *570*
K5	85 *280*	100 *330*	105 *345*	110 *360*	110 *360*	80 *260*	95 *310*	100 *330*	105 *345*	105 *345*
K6	120 *395*	140 *460*	150 *490*	165 *540*	160 *520*	115 *375*	135 *445*	145 *475*	155 *510*	155 *510*
K7	105 *345*	125 *410*	130 *425*	145 *475*	145 *475*	100 *330*	120 *395*	125 *410*	135 *445*	135 *445*
N1	1425 *4675*	1700 *5575*	1775 *5825*	1925 *6325*	1900 *6225*	1350 *4425*	1625 *5325*	1700 *5575*	1850 *6075*	1800 *5900*
N2	580 *1900*	690 *2275*	720 *2350*	780 *2550*	770 *2525*	550 *1800*	650 *2125*	680 *2225*	740 *2425*	730 *2400*
N3	385 *1275*	455 *1500*	480 *1575*	520 *1700*	510 *1675*	365 *1200*	435 *1425*	455 *1500*	495 *1625*	485 *1600*
N11	440 *1450*	520 *1700*	550 *1800*	600 *1975*	580 *1900*	420 *1375*	495 *1625*	520 *1700*	570 *1875*	560 *1825*
S1	42 *140*	60 *195*	55 *195*	60 *195*	60 *195*	40 *130*	55 *180*	55 *195*	60 *195*	60 *195*
S2	34 *110*	48 *155*	46 *160*	50 *165*	50 *165*	33 *110*	45 *150*	44 *155*	47 *155*	48 *155*
S3	30 *100*	41 *135*	40 *140*	43 *140*	43 *140*	28 *90*	39 *130*	38 *135*	41 *135*	41 *135*
S11	65 *215*	80 *260*	80 *280*	85 *280*	85 *280*	60 *195*	80 *260*	75 *260*	85 *280*	80 *260*
S12	45 *150*	55 *180*	55 *195*	60 *195*	60 *195*	43 *140*	55 *180*	55 *180*	55 *180*	55 *180*
S13	24 *80*	33 *110*	32 *110*	35 *115*	35 *115*	23 *75*	32 *105*	31 *110*	33 *110*	33 *110*
H5	39 *130*	48 *155*	48 *160*	55 *180*	50 *165*	37 *120*	46 *150*	46 *150*	50 *165*	50 *165*
H8	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*
H11	50 *165*	60 *195*	60 *195*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
H12	70 *230*	90 *295*	90 *310*	100 *330*	100 *330*	70 *230*	85 *280*	85 *295*	95 *310*	95 *310*
H21	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*

MM16 Z2 – Copiatura – Selezione dell'inserto – In mm/ *In pollici*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P3	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
P4	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
P5	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P6	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P7	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P8	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
P11	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P12	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0044*
M1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
M2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
M3	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,085 *0.0034*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0050*
M4	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
M5	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
K1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K3	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K4	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K5	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
K6	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K7	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
N1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S2	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S3	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*
S11	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*	0,12 *0.0050*
S12	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*	0,12 *0.0050*
S13	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
H5	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0044*
H8	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
H11	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0044*
H12	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
H21	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM16 Z2 – Copiatura – Selezione dell'inserto – Finitura – mm/*Inch*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
P3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P4	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P5	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P6	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
P7	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
P8	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
P12	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
M1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
M2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
M3	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
M4	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
M5	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
K1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
K2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K4	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K5	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,13 *0.0050*
K6	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K7	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,13 *0.0050*
N1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
N2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
N3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
N11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
S1	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S2	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S3	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
S11	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S12	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S13	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H5	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H8	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 *0.0012*	0,034 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
H11	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H12	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 *0.0012*	0,034 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
H21	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 *0.0012*	0,034 *0.0014*	0,048 *0.0019*	0,075 *0.0030*

SMG = Gruppo materiale Seco
f_z = mm/dente (poll./dente), v_c = m/min (sf/min), a_e/DC = %
Tutti i parametri di taglio sono valori iniziali

MM16 Z2 – Copiatura – Parametri di taglio v_c = (m/min)/*(sf/min)*

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	285 *940*	360 *1175*	390 *1275*	420 *1375*	415 *1350*	225 *740*	280 *920*	300 *980*	325 *1075*	325 *1075*	185 *610*	225 *740*	245 *800*	265 *870*	265 *870*
P2	275 *900*	350 *1150*	375 *1225*	405 *1325*	405 *1325*	220 *720*	270 *890*	295 *970*	315 *1025*	315 *1025*	180 *590*	220 *720*	240 *790*	255 *840*	255 *840*
P3	240 *790*	305 *1000*	325 *1075*	355 *1175*	355 *1175*	190 *620*	240 *790*	255 *840*	280 *920*	275 *900*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
P4	215 *710*	270 *890*	285 *940*	310 *1025*	310 *1025*	170 *560*	210 *690*	225 *740*	245 *800*	245 *800*	140 *460*	170 *560*	185 *610*	200 *660*	195 *640*
P5	205 *670*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	200 *660*	220 *720*	235 *770*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	190 *620*
P6	230 *750*	290 *950*	310 *1025*	335 *1100*	335 *1100*	180 *590*	225 *740*	245 *800*	265 *870*	265 *870*	150 *490*	180 *590*	200 *660*	215 *710*	215 *710*
P7	215 *710*	275 *900*	290 *950*	315 *1025*	315 *1025*	170 *560*	210 *690*	230 *750*	250 *820*	250 *820*	140 *460*	170 *560*	190 *620*	200 *660*	200 *660*
P8	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	160 *520*	200 *660*	215 *710*	235 *770*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	190 *620*
P11	210 *690*	265 *870*	285 *940*	310 *1025*	310 *1025*	165 *540*	205 *670*	225 *740*	240 *790*	240 *790*	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*
P12	135 *445*	175 *570*	175 *590*	190 *620*	190 *620*	110 *360*	140 *460*	145 *475*	155 *510*	155 *510*	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*
M1	225 *740*	285 *940*	300 *980*	330 *1075*	325 *1075*	175 *570*	220 *720*	235 *770*	255 *840*	250 *820*	145 *475*	180 *590*	190 *620*	205 *670*	205 *670*
M2	185 *610*	230 *750*	250 *820*	270 *890*	265 *870*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*	120 *395*	145 *475*	160 *520*	170 *560*	170 *560*
M3	150 *490*	190 *620*	195 *660*	210 *690*	210 *690*	120 *395*	150 *490*	155 *520*	170 *560*	170 *560*	95 *310*	125 *410*	125 *425*	135 *445*	135 *445*
M4	115 *375*	150 *490*	150 *520*	160 *520*	160 *520*	95 *310*	125 *410*	120 *425*	130 *425*	130 *425*	75 *245*	100 *330*	95 *345*	105 *345*	105 *345*
M5	95 *310*	125 *410*	125 *445*	135 *445*	135 *445*	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	65 *215*	85 *280*	80 *280*	90 *295*	85 *280*
K1	220 *720*	280 *920*	295 *970*	320 *1050*	320 *1050*	175 *570*	215 *710*	235 *770*	250 *820*	250 *820*	140 *460*	175 *570*	190 *620*	205 *670*	200 *660*
K2	195 *640*	245 *800*	260 *850*	285 *940*	280 *920*	155 *510*	190 *620*	210 *690*	220 *720*	220 *720*	125 *410*	155 *510*	170 *560*	180 *590*	180 *590*
K3	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*	130 *425*	160 *520*	175 *570*	190 *620*	185 *610*	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*
K4	155 *510*	195 *640*	210 *690*	230 *750*	225 *740*	125 *410*	155 *510*	170 *560*	180 *590*	180 *590*	100 *330*	125 *410*	135 *445*	145 *475*	145 *475*
K5	95 *310*	120 *395*	125 *410*	135 *445*	140 *460*	75 *245*	95 *310*	100 *330*	110 *360*	110 *360*	60 *195*	75 *245*	80 *260*	90 *295*	90 *295*
K6	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*	110 *360*	135 *445*	150 *490*	160 *520*	155 *510*	90 *295*	110 *360*	120 *395*	130 *425*	125 *410*
K7	120 *395*	150 *490*	165 *540*	175 *570*	175 *570*	95 *310*	120 *395*	130 *425*	140 *460*	140 *460*	80 *260*	95 *310*	105 *345*	115 *375*	115 *375*
N1	1675 *5500*	2125 *6975*	2250 *7375*	2450 *8050*	2450 *8050*	1300 *4275*	1625 *5325*	1725 *5650*	1875 *6150*	1850 *6075*	1050 *3450*	1325 *4350*	1400 *4600*	1525 *5000*	1500 *4925*
N2	680 *2225*	860 *2825*	910 *2975*	990 *3250*	990 *3250*	530 *1750*	660 *2175*	700 *2300*	760 *2500*	750 *2450*	425 *1400*	530 *1750*	570 *1875*	620 *2025*	610 *2000*
N3	450 *1475*	570 *1875*	610 *2000*	660 *2175*	660 *2175*	350 *1150*	435 *1425*	465 *1525*	510 *1675*	500 *1650*	285 *940*	355 *1175*	380 *1250*	410 *1350*	405 *1325*
N11	520 *1700*	650 *2125*	690 *2275*	750 *2450*	760 *2500*	400 *1300*	500 *1650*	530 *1750*	580 *1900*	570 *1875*	325 *1075*	405 *1325*	430 *1400*	470 *1550*	465 *1525*
S1	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	45 *160*	49 *160*	49 *160*
S2	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	35 *115*	46 *150*	45 *155*	49 *160*	49 *160*	29 *95*	37 *120*	36 *130*	40 *130*	39 *130*
S3	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*	31 *100*	40 *130*	39 *140*	43 *140*	43 *140*	25 *80*	32 *105*	32 *110*	35 *115*	35 *115*
S11	75 *245*	100 *330*	100 *345*	105 *345*	105 *345*	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*
S12	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	35 *115*	44 *145*	44 *150*	48 *155*	48 *155*
S13	31 *100*	39 *130*	39 *140*	42 *140*	42 *140*	25 *80*	32 *105*	31 *110*	34 *110*	34 *110*	20 *65*	26 *85*	25 *90*	28 *90*	28 *90*
H5	45 *150*	55 *180*	60 *195*	65 *215*	65 *215*	36 *120*	46 *150*	48 *155*	50 *165*	50 *165*	30 *100*	37 *120*	39 *130*	41 *135*	41 *135*
H8	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	31 *100*	40 *130*	40 *140*	44 *145*	43 *140*
H11	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	47 *155*	49 *165*	55 *180*	50 *165*
H12	85 *280*	105 *345*	105 *375*	115 *375*	115 *375*	70 *230*	90 *295*	90 *310*	95 *310*	95 *310*	55 *180*	70 *230*	70 *245*	80 *260*	80 *260*
H21	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	31 *100*	40 *130*	40 *140*	44 *145*	43 *140*

