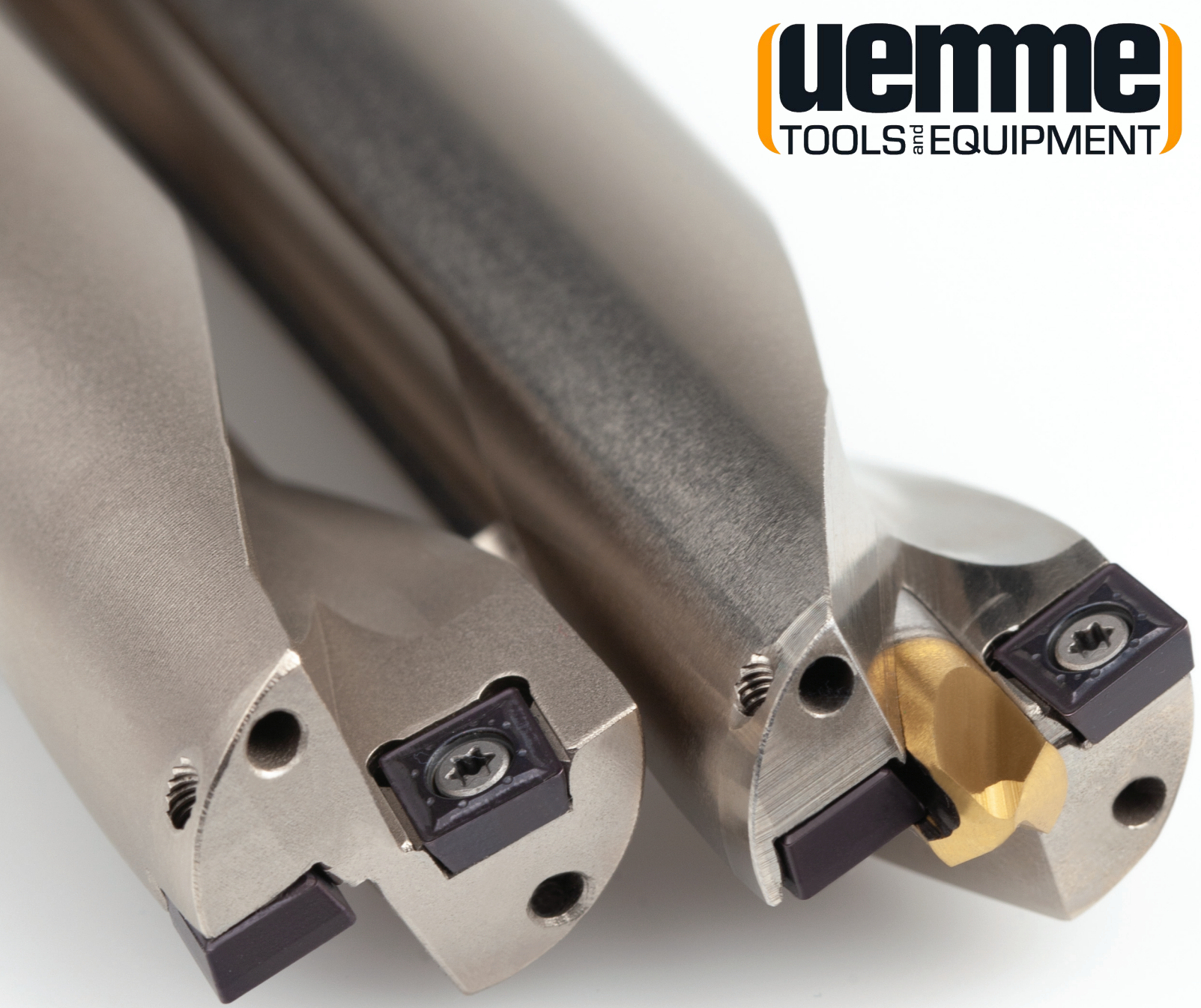




DRSSYSTEM

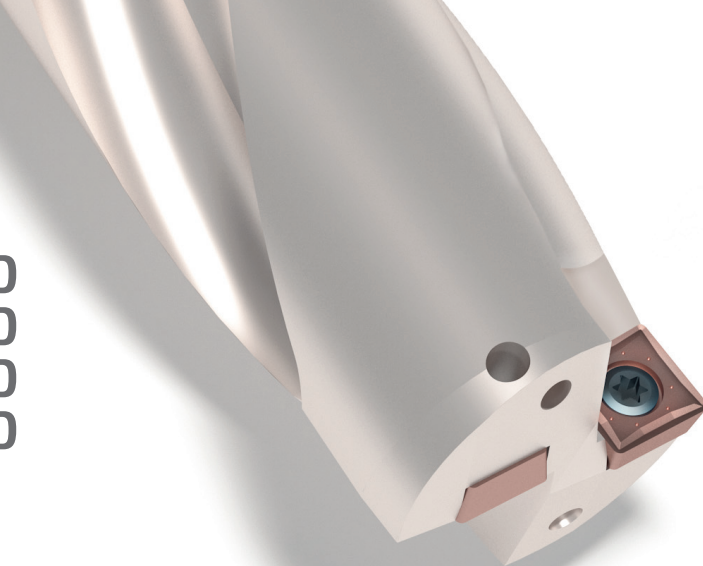
Ampia gamma di soluzioni per la foratura

2XD - 3XD
4XD - 5XD
6XD - 9XD

DRSDRILL

2XD
3XD
4XD
5XD

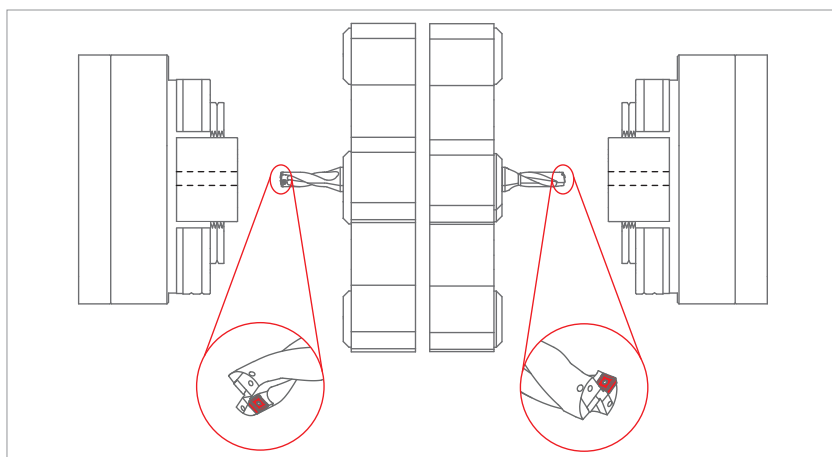
Punte ad alte prestazioni per uso universale



