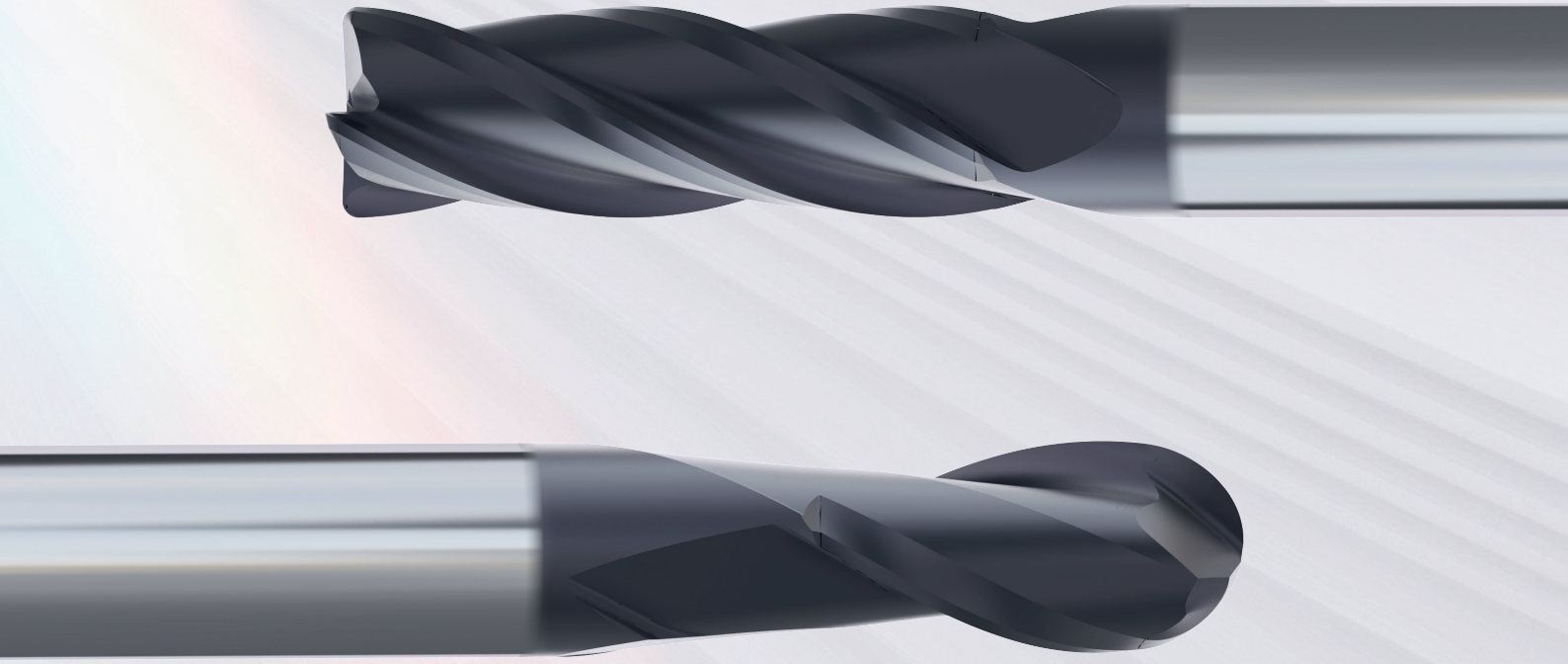
Seco

Catalogo e guida tecnica

Frese integrali 2026.1



Seco è una realtà multinazionale operante nel settore metalmeccanico, che realizza utensili, tecnologie e soluzioni per le sfide produttive più avanzate.

La sostenibilità, la produttività, l'innovazione tecnologica, le competenze e la passione per i clienti sono il cuore pulsante dell'azienda.

Sviluppiamo e forniamo tecnologie, processi e supporto su cui potrai sempre contare per massimizzare la tua produttività e la redditività con uno sguardo al futuro. L'elemento umano per noi di Seco è fondamentale. Lavoriamo a stretto contatto coi clienti per comprendere le loro necessità.

Intraprendiamo collaborazioni con università e associazioni di settore per monitorare tendenze e sviluppare soluzioni che soddisfino le esigenze di segmenti specifici. Collaboriamo strettamente coi fornitori di tecnologie complementari per garantire che i produttori abbiano accesso a soluzioni completamente ottimizzate.