Informazioni su chiave dinamometrica e giri al minuto massimi

Chiave dinamometrica

I giri al minuto raccomandati per tutte le frese Seco sono indicati su ogni pagina del catalogo.
Normalmente non sono necessari utensili di bilanciamento per giri al minuto fino a 10.000.
Tuttavia, in alcuni casi è necessario eseguire il bilanciamento, ad esempio quando si utilizzano utensili e portautensili pesanti in macchine di piccole dimensioni



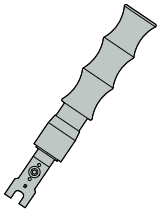
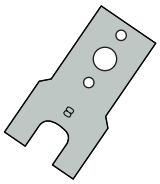
Chiave dinamometrica con valori di coppia fissi per garantire la corretta forza di serraggio durante il montaggio dell'inserto Minimaster nel relativo porta-inserto.
Le chiavi dinamometriche sono calibrate a norma ISO 6789.
Chiave di codifica: MM02-4006
MM02 = a 2 eliche (MM03 = a 3 eliche)
40 = valore di coppia 4 Nm
06 = dimensione dell'inserto

Oltre 10.000 giri al minuto:
Si raccomanda di bilanciare gli utensili e i portautensili almeno separatamente.
Oltre 20.000 giri al minuto:
Sia l'utensile che i portautensili devono essere bilanciati almeno separatamente.
Oltre 30.000 giri al minuto:
Gli utensili e i portautensili devono essere bilanciati come un'unità.
(I giri al minuto massimi riportati nelle tabelle non devono mai essere superati.)

Inserti a 2 eliche

Dimensione dell'inserto	Chiave dinamometrica (inclusa estremità chiave)	Estremità della chiave sostituibile	Valore di coppia
			
MM06	MM02-4006	MM02-06	4 Nm
MM08	MM02-8008	MM02-08	8 Nm
MM10	MM02-1201012	MM02-1012	12 Nm
MM12	MM02-1201012	MM02-1012	12 Nm
MM12 DC = Ø 14,0	MM02-16014	MM02-14	16 Nm
MM12 DCX = Ø 16,0	MM02-1601620	MM02-1620	16 Nm
MM16	MM02-1601620	MM02-1620	16 Nm

Inserti a 3 eliche

Dimensione dell'inserto	Chiave dinamometrica (inclusa estremità chiave)	Estremità della chiave sostituibile	Valore di coppia
			
MM06	MM03-4006	MM03-06	4 Nm
MM08	MM03-8008	MM03-08	8 Nm
MM10	MM03-1201012	MM03-1012	12 Nm
MM12	MM03-1201012	MM03-1012	12 Nm
MM16	MM03-16016	MM03-16	16 Nm



Gruppi materiale Seco – Introduzione

L'idea base della seconda versione dei gruppi materiale Seco è di classificare i materiali in base alla loro tipologia piuttosto che in base alla loro lavorabilità relativa, e di conseguenza contiene anche altri tipi di materiali, come i materiali compositi. Pur essendo una classificazione abbastanza completa, è sempre facile identificare a quale gruppo appartiene uno specifico materiale.
Ciascun gruppo materiale Seco ha uno specifico standard di materiale assegnato come riferimento per consentire una facile regolazione dei parametri di taglio per ogni materiale effettivo rispetto al materiale di riferimento, vedere pagina 676 - 679.
Come esempio, i materiali di riferimento EN C45E per il gruppo P4 e EN 42 CrMo 4 per entrambi i gruppi P5 e H5; vedere ulteriori dettagli sulle tabelle seguenti.
Nella seconda versione della classificazione dei materiali nei gruppi materiale Seco è indicata una condizione standard del materiale assegnata come riferimento per consentire una facile ed univoca regolazione dei parametri di taglio per ogni materiale effettivo rispetto al materiale di riferimento. Come esempi, i materiali di riferimento EN C45E per il gruppo P4 e EN 42 CrMo 4 per entrambi i gruppi P5 e H5 mostrati nella tabella 1 dove sono indicate le proprietà dei materiali di riferimento.