1. Quando è applicabile la punta DRSDRILL?

SUPERFICIE PIANA	SUPERFICIE CONCAVA	SUPERFICIE INCLINATA	MEZZI FORI	ESPANSIONE FORI	TUBI	FORATURA A PACCO

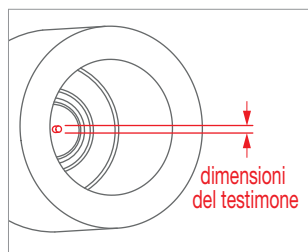
2. Montaggio su tornio



Si raccomanda di posizionare l'inserto esterno in modo che sia rivolto verso l'operatore come mostrato nel disegno, sia sul mandrino che sul contromandrino, per ottenere le migliori prestazioni.

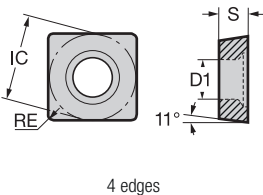
Seguendo queste istruzioni, generalmente l'inserto interno sarà posizionato sotto il centro, che è la situazione raccomandata per ottenere le migliori prestazioni

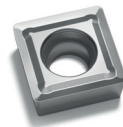
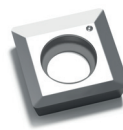
3. Controllo rapido dell'altezza del centro



Per verificare che l'asse della macchina sia allineato correttamente, si dovrà eseguire un foro di test per controllare la porzione di testimone rimanente sul fondo del foro.

Un aggiustamento dell'altezza del centro è necessario quando non rimane alcun testimone o il diametro del testimone è maggiore di 1mm.

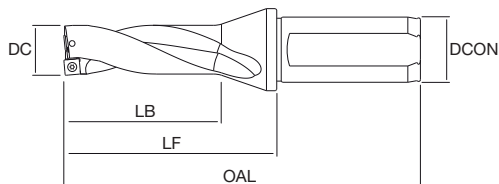
SP□X		DRS inserti a 4 taglienti					ISO513	HC-PVD		HW																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																		
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GENERALE		GP P M K S	SPMX	050204-GP	2xD	f _n ▶ 0.04	0.08	0.12													
					3xD	f _n ▶ 0.04	0.07	0.10	●	●	●										
					4xD	f _n ▶ 0.04	0.06	0.08													
					5xD	f _n ▶ 0.04	0.05	0.06													
		SPMX	060204-GP	2xD	f _n ▶ 0.06	0.10	0.14														
				3xD	f _n ▶ 0.06	0.09	0.12	●	●	●											
				4xD	f _n ▶ 0.05	0.07	0.10														
				5xD	f _n ▶ 0.04	0.06	0.08														
		SPMX	07T308-GP	2xD	f _n ▶ 0.06	0.11	0.16														
				3xD	f _n ▶ 0.06	0.10	0.14	●	●	●											
				4xD	f _n ▶ 0.06	0.09	0.12														
				5xD	f _n ▶ 0.05	0.07	0.09														
		SPMX	090408-GP	2xD	f _n ▶ 0.08	0.14	0.20														
				3xD	f _n ▶ 0.08	0.13	0.18	●	●	●											
				4xD	f _n ▶ 0.06	0.11	0.16														
	5xD			f _n ▶ 0.06	0.09	0.12															
	SPMX	110408-GP	2xD	f _n ▶ 0.08	0.15	0.22															
			3xD	f _n ▶ 0.08	0.14	0.20	●	●	●												
			4xD	f _n ▶ 0.07	0.12	0.18															
			5xD	f _n ▶ 0.06	0.12	0.16															
SPMX	140512-GP	2xD	f _n ▶ 0.10	0.17	0.24																
		3xD	f _n ▶ 0.10	0.16	0.22	●	●	●													
		4xD	f _n ▶ 0.08	0.14	0.20																
		5xD	f _n ▶ 0.07	0.12	0.18																
ALLUMINIO		AL N	SPGX	050204-AL	2xD	f _n ▶ 0.06	0.09	0.12													
					3xD	f _n ▶ 0.06	0.09	0.12													
					4xD	f _n ▶ 0.04	0.07	0.10					●								
					5xD	f _n ▶ 0.04	0.06	0.08													
			SPGX	060204-AL	2xD	f _n ▶ 0.08	0.12	0.16													
					3xD	f _n ▶ 0.08	0.12	0.16													
					4xD	f _n ▶ 0.06	0.09	0.12					●								
					5xD	f _n ▶ 0.06	0.08	0.10													
			SPGX	07T308-AL	2xD	f _n ▶ 0.10	0.14	0.18													
					3xD	f _n ▶ 0.10	0.14	0.18													
					4xD	f _n ▶ 0.08	0.11	0.14					●								
					5xD	f _n ▶ 0.08	0.10	0.12													
			SPGX	090408-AL	2xD	f _n ▶ 0.10	0.15	0.20													
					3xD	f _n ▶ 0.10	0.15	0.20													
					4xD	f _n ▶ 0.09	0.12	0.15					●								
					5xD	f _n ▶ 0.09	0.11	0.13													
			SPGX	110408-AL	2xD	f _n ▶ 0.11	0.16	0.21													
					3xD	f _n ▶ 0.11	0.16	0.21													
					4xD	f _n ▶ 0.10	0.14	0.18					●								
					5xD	f _n ▶ 0.10	0.13	0.16													
SPGX	140512-AL	2xD	f _n ▶ 0.12	0.17	0.22																
		3xD	f _n ▶ 0.12	0.17	0.22																
		4xD	f _n ▶ 0.10	0.15	0.20					●											
		5xD	f _n ▶ 0.10	0.14	0.18																
superficie lappata																					