Made for Makers

Informazioni tecniche

Panoramica prodotto 6
Riepilogo dei prodotti 11
Descrizione del prodotto 14
Servizi 18
Definizioni delle operazioni 19
Definizione delle strategie 21
Pittogrammi (esempi) 25
ISO 29

Universale

Panoramica prodotto 31
Scelta utensile 32
C-series 38
Solid² 75
Stabilizer 140
Solid² 166
C-series 181
Solid² 196
C-series 210
Solid² 214
HSM/Tornado 222
HFM 230
VHM 234
MINI 254

Acciaio e ghisa

Panoramica prodotto 273
Scelta utensile 274
Stabilizer 276
HPM 293
Tornado 303
Stabilizer 306
HSM/Tornado 313

Acciaio inossidabile e materiali S

Panoramica prodotto 321
Scelta utensile 322
Solid² 326
HPM 378
HSM/Tornado 401
HPM 423

HSM/Tornado 425
HFM 433
MINI 437

Materiali non ferrosi

Panoramica prodotto 439
Scelta utensile 440
Solid² 443
HPM 466
Solid² 470
HSM/Tornado 474
HSM 481
HSM/Tornado 483
Solid² 485
HSM/Tornado 488
MINI 492

Acciai temprati

Panoramica prodotto 498
Scelta utensile 499
HPM 501
HFM 504
HSM/Tornado 507
MINI 524

Plastica e cfrp

Panoramica prodotto 535
Scelta utensile 536
Compositi 539
PCD 581
VHM 587

Grafite

Panoramica prodotto 591
Scelta utensile 592
Diamante 594

X-Heads

Famiglia 608
Scelta utensile 609
Attacchi 611
Solid² 620

HSM/Tornado 655
HFM 657
VHM 673

Ricalcolo

Ricalcolo 698
Calcolo 708

Minimaster

Sistema Minimaster 710
Codoli – MM06 715
Inserti – MM06 717
Parametri di taglio – MM06 721
Codoli – MM08 730
Inserti – MM08 732
Parametri di taglio – MM08 736
Codoli – MM10 747
Inserti – MM10 749
Parametri di taglio – MM10 754
Codoli – MM12 765
Inserti – MM12 767
Parametri di taglio – MM12 773
Codoli – MM16 784
Inserti – MM16 786
Parametri di taglio – MM16 791
Chiavi dinamometriche 799

X-Heads

X-Heads 800

SMG

SMG 801

C
C5021 ... 210
C5041 ... 212
C5121 ... 38-45
C5131 ... 50-51
C5141 ... 56-68
C5231 ... 73
C5241 ... 73
C5321 ... 181-186
C5341 ... 189-193

D
D8961 ... 539-540

H
HK/HKM ... 240-250
HP4931 ... 466-468

J
J28 ... 589
J29 ... 234
J36 ... 237
J93 ... 587
JC845 ... 542
JC850 ... 544
JC860 ... 546
JC870 ... 548-551
JC871 ... 554-557
JC875 ... 560-561
JC876 ... 564-565
JC877 ... 568-569
JC880 ... 572
JC885 ... 574
JC898 ... 576
JC899 ... 578-579
JCG790 ... 399
JD620 ... 594
JD630 ... 596
JD640 ... 598
JD660 ... 600
JH112 ... 313-314,516-517
JH120 ... 507
JH130 ... 509
JH142 ... 303-304,513-514
JH150 ... 317,520
JH160 ... 319,522
JH40 ... 474-475
JH410 ... 481
JH421 ... 477-479
JH440 ... 483
JH450 ... 488
JH460 ... 490
JH710 ... 417
JH721 ... 429
JH722 ... 431
JH724 ... 401
JH726 ... 403
JH730 ... 421
JH734 ... 405
JH736 ... 407
JH740 ... 415
JH744 ... 409
JH746 ... 411
JH780 ... 425
JH790 ... 419
JH910 ... 222-223
JH930 ... 226,511
JHB720 ... 427
JHB970 ... 228,311
JHF181 ... 504
JHF980 ... 230-231
JHP170 ... 501-502
JHP751 ... 378-379
JHP760 ... 381-383
JHP770 ... 385-390
JHP780 ... 392-395
JHP794 ... 397
JHP951 ... 299-300
JHP993 ... 293-294
JHP994 ... 423
JM403 ... 494
JM404 ... 494
JM406 ... 494
JM413 ... 496
JM416 ... 496
JMB112 ... 531-533
JMB542 ... 264
JMB562 ... 267-268
JMB563 ... 271
JMB642 ... 606
JMB662 ... 606
JME142 ... 524-527
JME144 ... 529
JME542 ... 254
JME562 ... 257-258
JME564 ... 261
JME642 ... 604
JPD850 ... 581
JPD880 ... 583
JPD890 ... 585
JS412 ... 443-444
JS413 ... 446
JS506 ... 214-215
JS509 ... 218-219
JS520 ... 174-175
JS522 ... 178
JS532 ... 198-199
JS533 ... 202-203
JS534 ... 206-207
JS553 ... 95-106
JS554 ... 115-127
JS564 ... 166-167
JS565 ... 170-171
JS720 ... 354-371
JS730 ... 374-376
JS754 ... 326-340
JS755 ... 343-352
JSB512 ... 196
JSE512 ... 75-76
JSE513 ... 79-82
JSE514 ... 85-90