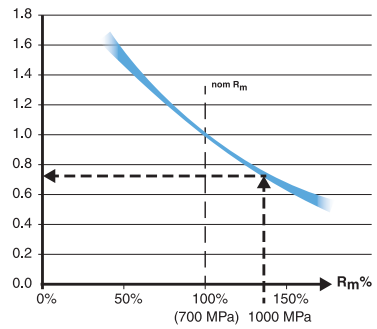
SMG	Descrizione	Proprietà	Riferimento
P4	Acciai da costruzione basso legati, 0,25% < C < 0,67% Acciai da bonifica basso legati	520 < R_m < 1200	C 45E R_m = 660 N/mm²
P5	Acciai da costruzione, 0,25% < C < 0,67% Acciai da bonifica	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm²

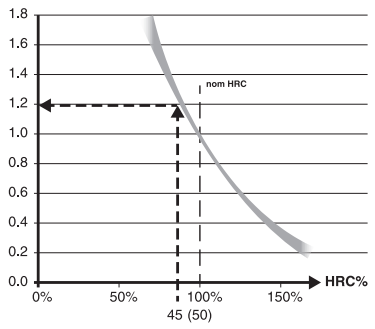
SMG	Descrizione	Proprietà	Riferimento
H5	Acciai bonificati	38 < HRC < 56	42 CrMo 4 50 HRC

Concentrandosi in particolare su EN 42 CrMo 4 allo stato ricotto il carico di rottura R_m può variare in genere tra Rm = 630 N/mm² e R_m = 780 N/mm², fornendo un riferimento per il gruppo materiale P5. Allo stato bonificato, il carico di rottura R_m può tipicamente essere tra R_m = 900 N/mm² e R_m = 1100 N/mm², appartenendo quindi ancora al gruppo P5. Tuttavia, se indurito sopra R_m = 1200 N/mm², appartiene invece al gruppo H5.

SMG	EN	W.-Nr	AFNOR	BS	UNI	JIS	AISI / ASTM	GOST	Condizione	R_{m_nom}	HRC_{nom}
P5	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Ricotto	700	
	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Bonificato	1000	
H5	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Bonificato		45
	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Bonificato		50

L'acciaio bonificato EN 42CrMo4 può essere utilizzato per illustrare la dipendenza della lavorabilità dalle condizioni del materiale.
I grafici sotto riportati indicano come le raccomandazioni relative alla velocità in condizioni e per materiali nominali possono essere regolati in funzione di R_m (diagramma a sinistra valido per ISO-P) ed in funzione di HRC (valido per ISO-H).





Per illustrare ulteriormente come con la nuova versione dei gruppi materiale Seco P5 il valore di v_c nominale può essere calcolato in modo più accurato è necessario conoscere il valore del carico di rottura R_m ed in questo caso utilizziamo EN 42 CrMo 4 bonificato a R_m = 1000 N/mm² secondo la tabella qui sopra (frecce blu in grassetto).
Supponiamo che troviamo che per il gruppo materiale P5 il valore di v_c nominale sia 280 m/min per un determinato prodotto e lavorazione.
Quindi il valore di v_c effettivo consigliato diventa 280 m/min x 0,75 = 210 m/min. Di conseguenza, nel gruppo materiale H5 il valore di v_c nominale può essere regolato utilizzando EN 42 CrMo 4 temprato a 45 HRC (piccole frecce grigie).
Supponiamo che il valore di v_c nominale per il gruppo materiale H5 sia 50 m/min per un determinato prodotto e per una lavorazione con inserti in metallo duro rivestito; quindi il valore di v_c effettivo diventa 50 m/min x 1,2 = 60 m/min. Per dettagli ulteriori sul materiale da lavorare, vedere pagina(e) 680-687, mentre per i parametri di taglio consigliati, vedere le relative pagine.

Per una gestione più comoda dei parametri di taglio si consiglia l'utilizzo degli strumenti disponibili su www.secotools.com alla sezione My Pages - Suggest.

Acciai, acciai inossidabili ferritici e martensitici

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
P1	Acciai automatici	360 < R_m < 880	11 SMn30 R_m = 385 N/mm^2	1500	0,14
P2	Acciai basso legati, C < 0,25% Acciai da costruzione saldabili basso legati	320 < R_m < 600	S235JRG2 R_m = 420 N/mm^2	1600	0,23
P3	Acciai ferritici e ferritico-perlitici, C < 0,25% Acciai da costruzione saldabili Acciai da cementazione	430 < R_m < 610	16 MnCr 5 R_m = 550 N/mm^2	1800	0,14
P4	Acciai da costruzione basso legati, 0,25% < C < 0,67% Acciai da bonifica basso legati	520 < R_m < 1200	C 45E R_m = 660 N/mm^2	2000	0,15
P5	Acciai da costruzione, 0,25% < C < 0,67% Acciai da bonifica	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm^2	2020	0,18
P6	Acciai basso legati per tempra a cuore, C > 0,67% Acciai basso legati per molle e cuscinetti	520 < R_m < 1200	C 100S R_m = 600 N/mm^2	2100	0,17
P7	Acciai per tempra a cuore, C > 0,67% Acciai per molle e cuscinetti	600 < R_m < 1200	100 Cr 6 R_m = 650 N/mm^2	2160	0,17
P8	Acciai da utensili Acciai super-rapidi (HSS)	600 < R_m < 1200	X 40 CrMoV 5 1 R_m = 700 N/mm^2	2400	0,20
P11	Acciai inossidabili ferritici e martensitici	415 < R_m < 1200	X 20 Cr 13 R_m = 675 N/mm^2	2000	0,15
P12	Acciai inossidabili maraging e per indurimento per precipitazione	500 < R_m < 1200	X 5 CrNiCuNb 16 4 R_m = 1100 N/mm^2	2100	0,17

Acciai inossidabili automatici, austenitici e duplex

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
M1	Acciai inossidabili austenitici automatici		X 10 CrNiS 18 9	1700	0,14
M2	Acciai inossidabili austenitici con contenuto di elementi in lega basso		X 5 CrNi 18 10	1920	0,18
M3	Acciai inossidabili austenitici con contenuto di elementi in lega medio		X 2 CrNiMo 18 14 3	2070	0,17
M4	Acciai inossidabili austenitici con contenuto di elementi in lega alto ed acciai inossidabili duplex		X 2 CrNiMoN 22 5 3	2230	0,16
M5	Acciai inossidabili austenitici con contenuto di elementi in lega alto ed acciai inossidabili duplex, di difficile lavorabilità		X 2 CrNiMoN 25 7 4	2510	0,13

Ghise

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
K1	Ghise grigie		EN-GJL-250	930	0,32
K2	Ghise a grafite compatta		EN-GJV-400	1000	0,35
K3	Ghise malleabili		EN-GJMB-550-4	1050	0,37
K4	Ghise sferoidali (nodulari)		EN-GJS-500-7	1160	0,37
K5	Ghise austemperate		EN-GJS-1000-5		
K6	Ghise austenitiche lamellari		EN-GJLA-XNiCuCr15-6-2		
K7	Ghise austenitiche sferoidali (nodulari)		EN-GJSA-XNiMn23-4		

Materiali non ferrosi

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
N1	Leghe di alluminio, Si < 9%		AW-7075		
N2	Leghe di alluminio, 9% < Si < 16%		AC-44200 Si = 12%		
N3	Leghe di alluminio, Si >16%		AlSi17Cu5		
N11	Leghe di rame		CW614N	740	0,26