● stock standard

MATERIALI

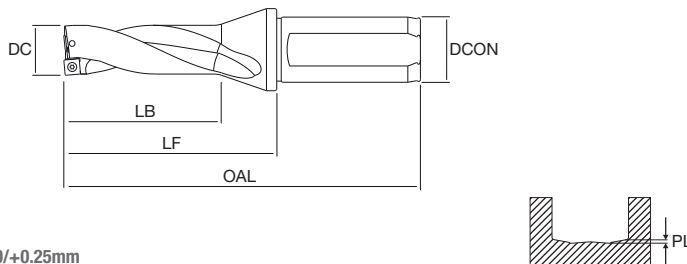


	 								
TOLLERANZA DEL FORO 0/+0.20mm									
DRS 2XD	DC	DCON	OAL	LF	LB	ADJLX offset radiale massimo	PL forma del fondo del foro	MIID	

05	NT-DRS-2D	D13.00-S20-05	●	13	20	94	44	26	0.50	0.40	SPMX05 SPGX05
		D14.00-S20-05	●	14	20	96	46	28	0.50	0.40	
		D15.00-S20-05	●	15	20	99	49	30	0.50	0.40	
06	NT-DRS-2D	D16.00-S25-06	●	16	25	108	52	32	0.50	0.50	SPMX06 SPGX06
		D17.00-S25-06	●	17	25	110	54	34	0.50	0.50	
		D18.00-S25-06	●	18	25	113	57	36	0.50	0.50	
		D19.00-S25-06	●	19	25	115	59	38	0.50	0.50	
		D20.00-S25-06	●	20	25	119	63	40	0.50	0.50	
		D21.00-S25-06	●	21	25	121	65	42	0.25	0.50	
07	NT-DRS-2D	D22.00-S25-07	●	22	25	123	67	44	0.50	0.50	SPMX07 SPGX07
		D23.00-S32-07	●	23	32	131	71	46	0.50	0.50	
		D24.00-S32-07	●	24	32	134	74	48	0.50	0.50	
		D25.00-S32-07	●	25	32	137	77	50	0.50	0.50	
		D26.00-S32-07	●	26	32	139	79	52	0.25	0.60	
		D27.00-S32-07	●	27	32	141	81	54	0.25	0.60	
09	NT-DRS-2D	D28.00-S32-09	●	28	32	144	84	56	0.50	0.80	SPMX09 SPGX09
		D29.00-S32-09	●	29	32	146	86	58	0.50	0.80	
		D30.00-S32-09	●	30	32	151	91	60	0.50	0.80	
		D31.00-S32-09	●	31	32	154	94	62	0.25	0.80	
		D32.00-S32-09	●	32	32	156	96	64	0.25	0.80	
		D33.00-S32-09	●	33	32	159	99	66	0.25	0.80	
11	NT-DRS-2D	D34.00-S40-11	●	34	40	171	101	68	0.50	0.90	SPMX11 SPGX11
		D35.00-S40-11	●	35	40	174	104	70	0.50	0.90	
		D36.00-S40-11	●	36	40	177	107	72	0.50	0.90	
		D37.00-S40-11	●	37	40	180	110	74	0.50	0.90	
		D38.00-S40-11	●	38	40	183	113	76	0.50	0.90	
		D39.00-S40-11	●	39	40	185	115	78	0.50	0.90	
		D40.00-S40-11	●	40	40	188	118	80	0.25	0.90	
		D41.00-S40-11	●	41	40	191	121	82	0.25	0.90	
14	NT-DRS-2D	D42.00-S40-14	●	42	40	193	123	84	0.50	1.00	SPMX14 SPGX14
		D43.00-S40-14	●	43	40	196	126	86	0.50	1.00	
		D44.00-S40-14	●	44	40	198	128	88	0.50	1.00	
		D45.00-S40-14	●	45	40	202	132	90	0.50	1.00	
		D46.00-S40-14	●	46	40	205	135	92	0.50	1.00	
		D47.00-S40-14	●	47	40	207	137	94	0.50	1.00	
		D48.00-S40-14	●	48	40	210	140	96	0.25	1.00	
		D49.00-S40-14	●	49	40	212	142	98	0.25	1.00	
		D50.00-S40-14	●	50	40	215	145	100	0.25	1.00	

● stock standard

Ricambi	VITE INSERTO	CHIAVE INSERTO
		
NT-DRS-2D D00.00-S00-05	NT-ST059	NT-FTB06
NT-DRS-2D D00.00-S00-06	NT-ST061	NT-FTB06
NT-DRS-2D D00.00-S00-07	NT-ST062	NT-FTB07
NT-DRS-2D D00.00-S00-09	NT-ST063	NT-FTB15
NT-DRS-2D D00.00-S00-11	NT-ST064	NT-FTB15
NT-DRS-2D D00.00-S00-14	NT-ST066	NT-FTB20