S
S4321 ... 485-486
S4521 ... 449-452
S4531 ... 454-461
S4651 ... 463-464
S4931 ... 470-472
SHF712 ... 433
SMB413/414/416 ... 492
SMB614/616 ... 602
SMB713/714/716 ... 437
SME714/716 ... 435
ST5341 ... 306-308
ST5541 ... 276-288
ST5551 ... 140-157

V
V31 ... 251

M

MM06 716-721
MM08 731-736
MM10 748-754
MM12 766-773
MM16 785-790

X

XE-DM 618
XE-E 615-617
XE-S 611-614
XHF580 657-658
XHF780 663-664
XHT740 655
XS5021 669
XS5061 671
XSB540 637
XSB720 645-646
XSE450 651-652
XSE550 620-621,626-628,633-634
XSE720 639-640
XVB510 688-689
XVC506 692
XVC509 692
XVC512 692
XVE510 685
XVE540 673-674,679-680
XVK310 696

Panoramica della famiglia di prodotti

C-series



Questa gamma di frese Seco in metallo duro integrale è composta da frese integrali di base per operazioni di base. Include frese integrali rivestite e non rivestite. Ampia gamma di prodotti per lavorazioni universali
Le C-series di Seco sono disponibili in un'ampia gamma di frese con smussi, spigolo vivo, sferiche per sgrossatura e finitura, per contornatura, spianatura o scanalatura.

SOLID²



Seco Solid² è una gamma di frese integrali in metallo duro per applicazioni generiche che garantisce flessibilità, velocità ed ottimizzazione dei costi. Le frese Seco Solid² sono disponibili nei diametri da ∅1-∅32 mm e di ∅1/32 - 1 1/4 *pollici*.
Seco Solid² comprende anche frese specifiche per lavorazioni di sgrossatura avanzata (JS564 e JS565).
Le frese JS564 e JS565 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,
Consulti la pagina 11 per una panoramica divisa per prodotti Seco Solid*.

Stabilizer



Le frese integrali Seco della serie Stabilizer usano geometrie a elica unica per asportazioni estremamente aggressive in lavorazioni ad alte prestazioni.
Le frese Seco Stabilizer sono disponibili in un'ampia gamma di frese cilindriche e sferiche per operazioni di sgrossatura, di contornatura, scanalatura e sgrossatura avanzata.

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 11 si trova una panoramica delle frese HSM/TORNADO (lavorazioni ad alta velocità).

Panoramica della famiglia di prodotti

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 12 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 12 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 12 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 12 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 12 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 13 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 13 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 13 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 609 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
C-series	Lavorazioni generiche	C			■				
Solid²	Lavorazioni generiche	JS		■	■		■		
Stabilizer	Lavorazioni ad alte prestazioni	ST			■				
HPM	Lavorazioni ad alte prestazioni	JHP	■	■			■		■
HFM	Lavorazioni ad elevato avanzamento	JHF	■						■
Mini	Micro lavorazioni	JM	■	■	■	■			■
HSM/Tornado	Lavorazioni ad alta velocità	JH	■	■			■		■
Ceramic	Lavorazioni ad alte prestazioni	JCG					■		
Diamond	Lavorazioni della grafite	JD				■			
Composite	Lavorazioni di compositi	JC, JPD						■	
VHM	Lavorazioni generiche	J		■					■
HSS-E	Lavorazioni generiche	JCO					■		
X-Heads - Solid²	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 802									