Superleghe e titanio

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
S1	Superleghe a base ferro		Discalloy		
S2	Superleghe a base cobalto		Stellite 21		
S3	Superleghe a base nichel		Inconel 718	2530	0,21
S11	Titanio, basso legato, (α)		Ti		
S12	Titanio, medio legato, (α+β)		TiAl6V4	1500	0,24
S13	Titanio, alto legato, (“quasi β” e β)		Ti10V2Fe3Al		

Materiali ad elevata durezza

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
H3	Acciai induriti superficialmente	58 < HRC < 62	16 MnCr 5 60 HRC	2070	0,14
H5	Acciai bonificati	38 < HRC < 56	42 CrMo 4 50 HRC	2320	0,18
H7	Acciai bonificati Acciai per cuscinetti	56 < HRC < 64	100 Cr 6 60 HRC	2480	0,17
H8	Acciai da utensili Acciai super-rapidi (HSS)	38 < HRC < 64	X 40 CrMoV 5 1 50 HRC	2750	0,20
H11	Acciai inossidabili martensitici	38 < HRC < 50	X 20 Cr 13 45 HRC	2300	0,15
H12	Acciai inossidabili maraged ed induriti per precipitazione	1200 < R_m < 1650	X 5 CrNiCuNb 16 4 R_m = 1450 N/mm^2	2410	0,17
H21	Acciai al manganese	23 < HRC < 64	X 120 Mn 12 50 HRC		
H31	Ghise bianche	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC		

Altri materiali di difficile lavorabilità

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
PM1	Materiali da metallurgia delle polveri con contenuto di elementi in lega basso		F-0008 Fe-0.7C		
PM2	Materiali da metallurgia delle polveri con contenuto di elementi in lega medio		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C		
PM3	Materiali da metallurgia delle polveri con contenuto di elementi in lega alto Materiali per sedi valvole di scarico				
HF1	Leghe per riporti duri Riporto di leghe a base ferro mediante saldatura o plasma				
HF2	Leghe per riporti duri Riporto di leghe a base cobalto o nichel mediante saldatura o plasma				
CC1	Metallo duro		G50		

Plastiche e materiali compositi

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
TS1	Polimeri termoindurenti		Urea formaldeide (UF)		
TS2	Compositi di resina termoindurente rinforzata con fibra di carbonio		T300 T700 T800 HTA-S IMA - Resina epossidica (M21)...		
TS3	Compositi di resina termoindurente rinforzata con fibra di vetro		Resina epossidica - HX..(42..)/ vetro E (7781...)...		
TS4	Compositi di resina termoindurente rinforzata con fibra aramidica		Kevlar 49		
TP1	Polimeri termoplastici		Policarbonato (PC)		
TP2	Compositi di resina termoplastica rinforzata con fibra di carbonio		PPS/PEEK - T300..		
TP3	Compositi di resina termoplastica rinforzata con fibra di vetro		PPS/PEEK - vetro E o A...		
TP4	Compositi di resina termoplastica rinforzata con fibra aramidica				

Grafite

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
GR1	Grafite		R 8500		

SMG

Grup-po mate-riale Seco	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
	11 SMn 30	1.0715	1.0715	9 SMn 28	S 250	230 M 07	CF 9 SMn 28	SUM 22	1912	G12130
	11 SMnPb 30	1.0718	1.0718	9 SMnPb 28	S 250 Pb		CF 9 SMnPb 28	SUM 22 L	1914	G12134
	10 S 20	1.0721	1.0721	10 S 20	10 F 1	210 M 15	CF 10 S 20			
			1.0722	10 SPb 20	10 PbF 2		CF 10 SPb 20			
P1	15 SMn 13	1.0725	1.0723	15 S 20		210 A 15		SUM 32	1922	
	35 S20	1.0726	1.0726	35 S 20	35 MF 4	212 M 36			1957	G11400
	46 S20	1.0727	1.0727	46 S 20	45 MF 4	212 M 44			1973	G11460
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	S235JR	1.0037	1.0037	St 37-2	E 24-2		Fe 360 B	STKM 12 C	1311	
	S235JRG2	1.0038	1.0116	St 37-3	E 24-3, E 24-4	4360-40 C	Fe 360 D FF		1312, 1313	
	S275J2G3	1.0144	1.0144	St 44-3 N	E 28-3, E 28-4	4360-43 C	Fe 430 D FF	SM 41 C	1412, 1414	
	C 10	1.0301	1.0301	C 10	34 C 10, XC 10	045 M 10	C 10	S 10 C		G10100
P2			1.0401	C 15	37 C 12, XC 18	080 M 15	C 15, C 16		1350	G10170
	C22	1.0402	1.0402	C 22	C 20	050 A 20	C 20, C 21		1450	G10200
	S355JR	1.0570	1.0570	St 52-3	E 36-3, E 36-4	4360-50 C	Fe 510 B	SM 50 YA	2172, 2132	
	C 15R	1.1141	1.1141	Ck 15	XC 15, XC 18	080 M 15	C 15, C 16	S 15 C, S 15 CK	1370	G10170
			1.1158	Ck 25	XC 25	060 A 25	C 25	S 25 C		G10250
			1.2162	21 MnCr 5	20 NC 5			SCR 420 H		
	16 Mo 3	1.5415	1.5415	15 Mo 3	15 D 3	1501-240	16 Mo 3		2912	
			1.5423	16 Mo 5		1503-245-420	16 Mo 5	SB 450 M		G45200
	14 NiCr 14	1.5752	1.5752	14 NiCr 14	12 NC 15	655 M 13		SNC 815 (H)		G33106
			1.5919	15 CrNi 6	16 NC 6	S 107	16 CrNi 4			
	18 NiCrMo 7 6	1.6587	1.6587	18 CrNiMo 7 6	18 NCD 6	820 A 16	18 NiCrMo 7			
P3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
	16 MnCrS 5	1.7139	1.7139	16 MnCrS 5						
	20 MnCr 5	1.7147	1.7147	20 MnCr 5	20 MC 5		20 MnCr 5	SMnC 420 (H)		G51200
	20 MnCrS 5	1.7149	1.7149	20 MnCrS 5	20 MnCrS 5			SMnC 21 H		
	13 CrMo 4 5	1.7335	1.7335	13 CrMo 4 4	15 CD 3.5	1501-620 Gr. 27	14 CrMo 4 5		2216	
			1.7337	16 CrMo 4 4	15 CD 4.5	1501-620 Gr. 27	14 CrMo 4 5		2216	
	10 CrMo 9 10	1.7380	1.7380	10 CrMo 9 10	10 CD 9.10	1501-622 Gr. 31	12 CrMo 9 10		2218	J21890
	C35		1.0501	C 35	55 C 35	060 A 35	C 35		1550	G10350
	E 335	1.0503	1.0503	C 45	65 C 45	80 M 46	C 45	S 45 C	1650	G10430
	C40		1.0511	C 40	60 C 40	080 M 40	C 40	S 40 C		
	E 360	1.0070	1.0535	St 70-2	A 70-2		Fe 690		1655	
	C60	1.0601	1.0601	C 60	CC 55	080 A 62	C 60			G10600
P4			1.1157	40 Mn 4	35 M 5	150 M 36				G10390
	G 28 Mn6	1.1165	1.1165	30 Mn 5		120 M 36		SMn 1 H, SCMn 2		G13300
	C 35E	1.1181	1.1181	Ck 35	XC 38 H1	080 M 36	C 35	S 35 C	1572	G10340
	C 45E	1.1191	1.1191	Ck 45	XC 42	080 M 46	C 45	S 45 C	1672	G10420
	C 60E	1.1221	1.1221	Ck 60	XC 60	080 A 62	C 60	S 58 C	1665, 1678	G10640
			1.1740	C 60 W	Y3 55			SK 7		
	55 SiCr7	1.7100	1.0904	55 Si 7	55 S 7	250 A 53	55 Si 8		2085, 2090	
			1.2330	35 CrMo 4	34 CD 4	708 A 37	35 CrMo 4		2234	T51620
			1.2542	45 WCrV 7		BS 1	45 WCrV 8 KU		2710	T41901
		1.2714	1.2714	56 NiCrMoV 7		BH 224-5	56 NiCrMoV7-KU	SKT 4		T61206
			1.5121	46 MnSi 4						
			1.5710	36 NiCr 6	35 NC 6	640 A 35		SNC 236		
			1.5736	36 NiCr 10	35 NC 11		35 NiCr 9	SNC 631 (H)		
	36 CrNiMo 4		1.6511	36 CrNiMo 4	40 NCD 3	816 M 40	38 NiCrMo 4 (KB)			G98400
P5	34 CrNiMo 6	1.6582	1.6582	34 CrNiMo 6	35 NCD 6	817 M 40	35 NiCrMo 6 (KW)	SNCM 447	2541	G43400
	34 Cr 4	1.7033	1.7033	34 Cr 4	32 C 4	530 A 32	34 Cr 4 (KB)	SCR 430 (H)		G51320
	41 Cr 4	1.7035	1.7035	41 Cr 4	42 C 4	530 M 40	41 Cr 4	SCR 440 (H)		G51400
	25 CrMo 4	1.7218	1.7218	25 CrMo 4	25 CD 4 S	708 M 25	25 CrMo 4 (KB)	SCM 425	2225	G41300
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
			1.7361	32 CrMo 12	30 CD 12	722 M 24	32 CrMo 12		2240	
	50 CrV 4	1.8159	1.8159	50 CrV 4	50 CV 4	735 A 50	51 CrV 4	SUP 10	2230	H61500
	41 CrAlMo 7 10	1.8509	1.8509	41 CrAlMo 7	40 CAD 6.12	905 M 39	41 CrAlMo 7	SACM 645	2940	K24065
	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
P6	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.1645	C 105 W2	Y1 105		C 100 KU	SK 3		
			1.1663	C 125 W	Y2 120		C 120 KU	SK 2		