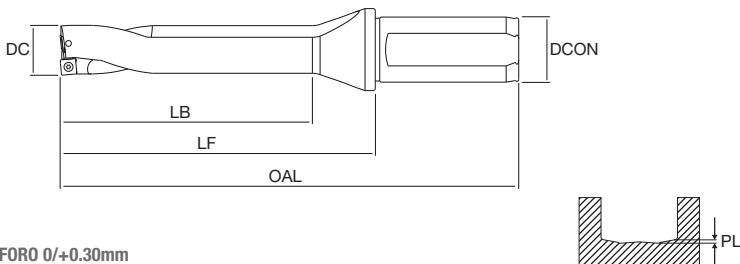
											
TOLLERANZA DEL FORO 0/+0.25mm											
DRS 3XD				DC	DCON	OAL	LF	LB	ADJLX offset radiale massimo	PL forma del fondo del foro	MIID
05	NT-DRS-3D	D12.50-S20-05	●	12.5	20	107	57	39	0.50	0.40	SPMX05 SPGX05
		D13.00-S20-05	●	13	20	107	57	39	0.50	0.40	
		D13.50-S20-05	●	13.5	20	110	60	42	0.50	0.40	
		D14.00-S20-05	●	14	20	110	60	42	0.50	0.40	
		D14.50-S20-05	●	14.5	20	114	64	45	0.50	0.40	
		D15.00-S20-05	●	15	20	114	64	45	0.50	0.40	
06	NT-DRS-3D	D15.50-S25-06	●	15.5	25	124	68	48	0.50	0.50	SPMX06 SPGX06
		D16.00-S25-06	●	16	25	124	68	48	0.50	0.50	
		D16.50-S25-06	●	16.5	25	127	71	51	0.50	0.50	
		D17.00-S25-06	●	17	25	127	71	51	0.50	0.50	
		D17.50-S25-06	●	17.5	25	131	75	54	0.50	0.50	
		D18.00-S25-06	●	18	25	131	75	54	0.50	0.50	
		D18.50-S25-06	●	18.5	25	134	78	57	0.50	0.50	
		D19.00-S25-06	●	19	25	134	78	57	0.50	0.50	
		D19.50-S25-06	●	19.5	25	139	83	60	0.50	0.50	
		D20.00-S25-06	●	20	25	139	83	60	0.50	0.50	
		D20.50-S25-06	●	20.5	25	142	86	63	0.25	0.50	
		D21.00-S25-06	●	21	25	142	86	63	0.25	0.50	
		D21.50-S25-06	●	21.5	25	145	89	66	0.25	0.50	
07	NT-DRS-3D	D22.00-S25-07	●	22	25	145	89	66	0.50	0.50	SPMX07 SPGX07
		D22.50-S32-07	●	22.5	32	154	94	69	0.50	0.50	
		D23.00-S32-07	●	23	32	154	94	69	0.50	0.50	
		D23.50-S32-07	●	23.5	32	158	98	72	0.50	0.50	
		D24.00-S32-07	●	24	32	158	98	72	0.50	0.50	
		D24.50-S32-07	●	24.5	32	162	102	75	0.50	0.50	
		D25.00-S32-07	●	25	32	162	102	75	0.50	0.50	
		D25.50-S32-07	●	25.5	32	165	105	78	0.50	0.60	
		D26.00-S32-07	●	26	32	165	105	78	0.25	0.60	
		D26.50-S32-07	●	26.5	32	168	108	81	0.25	0.60	
		D27.00-S32-07	●	27	32	168	108	81	0.25	0.60	
		D27.50-S32-07	●	27.5	32	172	112	84	0.25	0.60	
09	NT-DRS-3D	D28.00-S32-09	●	28	32	172	112	84	0.50	0.80	SPMX09 SPGX09
		D28.50-S32-09	●	28.5	32	175	115	87	0.50	0.80	
		D29.00-S32-09	●	29	32	175	115	87	0.50	0.80	
		D29.50-S32-09	●	29.5	32	181	121	90	0.50	0.80	
		D30.00-S32-09	●	30	32	181	121	90	0.50	0.80	
		D31.00-S32-09	●	31	32	185	125	93	0.25	0.80	
		D32.00-S32-09	●	32	32	188	128	96	0.25	0.80	
		D33.00-S32-09	●	33	32	192	132	99	0.25	0.80	

● stock standard

DRS 3XD				DC	DCON	OAL	LF	LB	ADJLX offset radiale massimo	PL forma del fondo del foro	MIID
11	NT-DRS-3D	D34.00-S40-11	●	34	40	205	135	102	0.50	0.90	SPMX11 SPGX11
		D35.00-S40-11	●	35	40	209	139	105	0.50	0.90	
		D36.00-S40-11	●	36	40	213	143	108	0.50	0.90	
		D37.00-S40-11	●	37	40	217	147	111	0.50	0.90	
		D38.00-S40-11	●	38	40	221	151	114	0.50	0.90	
		D39.00-S40-11	●	39	40	224	154	117	0.50	0.90	
		D40.00-S40-11	●	40	40	228	158	120	0.25	0.90	
		D41.00-S40-11	●	41	40	232	162	123	0.25	0.90	
14	NT-DRS-3D	D42.00-S40-14	●	42	40	235	165	126	0.50	1.00	SPMX14 SPGX14
		D43.00-S40-14	●	43	40	239	169	129	0.50	1.00	
		D44.00-S40-14	●	44	40	242	172	132	0.50	1.00	
		D45.00-S40-14	●	45	40	247	177	135	0.50	1.00	
		D46.00-S40-14	●	46	40	251	181	138	0.50	1.00	
		D47.00-S40-14	●	47	40	254	184	141	0.50	1.00	
		D48.00-S40-14	●	48	40	258	188	144	0.25	1.00	
		D49.00-S40-14	●	49	40	261	191	147	0.25	1.00	
		D50.00-S40-14	●	50	40	265	195	150	0.25	1.00	

● stock standard

Ricambi	VITE INSERTO	CHIAVE INSERTO
		
NT-DRS-3D D00.00-S00-05	NT-ST059	NT-FTB06
NT-DRS-3D D00.00-S00-06	NT-ST061	NT-FTB06
NT-DRS-3D D00.00-S00-07	NT-ST062	NT-FTB07
NT-DRS-3D D00.00-S00-09	NT-ST063	NT-FTB15
NT-DRS-3D D00.00-S00-11	NT-ST064	NT-FTB15
NT-DRS-3D D00.00-S00-14	NT-ST066	NT-FTB20

	 TOLLERANZA DEL FORO 0/+0.30mm								
DRS 4XD	DC	DCON	OAL	LF	LB	ADJLX offset radiale massimo	PL forma del fondo del foro	MIID	

05	NT-DRS-4D	D12.50-S20-05	●	12.5	20	120	70	52	0.50	0.40	SPMX05 SPGX05
		D13.00-S20-05	●	13	20	120	70	52	0.50	0.40	
		D13.50-S20-05	●	13.5	20	124	74	56	0.50	0.40	
		D14.00-S20-05	●	14	20	124	74	56	0.50	0.40	
		D14.50-S20-05	●	14.5	20	129	79	60	0.50	0.40	
		D15.00-S20-05	●	15	20	129	79	60	0.50	0.40	
06	NT-DRS-4D	D15.50-S25-06	●	15.5	25	140	84	64	0.50	0.50	SPMX06 SPGX06
		D16.00-S25-06	●	16	25	140	84	64	0.50	0.50	
		D16.50-S25-06	●	16.5	25	144	88	68	0.50	0.50	
		D17.00-S25-06	●	17	25	144	88	68	0.50	0.50	
		D17.50-S25-06	●	17.5	25	149	93	72	0.50	0.50	
		D18.00-S25-06	●	18	25	149	93	72	0.50	0.50	
		D18.50-S25-06	●	18.5	25	153	97	76	0.50	0.50	
		D19.00-S25-06	●	19	25	153	97	76	0.50	0.50	
		D19.50-S25-06	●	19.5	25	159	103	80	0.50	0.50	
		D20.00-S25-06	●	20	25	159	103	80	0.50	0.50	
		D20.50-S25-06	●	20.5	25	163	107	84	0.25	0.50	
		D21.00-S25-06	●	21	25	163	107	84	0.25	0.50	
		D21.50-S25-06	●	21.5	25	167	111	88	0.25	0.50	
07	NT-DRS-4D	D22.00-S25-07	●	22	25	167	111	88	0.50	0.50	SPMX07 SPGX07
		D22.50-S32-07	●	22.5	32	177	117	92	0.50	0.50	
		D23.00-S32-07	●	23	32	177	117	92	0.50	0.50	
		D23.50-S32-07	●	23.5	32	182	122	96	0.50	0.50	
		D24.00-S32-07	●	24	32	182	122	96	0.50	0.50	
		D24.50-S32-07	●	24.5	32	187	127	100	0.50	0.50	
		D25.00-S32-07	●	25	32	187	127	100	0.50	0.50	
		D25.50-S32-07	●	25.5	32	191	131	104	0.50	0.60	
		D26.00-S32-07	●	26	32	191	131	104	0.25	0.60	
		D26.50-S32-07	●	26.5	32	195	135	108	0.25	0.60	
		D27.00-S32-07	●	27	32	195	135	108	0.25	0.60	
		D27.50-S32-07	●	27.5	32	200	140	112	0.25	0.60	
09	NT-DRS-4D	D28.00-S32-09	●	28	32	200	140	112	0.50	0.80	SPMX09 SPGX09
		D28.50-S32-09	●	28.5	32	204	144	116	0.50	0.80	
		D29.00-S32-09	●	29	32	204	144	116	0.50	0.80	
		D29.50-S32-09	●	29.5	32	211	151	120	0.50	0.80	
		D30.00-S32-09	●	30	32	211	151	120	0.50	0.80	
		D31.00-S32-09	●	31	32	216	156	124	0.25	0.80	
		D32.00-S32-09	●	32	32	220	160	128	0.25	0.80	
		D33.00-S32-09	●	33	32	225	165	132	0.25	0.80	

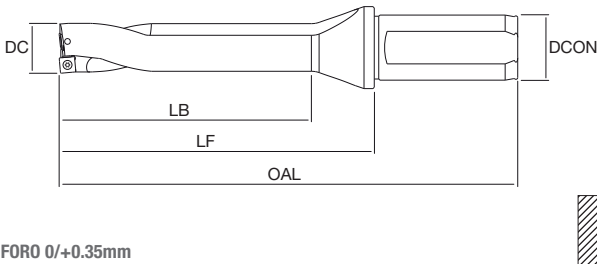
● stock standard

DRS 4XD				DC	DCON	OAL	LF	LB	ADJLX offset radiale massimo	PL forma del fondo del foro	MIID
11	NT-DRS-4D	D34.00-S40-11	●	34	40	239	169	136	0.50	0.90	SPMX11 SPGX11
		D35.00-S40-11	●	35	40	244	174	140	0.50	0.90	
		D36.00-S40-11	●	36	40	249	179	144	0.50	0.90	
		D37.00-S40-11	●	37	40	254	184	148	0.50	0.90	
		D38.00-S40-11	●	38	40	259	189	152	0.50	0.90	
		D39.00-S40-11	●	39	40	263	193	156	0.50	0.90	
		D40.00-S40-11	●	40	40	268	198	160	0.25	0.90	
		D41.00-S40-11	●	41	40	273	203	164	0.25	0.90	
14	NT-DRS-4D	D42.00-S40-14	●	42	40	277	207	168	0.50	1.00	SPMX14 SPGX14
		D43.00-S40-14	●	43	40	282	212	172	0.50	1.00	
		D44.00-S40-14	●	44	40	286	216	176	0.50	1.00	
		D45.00-S40-14	●	45	40	292	222	180	0.50	1.00	
		D46.00-S40-14	●	46	40	297	227	184	0.50	1.00	
		D47.00-S40-14	●	47	40	301	231	188	0.50	1.00	
		D48.00-S40-14	●	48	40	306	236	192	0.25	1.00	
		D49.00-S40-14	●	49	40	310	240	196	0.25	1.00	
		D50.00-S40-14	●	50	40	315	245	200	0.25	1.00	

● stock standard

Ricambi	VITE INSERTO	CHIAVE INSERTO
		
NT-DRS-4D D00.00-S00-05	NT-ST059	NT-FTB06
NT-DRS-4D D00.00-S00-06	NT-ST061	NT-FTB06
NT-DRS-4D D00.00-S00-07	NT-ST062	NT-FTB07
NT-DRS-4D D00.00-S00-09	NT-ST063	NT-FTB15
NT-DRS-4D D00.00-S00-11	NT-ST064	NT-FTB15
NT-DRS-4D D00.00-S00-14	NT-ST066	NT-FTB20