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Marchi misti	Condizione	Struttura
	1213				Ricotto	
	12 L 13				Ricotto	
	1108				Ricotto	
	11 L 08				Ricotto	
					Ricotto	
	1140	40			Ricotto	
	1146				Ricotto	
	1215				Ricotto	
	12 L 14				Ricotto	
		16D			Ricotto	
	A573 Grade 58	18kp	11 378		Ricotto	
	A573 Grade 70	St14kP	11 448		Ricotto	
	1010	10			Ricotto	
F.1110	1015	15			Ricotto	
	1020, 1023	20	12 024		Ricotto	
		17G1S	11 523		Ricotto	
F.1511	1015	15			Ricotto	
F.1120	1025	25			Ricotto	
					Ricotto	
	A204 Grade A		15 020		Ricotto	
	4520				Ricotto	
	3310, 9314	20X2H4A	16 420		Ricotto	
	4320		16 220		Ricotto	
					Ricotto	
F.1516	5115	12KHN2	14 220		Ricotto	
		18HG			Ricotto	
	5120	20KH	14 221		Ricotto	
	5120 H	20KH			Ricotto	
	A182-F11, A182-F12	12KHM	15 121		Ricotto	
	A387 Grade 12 Cl. 2				Ricotto	
F.155	A182-F22	12KH8	15 313		Ricotto	
F.1130	1035	35	12 040		Ricotto	
F.5110	1045	45	12 050		Ricotto	
	1040	40	12 041		Ricotto	
F.1150	1055	55			Ricotto	
	1060	60	12 061		Ricotto	
	1039	40G			Ricotto	
	1330	30G2			Ricotto	
F.1135	1035	35			Ricotto	
F.1140	1045	45	12 050		Ricotto	
F.1150	1064	60			Ricotto	
	1060	60			Ricotto	
F.144	9255	55S2			Ricotto	
F.1250	4135	35KHM			Ricotto	
F.5241	S1	5KHV2S			Ricotto	
	L6	5KHNV			Ricotto	
	5045				Ricotto	
	3135				Bonificato	
	3435				Ricotto	
	9840				Bonificato	
F.1280	4340	38H2N2MA	16 343		Ricotto	
	5132	35KH			Bonificato	
	5140	40H	14 140		Bonificato	
F.1251	4130	20KHM	15 130		Bonificato	
F.1252	4142, 4140	38HM	15 142		Ricotto	
F.1252	4142, 4140	38HM	15 142		Bonificato	
					Bonificato	
F.143	6150	50KHFA	15 260		Bonificato	
F.1740	A355 Cl. A				Ricotto	
F.5103	1070	70			Ricotto	
F.5117	1095				Ricotto	
F.5118	W1	U10A			Ricotto	
		U10			Ricotto	
	W1	U13			Ricotto	