TOLLERANZA DEL FORO 0/+0.35mm

DRS 5XD	DC	DCON	OAL	LF	LB	ADJLX offset radiale massimo	PL forma del fondo del foro	MIID
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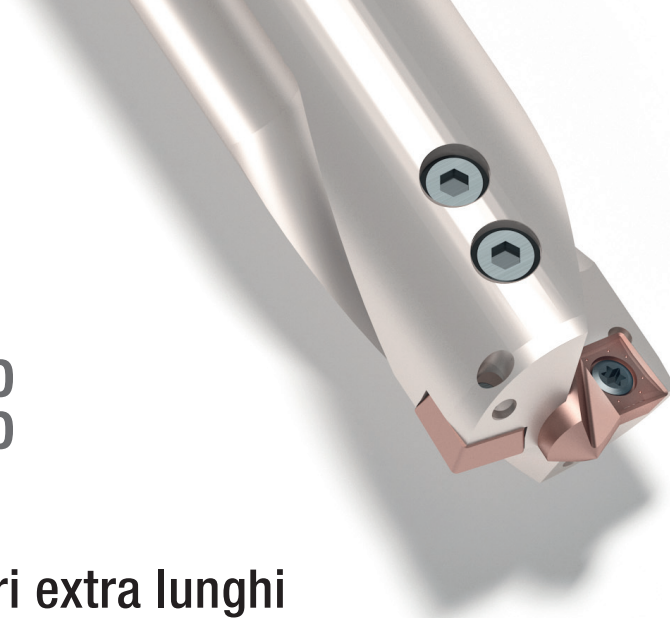
05	NT-DRS-5D	D13.00-S20-05	●	13	20	133	83	65	0.50	0.40	SPMX05 SPGX05
		D14.00-S20-05	●	14	20	138	88	70	0.50	0.40	
		D15.00-S20-05	●	15	20	144	94	75	0.50	0.40	
06	NT-DRS-5D	D16.00-S25-06	●	16	25	156	100	80	0.50	0.50	SPMX06 SPGX06
		D17.00-S25-06	●	17	25	161	105	85	0.50	0.50	
		D18.00-S25-06	●	18	25	167	111	90	0.50	0.50	
		D19.00-S25-06	●	19	25	172	116	95	0.50	0.50	
		D20.00-S25-06	●	20	25	179	123	100	0.50	0.50	
		D21.00-S25-06	●	21	25	184	128	105	0.25	0.50	
07	NT-DRS-5D	D22.00-S25-07	●	22	25	189	133	110	0.50	0.50	SPMX07 SPGX07
		D23.00-S32-07	●	23	32	200	140	115	0.50	0.50	
		D24.00-S32-07	●	24	32	206	146	120	0.50	0.50	
		D25.00-S32-07	●	25	32	212	152	125	0.50	0.50	
		D26.00-S32-07	●	26	32	217	157	130	0.25	0.60	
		D27.00-S32-07	●	27	32	222	162	135	0.25	0.60	
09	NT-DRS-5D	D28.00-S32-09	●	28	32	228	168	140	0.50	0.80	SPMX09 SPGX09
		D29.00-S32-09	●	29	32	233	173	145	0.50	0.80	
		D30.00-S32-09	●	30	32	241	181	150	0.50	0.80	
		D31.00-S32-09	●	31	32	247	187	155	0.25	0.80	
		D32.00-S32-09	●	32	32	252	192	160	0.25	0.80	
		D33.00-S32-09	●	33	32	258	198	165	0.25	0.80	
11	NT-DRS-5D	D34.00-S40-11	●	34	40	273	203	170	0.50	0.90	SPMX11 SPGX11
		D35.00-S40-11	●	35	40	279	209	175	0.50	0.90	
		D36.00-S40-11	●	36	40	285	215	180	0.50	0.90	
		D37.00-S40-11	●	37	40	291	221	185	0.50	0.90	
		D38.00-S40-11	●	38	40	297	227	190	0.50	0.90	
		D39.00-S40-11	●	39	40	302	232	195	0.50	0.90	
		D40.00-S40-11	●	40	40	308	238	200	0.25	0.90	
		D41.00-S40-11	●	41	40	314	244	205	0.25	0.90	
14	NT-DRS-5D	D42.00-S40-14	●	42	40	319	249	210	0.50	1.00	SPMX14 SPGX14
		D43.00-S40-14	●	43	40	325	255	215	0.50	1.00	
		D44.00-S40-14	●	44	40	330	260	220	0.50	1.00	
		D45.00-S40-14	●	45	40	337	267	225	0.50	1.00	
		D46.00-S40-14	●	46	40	343	273	230	0.50	1.00	
		D47.00-S40-14	●	47	40	348	278	235	0.50	1.00	
		D48.00-S40-14	●	48	40	354	284	240	0.25	1.00	
		D49.00-S40-14	●	49	40	359	289	245	0.25	1.00	
		D50.00-S40-14	●	50	40	365	295	250	0.25	1.00	

● stock standard

Ricambi	VITE INSERTO	CHIAVE INSERTO
		
NT-DRS-5D D00.00-S00-05	NT-ST059	NT-FTB06
NT-DRS-5D D00.00-S00-06	NT-ST061	NT-FTB06
NT-DRS-5D D00.00-S00-07	NT-ST062	NT-FTB07
NT-DRS-5D D00.00-S00-09	NT-ST063	NT-FTB15
NT-DRS-5D D00.00-S00-11	NT-ST064	NT-FTB15
NT-DRS-5D D00.00-S00-14	NT-ST066	NT-FTB20

DRSPILOT^{6XD}_{9XD}

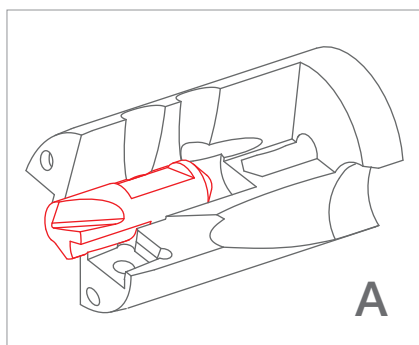
Centraggio perfetto anche su fori extra lunghi



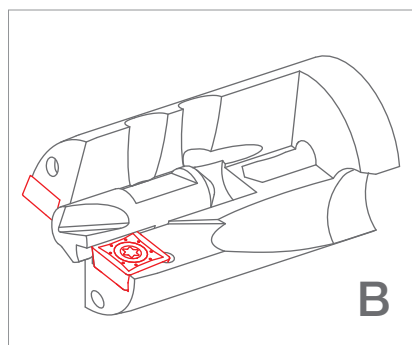
1. Quando è applicabile DRSPILOT?

SUPERFICIE PIANA	SUPERFICIE CONCAVA	TUBI	MEZZI FORI	ESPANSIONE FORI	SUPERFICIE INCLINATA	FORATURA A PACCO

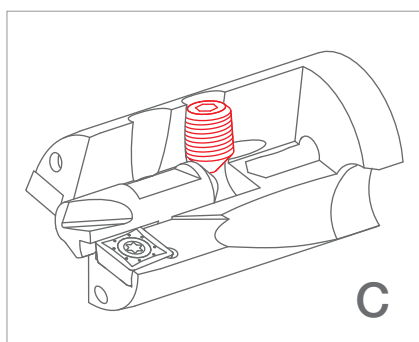
2. Installazione degli inserti e della punta pilota



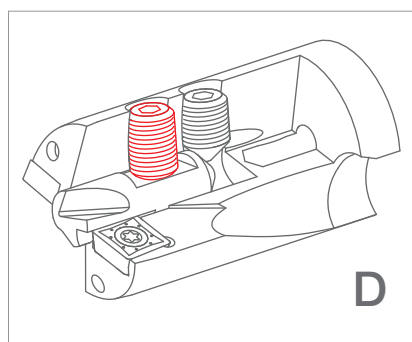
*Inserire DRSP
Pilota nel corpo
della punta.*