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
P7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
P8	X 210 Cr 12	1.2080	1.2080	X 210 Cr 12	Z 200 C 12	BD 3	X 210 Cr 13 KU	SKD 1		T30403
			1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	BH 11	X 37 CrMoV 5 1 KU	SKD 6		T20811
	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
			1.2365	X 32 CrMoV 3 3	32 DCV 28	BH 10	30 CrMoV 12 27 KU	SKD 7		T20810
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-1-2-5	1.3255	1.3255	S 18-1-2-5	Z 80 WKCV 18-05-04-01	BT 4	HS 18-1-1-5	SKH 3		T12004
	HS 6-5-2	1.3343	1.3343	S 6-5-2	Z 85 WDCV 06-05-04-02	BM 2	HS 6-5-2	SKH 9, SKH 51	2722	T11302
	HS 2-9-2	1.3348	1.3348	S 2-9-2	Z 100 DCWV 09-04-02-02		HS 2-9-2	SKH 58	2782	T11307
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
P11	X 6 Cr 13	1.4000	1.4000	X 6 Cr 13	Z 6 C 12	403 S 17	X 6 Cr 13	SUS 403	2301	S41008
	X 12 Cr 13	1.4006	1.4006	X 10 Cr 13	Z 10 C 13	410 S 21	X 12 Cr 13	SUS 410	2302	S41000
	X 6 Cr 17	1.4016	1.4016	X 6 Cr 17	Z 8 C 17	430 S 15	X 8 Cr 17	SUS 430	2320	S43000
	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 39 Cr 13	1.4031	1.4031	X 40 Cr 13	Z 40 C 14	420 S 45	X 40 Cr 14	SUS 420	2304	S40280
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
	X 3 CrNIMo 13 3	1.4313	1.4313	X 5 CrNi 13 4	Z 5 CN 13.4	425 C 11	X 6 CrNi 13 04	SCS 5	2385	S41500
	X 18 CrN 28	1.4749	1.4749	X 18 CrN 28	Z 18 C 25				2322	S44600
P12	X 6 NiCrTiMoV 25 15	1.4534	1.4534	X 3 CrNiMoAl 13 8 2						S13800
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
		1.4540	1.4540	X 4 CrNiCuNb 16 4	Z 4 CNUNb 16.4 M					S15500
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 17 4	1.4548	1.4542	X 5 CrNiCuNb 17 4	Z 6 CNU 17.4			SCS 24, SUS 630		S17400
	X 7 CrNiAl 17 7	1.4564	1.4564	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMo 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
M1	X 10 CrNiS 18 9	1.4305	1.4305	X 10 CrNiS 18 9	Z 10 CNF 18.09	303 S 31	X 10 CrNi 18 09	SUS 303	2346	S30300
M2	X 2 CrNi 19 11	1.4306	1.4306	X 2 CrNi 19 11	Z 2 CN 18.10	304 S 12	X 3 Cr Ni 18 11	SUS 304 L	2352	S30403
	X 5 CrNi 18 10	1.4301	1.4301	X 5 CrNi 18 10	Z 6 CN 18.09	304 S 31	X 5 CrNi 18 11	SUS 304	2333	S30400
	X 5 CrNiMo 17 12 2	1.4401	1.4401	X 5 CrNiMo 17 12 2	Z 3 CND 17.11.1	316 S 31	X 5 CrNiMo 17 12	SUS 316	2347	S31600
	X 6 CrNiNb 18 10	1.4550	1.4550	X 6 CrNiNb 18 10	Z 6 CNNb 18.10	347 S 31	X 6 CrNiNb 18 11	SUS 347	2338	S34700
	X 9 CrNi 18 8	1.4310	1.4310	X 12 CrNi 17 7	Z 12 CN 17.07	301 S 21	X 12 CrNi 17 07	SUS 301	(2331)	S30100
	X 12 CrNi 18 8	1.4300	1.4300	X 12 CrNi 18 8	Z 12 CN 18	302 S 25		SUS 302	2331	S30200
M3	X 2 CrNiMo 18 14 3	1.4435	1.4435	X 2 CrNiMo 18 14 3	Z 2 CND 17.13	316 S 12	X 2 CrNiMo 17 13 2	SCS 16, SUS 316 L	2353	S31603
	X 2 CrNiMoN 17 13 3	1.4429	1.4429	X 2 CrNiMoN 17 13 3	Z 2 CND 17.13 Az	316 S 62	X 2 CrNiMoN 17 13 3	SUS 316 LN	2375	S31653
	X 2 CrNiN 18 10	1.4311	1.4311	X 2 CrNiN 19 11	Z 2 CN 18 .10 Az	304 S 62	X 2 CrNiN 18 11	SUS 304 LN	2371	S30453
	X 3 CrNiMo 18 12 3	1.4466	1.4466	X 5 CrNi 18 15		317 S 16	X 5 CrNi 18 15	SUS 317	2366	S31700
	X 9 CrNiSiNCe 21 11 2	1.4835	1.4893	X 9 CrNiSiNCe 21 11 2		310 S 31			2368	S30815
	X 12 CrNi 25 21	1.4335	1.4335	X 12 CrNi 25 21	Z 12 CN 25.20	310 S 24	X 6 CrNi 26 20	SUH 310, SUS 310 S	2361	S31008
M4	X 2 CrNiMoN 22 5 3	1.4462	1.4462	X 2 CrNiMoN 22 5	Z 2 CND 22.05 Az	332 S 15	X 2 CrNiMoN 22 5		2377	S31803
	X 2 CrNiMoSi 19 5	1.4424	1.4417	X 2 CrNiMoSi 19 5	Z 2 CND 18.05.03				2376	S31500
	X 2 NiCrMoCu 25 20 5	1.4539	1.4539	X 2 NiCrMoCu 25 20 5	Z 2 NCDU 25 20	904 S 13			2562	N08904
	X 3 CrNiMo 27 5 2	1.4460	1.4460	X 4 CrNiMo 27 5 2	Z 3 CND 25.7 Az		X 3 CrNiMo 27 5 2	SUS 329 J 1	2324	S32900
	X 5 CrNiCuNb 16 4	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
M5	X 1 CrNiMoN 20 18 7	1.4547	1.4529	X 1 CrNiMoN 20 18 7	Z 1 CNDU 20.18.05 Az		X 1 CrNiMoN 20 18 7		2778	S31254
	X 1 CrNiMoN 25 22 8	1.4652	1.4652	X 2 CrNiMoN 25 22 7						S32654
	X 10 NiCrAlTi 32 20	1.4876	1.4876	X 10 NiCrAlTi 32 20	Z 10 NC 32.21			NCF 800		N08800
	X 2 CrNiMoN 25 7 4	1.4410	1.4410	X 2 CrNiMoN 25 7 4	Z 3 CND 25.07 Az		X 2 CrNiMoN 25 7 4		2328	S32750

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Marchi misti	Condizione	Struttura
F.520L	L2	11KHF			Ricotto	
F.5220	O1	9KHVG			Ricotto	
	O2	9G2F			Ricotto	
F.5230	52100	SHKH15	14 109		Ricotto	
F.5212	D3	KH12			Ricotto	
	H11	4KH5MFS			Ricotto	
F.5318	H13	4KH5MF1S			Ricotto	
F.5227	A2	9KH5VF			Ricotto	
	H10	3KH3M3F			Ricotto	
F.5213		KH12			Ricotto	
		KH12MF			Ricotto	
F.520.S	L6	5KHNM			Ricotto	
F.5613	M35	R6M5K5			Ricotto	
	M42	R2AM9K5			Ricotto	
	T4	R18K5F2			Ricotto	
F.5603	M2	R6M5			Ricotto	
	M7				Ricotto	
	T1	R18			Ricotto	
	403	08KH13			Ricotto	Ferritico
F.3401	410, CA-15	12KH13, 08KH13			Ricotto	Martensitico
F.3113	430	12KH17			Ricotto	Ferritico
F.5261	420	20KH13	17 022		Ricotto	Martensitico
F.3404	420	40KH13			Ricotto	Martensitico
	440 A				Ricotto	Martensitico
	440 B	95KH18			Ricotto	Martensitico
	440 C	95KH18			Ricotto	Martensitico
	A182 F6NM			F6NM	Ricotto	Martensitico
	446	15KH28			Ricotto	Ferritico
	XM-13			PH 13-8 Mo	Ricotto solubilizzato	Austenitico
	XM-12			15-5 PH	H1150	Martensitico
	XM-12			15-5 PH	Ricotto solubilizzato	Martensitico
	XM-12			15-5 PH	H1025	Martensitico
	SAE 630			17-4 PH	H1150	Martensitico
	630			17-4 PH	Ricotto solubilizzato	Martensitico
	631	09KH17N7YU1		17-7 PH	Ricotto solubilizzato	Austenitico/Ferritico
	AMS 6515			Marage 350	Ricotto solubilizzato	Martensitico
	AMS 6521			Marage 300	Ricotto solubilizzato	Martensitico
	AMS 6514			Marage 300, Vascomax C300	Ricotto solubilizzato	Martensitico
	AMS 6512			Marage 250	Ricotto solubilizzato	Martensitico
	AMS 6512			Marage 250, Vascomax C250	Ricotto solubilizzato	Martensitico
F.3508	303	12KH19N9			Ricotto	Austenitico
F.3504	304 L	03KH18N11			Ricotto	Austenitico
F.3504	304	08KH18N10	17 240		Ricotto	Austenitico
F.3534	316	08KH17H13M2T	17 346		Ricotto	Austenitico
F.3524	347	08KH18N12B			Ricotto	Austenitico
F.3517	301	07KH16N6			Ricotto	Austenitico
	302	12KH18N9			Ricotto	Austenitico
F.3533	(316 L)	03KH17N14M3	17 349		Ricotto	Austenitico
	316 LN	03KH16N15M3			Ricotto	Austenitico
F.3541	304 LN	03KH18N11			Ricotto	Austenitico
	317	08KH17H15M3T			Ricotto	Austenitico
				253 MA	Ricotto	Austenitico
	310 S	12KH25N20			Ricotto	Austenitico
	329 LN			SAF 2205	Ricotto	Duplex
				3RE60	Ricotto	Duplex
	904L				Ricotto	Super austenitico
	329				Ricotto	Duplex
	660			A286	Ricotto solubilizzato	Austenitico
				254 SMO	Ricotto	Super austenitico
				654 SMO	Ricotto	Super austenitico
				Alloy 800	Ricotto	Austenitico
	F 53			SAF 2507	Ricotto	Super duplex