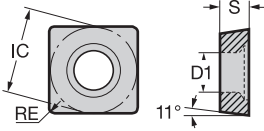
*Installare gli
inserti SPMX/
SPGX.*

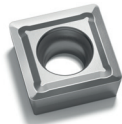


*Regolare
l'altezza del
DRSP Pilota
usando il grano
di regolazione
come mostrato
nel disegno,
seguendo la
tabella a pag. 11.*

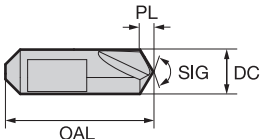
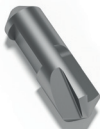


*Avvitare con
forza il grano di
fissaggio.*

SP□X		DRS PILOT inserti a 4 taglienti					ISO513	HC-PVD																						
								JP5625	JP5530	JP9635	JU6520	HW																		
 4 edges		Dimensioni	IC	S	D1	RE	P	60 220	60 220																					
		05	5.00	2.38	2.50	0.40	M			40 160																				
		06	6.00	2.38	2.80	0.40	K	100 190	100 190																					
		07	7.94	3.97	2.80	0.80	N				150 300																			
							S																							
							H																							
AREA DI APPLICAZIONE DEL GRADO		Condizioni di taglio stabili					+ Durezza	- tenacità																						
										Condizioni di taglio medie																				
															Condizioni di taglio instabili															
■ applicazione principale																														
■ applicabile																														

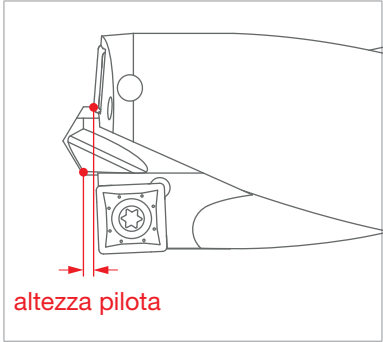
GENERALE	GP P M K		SPMX 050204-GP	6xD 9xD	f _n ▶ f _n ▶	0.08 0.06	0.10 0.08	0.12 0.10	● ● ●																
	SPMX 060204-GP	6xD 9xD	f _n ▶ f _n ▶	0.08 0.06	0.10 0.08	0.12 0.10	● ● ●																		
	SPMX 07T308-GP	6xD 9xD	f _n ▶ f _n ▶	0.09 0.07	0.11 0.09	0.13 0.11	● ● ●																		
ALLUMINIO	AL N	 superficie lappata	SPGX 050204-AL	6xD 9xD	f _n ▶ f _n ▶	0.05 0.04	0.07 0.06	0.09 0.08	●																
	SPGX 060204-AL	6xD 9xD	f _n ▶ f _n ▶	0.05 0.04	0.07 0.06	0.09 0.08	●																		
	SPGX 07T308-AL	6xD 9xD	f _n ▶ f _n ▶	0.06 0.05	0.08 0.07	0.10 0.09	●																		

● stock standard

DRSP		DRS PILOT punta centrante intercambiabile					
		Dimensioni	DC	OAL	PL	SIG	
		06	6	20	1.5	118°	
		08	8	25	2.1	118°	
GENERALE		DRSP 06-GP HSS TIN					●
		DRSP 08-GP HSS TIN					●

● stock standard

REGOLAZIONE ALTEZZA



MATERIALE	6xD	9xD
P M K	1.0 mm	1.4 mm
N	1.5 mm	1.7 mm

MATERIALI

P

M

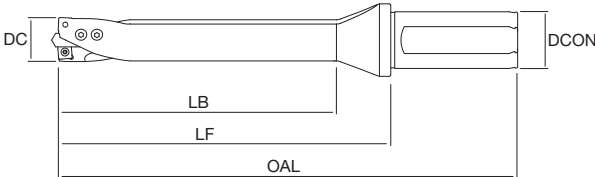
K

N

S

H

▶ p. 14-15

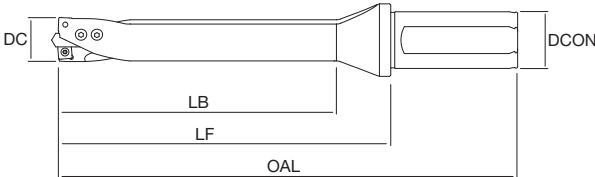
								
DRS PILOT 6XD	DC	DCON	OAL	LF	LB		MID (Inserto)	MID (Pilota)

05	NT-DRS-6D	D18.00-S25-05P6	●	18	25	191	135	112	SPMX05 SPGX05	DRSP06
		D19.00-S25-05P6	●	19	25	197	141	118		
06	NT-DRS-6D	D20.00-S25-06P6	●	20	25	203	147	124	SPMX06 SPGX06	DRSP06
		D21.00-S25-06P6	●	21	25	209	153	130		
		D22.00-S25-06P6	●	22	25	215	159	136		
		D23.00-S32-06P6	●	23	32	228	168	142		
		D24.00-S32-06P6	●	24	32	234	174	148		
		D25.00-S32-06P6	●	25	32	240	180	154		
07	NT-DRS-6D	D26.00-S32-07P8	●	26	32	246	186	160	SPMX07 SPGX07	DRSP08
		D27.00-S32-07P8	●	27	32	252	192	166		
		D28.00-S32-07P8	●	28	32	258	198	172		
		D29.00-S32-07P8	●	29	32	264	204	178		
		D30.00-S32-07P8	●	30	32	270	210	184		

● stock standard

Ricambi	VITE INSERTO	CHIAVE INSERTO
		
NT-DRS-6D D■■■■-S■■-05P6	NT-ST059	NT-FTB06
NT-DRS-6D D■■■■-S■■-06P6	NT-ST061	NT-FTB06
NT-DRS-6D D■■■■-S■■-07P8	NT-ST062	NT-FTB07

Ricambi	GRANO DI SERRAGGIO	GRANO DI REGOLAZIONE	CHIAVE GRANO
			
DC 18÷22	NT-ST042	NT-ST043	NT-WR025
DC 23÷25	NT-ST044	NT-ST045	
DC 26÷30	NT-ST046	NT-ST047	NT-WR030

								
DRS PILOT 9XD	DC	DCON	OAL	LF	LB		MID (Inserto)	MID (Pilota)