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
	EN-GJL-150	0.6150	0.6150	GG-15	Ft 15 D	Grade 150	G15	FC 150	01 15-00	F11601
	EN-GJL-200	0.6200	0.6200	GG-20	Ft 20 D	Grade 220	G20	FC 200	01 20-00	F12101
K1	EN-GJL-250	0.6250	0.6250	GG-25	Ft 25 D	Grade 260	G25	FC 250	01 25-00	F12401
	EN-GJL-350	0.6350	0.6350	GG-35	Ft 35 D	Grade 350	G35	FC 350	01 35-00	F13502
	EN-GJL-215			GG-220 HB					02 19	
	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
K2	EN-GJV-400			GJV-400						
	EN-GJV-450			GJV-450						
	EN-GJV-500			GJV-500						
K3	EN-GJMB-550-4	0.8155		GTS-55-04	P 540/5	P 540/5	P 55-04	PCMP55-04	08 54-00	F24130
	EN-GJS-350-22	0.7033	0.7033	GGG-35.3	FGS 370-17	Grade 350/22		FCD 350-22L	07 17-15	
	EN-GJS-400-15	0.7040	0.7040	GGG-40	FGS 400-12	Grade 420/12	GS 400-12	FCD 400-18L	07 17-02	F32800
K4	EN-GJS-400-18	0.7043	0.7043	GGG-40.3	FGS 370-17	Grade 370/17	GSO 42/17		07 17-12	F32800
	EN-GJS-500-7	0.7050	0.7050	GGG-50	FGS 500-7	Grade 500/7	GS 500-7	FCD 500-7	07 27-02	F33800
	EN-GJS-600-3	0.7060	0.7060	GGG-60	FGS 600-3	Grade 600/3	GS 600-3	FCD 600-3	07 32-03	F34100
	EN-GJS-700-2	0.7070	0.7070	GGG-70	FGS 700-2	Grade 700/2	GS 700-2	FCD 700-2	07 37-01	F34800
										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
K5	EN-GJS-1200-2			GJS-1200-2						ADI grade 3
	EN-GJS-1400-1			GJS-1400-1						ADI grade 4
	EN-GJS-800-8			GJS-800-8						ADI grade 1
	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002
K6	EN-GJLA-XNiCr 30-3	0.6676	0.6676	GGL-NiCr 30 3	FGL Ni30 Cr3	Grade F3				F41004
	EN-GJLA-XNiCuCr 15-6-2	0.6655	0.6655	GGL-NiCuCr 15 6 2	FGL Ni15 Cu6 Cr2	Grade F1				F41000
	EN-GJSA-XNiMn 13-7	0.7652	0.7652	GGG-NiMn 13 7	FGS Ni13 Mn7	Grade S6			07 72-00	
	EN-GJSA-XNiCr 20-2	0.7660	0.7660	GGG-NiCr 20 2	FGS Ni20 Cr2	Grade S2				F43000
K7	EN-GJSA-XNiMn 23-4	0.7673	0.7673	GGG-NiMn 23 4	FGS Ni23 Mn4	Grade S2M				F43010
	EN-GJSA-XNiCr 30-3	0.7676	0.7676	GGG-NiCr 30 3	FGS Ni30 Cr3	Grade S3				F43003
	EN-GJSA-XNi 35	0.7683	0.7683	GGG-Ni 35	FGS Ni35					F43006
	AW-1050A	Al99.5	3.0255	Al99.5	A-5/1050A	1B		(A1050)	4007	AA1050A
	AW-2011	AlCuBiPb	3.1655	AlCuBiPb	A-U5PbBi/2011	FC1		A2011	4355	AA2011
	AW-2014	AlCuSiMn	3.1255	AlCuSiMn	A-U4SG/2014	H15			4338	AA2014
	AW-5005	AlMg1	3.3315	AlMg1	A-G0.6	N41			4106	AA5005
	AW-6060	AlMgSi0.5	3.3206	AlMgSi0.5	A-GS/6060	(H9)			4103	AA6060
	AW-6063	AlMgSi0.7	3.3210	AlMgSi0.7	A-GSUC/6061	(H10)		(A6063)	4104, 4107	AA6005
	AW-3103	AlMn1	3.0515	AlMn1		N3			4054	AA3103
N1	AW-3003	AlMn1Cu	3.0517	AlMn1Cu	A-M1/3003			A3003		AA3003
	AW-7020	AlZn4.5Mg1	3.4335	AlZn4.5Mg1	A-Z5G/7020	H17			4425	AA7020
	AW-7075		3.4365	AlZnMgCu1.5	A-Z5GU/7075	2L95/2L96		A7075		AA7075
	AC-42000		3.2341	G-AlSi5Mg	A-S7G	LM25	3599	AC 4C	4244	
	AC-46200	AlSi8Cu3(Si)	3.2161	G-AlSi8Cu3					4251	A13800
	MG-P-63	MgAl6Zn	3.5612	G-MgAl6Zn	G-A6-Z1	MAG-E-121				M11600
	MG-P-61	MgAl8Zn	3.5812	G-MgAl8Zn	(G-A7-Z1)					
	MN65120	MgSe3Zn2Zr1	3.5103	G-MgSe3Zn2Zr1	ZRE1	MAG6-TE				M12330
	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
N2	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
	CC331G		2.0940.01	CuAl10Fe	CuAl10Fe	AB1			5710	C95200
	CC333G		2.0975.01	CuAl10Ni	CuAl10Ni5Fe5	AB2			5716	C95500
		CuNi10Fe1Mn	2.0872	CuNi10Fe1Mn	CuNi10Fe1Mn	CN102			5667	C70600
				CuNi10Zn45						
		CW408J	2.0790	CuNi18Zn19Pb	CuNi18Zn19Pb1					C76300
	CW352H		2.1176	CuPb10Sn	CuSn10Pb10	LB2			5640	C93700
	CC480K		2.1050.01	CuSn10	CuSn10	CT1			5443	C90700
N11			2.1087	CuSn10Zn					5458	C90500
	CW452K	CuSn6	2.1020	CuSn6	CuSn6	PB103		C5191	5428	C51900
	CW502L	CuZn15	2.0240	CuZn15	CuZn15	CZ102		C2300	5112	C23000
	CW706R	CuZn28Sn1	2.0470	CuZn28Sn1	CuZn29Sn1				5220	C44300
	CW508L	CuZn37	2.0321	CuZn37	CuZn37	CZ108			5150	C27200
	CW717R	CuZn38Sn1	2.0530	CuZn38Sn1						C46400
	CW614N	CuZn39Pb3	2.0401	CuZn39Pb3	CuZn39Pb3	CZ121			5170	C38500
	CW612N	CuZn40Pb2	2.0402	CuZn40Pb2	CuZn39Pb2	CZ120			5168	C37800
	CW622N	CuZn44Pb2	2.0410	CuZn44Pb2		CZ104			5272	C68700

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Marchi misti	Condizione	Struttura
	A48 25 B	Sc 15	422 415			Ghisa grigia
	A48 30 B	Sc 20	422 420			Ghisa grigia
	A48 35 B	Sc 25	422 425			Ghisa grigia
	A48 50 B	Sc 35				Ghisa grigia
	G 3500					Ghisa grigia
	Grade 350					Ghisa a grafite compatta
	Grade 400					Ghisa a grafite compatta
	Grade 400-15					Ghisa a grafite compatta
	Grade 450					Ghisa a grafite compatta
	Grade 500					Ghisa a grafite compatta
	A220 60004				Rinvenuto	Ghisa malleabile
						Ghisa sferoidale (nodulare)
FGE 38-17	60-40-18	Vc 42-12	422 304			Ghisa sferoidale (nodulare)
	60-40-18	Vc 42-12				Ghisa sferoidale (nodulare)
FGE 50-7	A536, 80-55-06	Vc 50-2	422 305			Ghisa sferoidale (nodulare)
FGE 60-2	A476, 80-60-03	Vc 60-2	422 306			Ghisa sferoidale (nodulare)
FGE 70-2	A536, 100-70-03	Vc 70-2				Ghisa sferoidale (nodulare)
	1600/1300/-					Ghisa austemperata
	1050/700/7					Ghisa austemperata
	1200/850/4					Ghisa austemperata
	1400/1100/1					Ghisa austemperata
	850/550/10					Ghisa austemperata
	A436 Type 2			Ni-Resist 2		Ghisa austenitica lamellare
	A436 Type 3			Ni-Resist 3		Ghisa austenitica lamellare
	A436 Type 1			Ni-Resist 1		Ghisa austenitica lamellare
				Nodumag		Ghisa austenitica sferoidale (nodulare)
	A436 Type D-2			Ni-Resist D-2		Ghisa austenitica sferoidale (nodulare)
	A439 Type D-2M			Ni-Resist D-2M		Ghisa austenitica sferoidale (nodulare)
	A436 Type D-3			Ni-Resist D-3		Ghisa austenitica sferoidale (nodulare)
	A439 Type D-5			Ni-Resist D-5		Ghisa austenitica sferoidale (nodulare)
	B26					
	A380					
	AZ61A					
	AZ80A					
	AMS 4442					
	B85					
	A413.2					
	B390.0					
	CA952	BrA9ZH3L				
	CA955	BrA10ZH4N4L				
	CA937					
		BrOF6.5-0.15				
		L90				
		LOMsh70-1-0.05				
		LO60-1				
		LAMsh77-2-0.05				

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
S1										
S2										
S3	NiMo30		2.4810							N10002
	NiMo16Cr15W		2.4819							N10276
	NiCr19Fe19Nb5Mo3		2.4668							N07718
			2.4669							N07750
	NiCr20TiAl		2.4631							N07080
	NiCr19Co18Mo4Ti3Al3									N07500
	NiCr20Co13Mo4Ti3Al		2.4654							N07001
S11			3.7024							
										R54620
S12										R56320
	TiAl6V4		3.7164							R56400
S13				TiV10Fe2Al3						
H3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
H5	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 75S	1.1248	1.1248	Ck 75	XC 75	060 A 78	C 75		1774, 1778	G10780
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.2550	60 WCrV 7	55 WC 20		55 WCrV 8 KU			
	55 Cr 3	1.7176	1.7176	55 Cr 3	55 C 3	527 A 60	55 Cr 3	SUP 9 (A)	2253	G51550
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
H7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
H8	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
	X 155 CrVMo 12 1		1.2379	X 155 CrVMo 12 1	Z 160 CDV 12	BD 2	X 155 CrVMo 12 1 KU	SKD 11		T30402
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
H11	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
H12	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 7 CrNiAl 17 7	1.4568	1.4568	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 8 CrNiMoAl 15 7 5	1.4574	1.4574	X 8 CrNiMoAl 15 7 5						S15700
	X 6 NiCrTiMoV 25 15	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
H21	X 120 Mn 12	1.3401	1.3401	X 120 Mn 12	Z 120 M 12	BW 10		SC MnH 1	2183	
H31	EN-GJN-HV520	0.9620	0.9620	G-X330 NiCr 4 2	FB Ni4 Cr2 BC	Grade 2 A			05 12-00	F45001
	EN-GJN-HV550	0.9625	0.9625	G-X260 NiCr 4 2	FB Ni4 Cr2 HC	Grade 2 B			05 13-00	F45000
	EN-GJN-HV600(XCr11)	0.9630	0.9630	G-X300 CrNiSi 9 5 2	FB Cr9 Ni5	Grade 2 C, D, E			04 57-00	F45003

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Marchi misti	Condizione	Struttura
				Discalloy	Indurito per precipitazione	
				Haynes 25		
				Stellite 21		
				Hastelloy C		
		KHN65MV		Hastelloy C-276		
				IN 100		
				Inconel 718		
				Inconel X-750	Ricotto solubilizzato	
				Nimonic 80A		
				René 41		
				Udimet 500		
				Waspalloy		
				Ti	Commercialmente puro	Ti (α)
	AMS 4919			Ti 6-2-4-2	Ricotto	Ti (α)
	AMS 4943			Ti 3Al-2.5V (grd 9)	Ricotto	Ti (α+β)
	AMS 4920, Grade 5	VT6		Ti 6Al-4V	Ricotto	Ti (α+β)
	AMS 4986			Ti 10V-2Fe-3Al	Ricotto	Ti (β)
F.1516	5115	12KHN2	14 220		Indurito superficialmente	
F.5103	1070	70			Bonificato	
F.5107	1078, 1080	75			Bonificato	
F.5117	1095				Bonificato	
F.5118	W1	U10A			Bonificato	
	S1	5KHV2SF			Bonificato	
	5155				Bonificato	
F.1252	4142, 4140	38HM	15 142		Bonificato	
F.520L	L2	11KHF			Bonificato	
F.5220	O1	9KHVG			Bonificato	
	O2	9G2F			Bonificato	
F.5230	52100	SHKH15	14 109		Bonificato	
F.5318	H13	4KH5MF1S			Bonificato	
F.5227	A2	9KH5VF			Bonificato	
F.5211	D2	KH12MF			Bonificato	
F.5213		KH12			Bonificato	
		KH12MF			Bonificato	
F.520.S	L6	5KHNM			Bonificato	
F.5613	M35	R6M5K5			Bonificato	
	M42	R2AM9K5			Bonificato	
	T1	R18			Bonificato	
F.5261	420	20KH13	17 022		Bonificato	Martensitico
	440 A				Bonificato	Martensitico
	440 B	95KH18			Bonificato	Martensitico
	440 C	95KH18			Bonificato	Martensitico
	XM-12			15-5 PH	H900	Martensitico
	SAE 630			17-4 PH	H1025	Martensitico
	SAE 630			17-4 PH	H900	Martensitico
	AMS 5528	09KH17N7YU1		17-7 PH	TH1050	Martensitico
	632			PH 15-7 Mo	TH1050	Martensitico
	660			A286	Indurito per precipitazione	Austenitico
	AMS 6512			Marage 250	Indurito per precipitazione	Martensitico
	AMS 6521			Marage 300	Indurito per precipitazione	Martensitico
	AMS 6521			Marage 300	Indurito per precipitazione	Martensitico
	AMS 6515			Marage 350	Indurito per precipitazione	Martensitico
	A128 Grade A			Hadfield		
	A532 IB (NiCr-LC)			Ni-Hard 2		Ghisa bianca
	A532 IA (NiCr-HC)			Ni-Hard 1		Ghisa bianca
	A532 ID (Ni-HiCr)			Ni-Hard 4		Ghisa bianca

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