05	NT-DRS-9D	D18.00-S25-05P6	●	18	25	245	189	166	SPMX05 SPGX05	DRSP06
		D19.00-S25-05P6	●	19	25	254	198	175		
06	NT-DRS-9D	D20.00-S25-06P6	●	20	25	263	207	184	SPMX06 SPGX06	DRSP06
		D21.00-S25-06P6	●	21	25	272	216	193		
		D22.00-S25-06P6	●	22	25	281	225	202		
		D23.00-S32-06P6	●	23	32	297	237	211		
		D24.00-S32-06P6	●	24	32	306	246	220		
		D25.00-S32-06P6	●	25	32	315	255	229		
07	NT-DRS-9D	D26.00-S32-07P8	●	26	32	324	264	238	SPMX07 SPGX07	DRSP08
		D27.00-S32-07P8	●	27	32	333	273	247		
		D28.00-S32-07P8	●	28	32	342	282	256		
		D29.00-S32-07P8	●	29	32	351	291	265		
		D30.00-S32-07P8	●	30	32	360	300	274		

● stock standard

Ricambi	VITE INSERTO	CHIAVE INSERTO
		
NT-DRS-9D D■■■■-S■■-05P6	NT-ST059	NT-FTB06
NT-DRS-9D D■■■■-S■■-06P6	NT-ST061	NT-FTB06
NT-DRS-9D D■■■■-S■■-07P8	NT-ST062	NT-FTB07

Ricambi	GRANO DI SERRAGGIO	GRANO DI REGOLAZIONE	CHIAVE GRANO
			
DC 18÷22	NT-ST042	NT-ST043	NT-WR025
DC 23÷25	NT-ST044	NT-ST045	
DC 26÷30	NT-ST046	NT-ST047	NT-WR030

VELOCITÀ DI TAGLIO [m/min]

	MATERIALI	DUREZZA/Rm	W.-Nr	DIN	AIISI-ASTM	TRADE MARK
P1	Acciai automatici e acciai strutturali	< 500 N/mm ²	1.0715 1.0765	9 SMn 28 36 SMnPb 14	1213 A29	AVP PR80
P2	Acciai al carbonio e acciai basso legati	500-700 N/mm ²	1.7147 1.0511	20 MnCr 5 C 40	5120 1040	- -
P3	Acciai medio legati e acciai da bonifica	600-800 N/mm ²	1.1201 1.6511	42 CrMo 4 36 CrNiMo 4	4142, 4140 9840	- -
P4	Acciai alto legati	800-1000 N/mm ²	1.1663 1.3505	C 125 W 100 Cr 6	W1 52100	- -
P5	Acciai per utensili	900-1200 N/mm ²	1.2080 1.2379	X 210 Cr 12 X 155 CrVMo 12 1	D3 -	K100 K110
M1	Acciai inossidabili ferritici	400-700 N/mm ²	1.4016 1.4104	X 6 Cr 17 X 12 CrMoS 17	430 430 F	- -
M2	Acciai inossidabili austenitici - buona lavorabilità	500-750 N/mm ²	1.4305 1.4301	X 10 CrNiS 18 9 X 6 CrNi 18 10	303 304, 304 H	- -
M3	Acciai inossidabili austenitici - media lavorabilità	550-850 N/mm ²	1.4401 1.4462	X 5 CrNiMo 17 12 2 X 2 CrNiMoN 22 5	316 F 51-329 A	- DUPLEX
M4	Acciai inossidabili martensitici	650-950 N/mm ²	1.4021 1.4410	X 20 Cr 13 X 2 CrNiMoN 25 7 4	420 F 53-329 S1	- SUPER DUPLEX
M5	Acciai inossidabili PH - indurenti per precipitazione	800-1250 N/mm ²	1.4540 1.4542	X 4 CrNiCuNb 16 4 X 5 CrNiNb 16 4	XM-12 631	15-5-PH 17-4-PH
K1	Ghise grigie	150-250 HB	0.6020 0.6025	GG-20 GG-25	A48 30 B A48 35 B	- -
K2	Ghise sferoidali	150-350 HB	0.7050 0.7070	GGG-50 GGG-70	A536 80-55-6 A536 100-70-03	- -
N1	Leghe di alluminio ≤ 12% Si		3.3547 3.2315	AlMg4.5Mn AlMgSi 1	5083 6082	Peraluman 440 Anticorodal 100
N2	Leghe di alluminio > 12% Si		3.2582	GD-AlSi12 G-AlSi6Cu4	A413.0 319	
N3	Rame		2.0940-01 2.1176	CuAl10Fe CuPb10Sn	CA952 CA937	
N4	Bronzo e ottone		2.0401	Cu Zn39Pb3		OT58 AMPCO 18

DRSDRILL

DRSPILOT

JP5625	JP5530	JP9635	JU6520	JP5625	JP5530	JP9635	JU6520	MATERIALI	DUREZZA/Rm	
180÷300	180÷300			130÷220	130÷220			Acciai automatici e acciai strutturali	< 500 N/mm ²	P1
140÷240	140÷240			100÷180	100÷180			Acciai al carbonio e acciai basso legati	500-700 N/mm ²	P2
100÷220	100÷220			80÷170	80÷170			Acciai medio legati e acciai da bonifica	600-800 N/mm ²	P3
100÷180	100÷180			80÷140	80÷140			Acciai alto legati	800-1000 N/mm ²	P4
80÷150	80÷150			60÷120	60÷120			Acciai per utensili	900-1200 N/mm ²	P5
		120÷220				90÷160		Acciai inossidabili ferritici	400-700 N/mm ²	M1
		80÷180				60÷130		Acciai inossidabili austenitici - buona lavorabilità	500-750 N/mm ²	M2
		60÷150				50÷110		Acciai inossidabili austenitici - media lavorabilità	550-850 N/mm ²	M3
		60÷150				50÷110		Acciai inossidabili martensitici	650-950 N/mm ²	M4
		50÷120				40÷100		Acciai inossidabili PH - indurenti per precipitazione	800-1250 N/mm ²	M5
180÷250	180÷250			130÷190	130÷190			Ghise grigie	150-250 HB	K1
120÷180	120÷180			100÷140	100÷140			Ghise sferoidali	150-350 HB	K2
			250÷400				200÷300	Leghe di alluminio ≤ 12% Si		N1
			150÷300				120÷240	Leghe di alluminio > 12% Si		N2
			200÷300				150÷240	Rame		N3
			200÷300				150÷240	Bronzo e ottone		N4

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