Riassunto

Pagina(e)	Famiglia	Nome	P1-8	P11-12	M1-3	M4-5	K1-7	N1	N2-3	N11	S1-3	S11-13	H3-31	TS1	TS2-3	TS4	TP1	TP2-3	TP4	A nido d'ape	GR
210	C-Series	C5021	●	○	●	○	●	○	○	○	○	○	○	○			○				○
212		C5041	●	○	●	○	●	○	○	○	○	○	○	○			○				○
38		C5121	●	○	●	○	●	○	○	○	○	○	○	○			○				○
50		C5131	●	○	●	○	●	○	○	○	○	○	○	○			○				○
56		C5141	●	○	●	○	●	○	○	○	○	○	○	○			○				○
73		C5231	●	○	●	○	●	○	○	○	○	○	○	○			○				○
73		C5241	●	○	●	○	●	○	○	○	○	○	○	○			○				○
181		C5321	●	○	●	○	●	○	○	○	○	○	○	○			○				○
189		C5341	●	○	●	○	●	○	○	○	○	○	○	○			○				○
466	HPM	HP4931						●	●												
75	SOLID[2]	JSE512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
79		JSE513	●	○	●	○	●	○	○	○	○	○	○	○			○				○
85		JSE514	●	○	●	○	●	○	○	○	○	○	○	○			○				○
196		JSB512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
95		JS553	●	●	●	●	●	●	●	●	●	●	●	●			●				○
115		JS554	●	●	●	●	●	●	●	●	●	●	●	●			●				○
443		JS412						●	●					●			●				
446		JS413						●	●					●			●				
485		S4321						●	●					●			●				
449		S4521						●	●					●			●				
454		S4531						●	●					●			●				
463		S4651						●	●	●											
174		JS520	●	○	○	○	●	●	●	●	○	●	○	●			●				○
178		JS522	●	●	●	●	●	●	●	●	○	●		●			●				○
198		JS532	●	○	●	●	●	●	●	●	○	●		●			●				○
202		JS533	●	○	●	●	●	●	●	●	○	●		●			●				○
206		JS534	●	○	●	●	●	●	●	●	○	●		●			●				○
214		JS506	●	○	●	●	●	●	●	●	○	●	●	●			●				○
218		JS509	●	○	●	●	●	●	●	●	○	●	●	●			●				○
166		JS564	●	○	●	●	●	●	●	●	●	●	●								
170		JS565	●	○	●	●	●	●	●	●	●	●	●								
354		JS720			●	●					●	●									
374		JS730			●	●					●	●									
326		JS754		○	●	●					●	●									
343		JS755		○	●	●					●	●									
474	HSM/TORNADO	JH40						●		●				●							
313, 517		JH112					●						●								
507		JH120											●								
509		JH130											●								
303, 514		JH142	●	●			●						●								
520		JH150					●						●								
522		JH160	●	○									●								
481		JH410						●		●				●							
477		JH421						●		●				●			●				
483		JH440						●	●	●				●			●				
488		JH450						●	●	●				●			●				
490		JH460						●		●		●		●			●				
417		JH710									●	●									
427		JHB720			●	●		●	●	●	○	●		●			●				
429		JH721									●	●									
431		JH722									●	●									
431		JH724			●	●					●	●									
431		JH726			●	●					●	●									
421		JH730									●	●									
405		JH734	○	●	●						○	●									
407		JH736	○	●	●						○	●									
415		JH740									●	●									
409		JH744	○	●	●						○	●									
411		JH746	○	●	●						○	●									
413		JH770									●	●									
425		JH780									●	●									
419		JH790									●	●									
222		JH910	●	○	●	●	●				●	●					●				●
226, 511		JH930	●	○			●				●	●	●								
228, 311		JHB970	●	○	●	●					●	●									

● Prima scelta ○ Scelta alternativa

Riassunto

Pagina(e)	Famiglia	Nome	P1-8	P11-12	M1-3	M4-5	K1-7	N1	N2-3	N11	S1-3	S11-13	H3-31	TS1	TS2-3	TP1	TP2-3	TS2/TP2+N1	TS2/TP2+S12	A nido d'ape	GR
306	Stabilizer	ST5341	●	●			●														
276		ST5541	●	●			●														
140		ST5551	●	●	●	●	●	●	●	●	●	●	●	●		●					○
501	HPM	JHP170											●								
470	Solid²	S4931						●	●												
378	HPM	JHP751									●	●									
381		JHP760			●	●															
385		JHP770										●									
392		JHP780									●										
381		JHP794			●	●															
299		JHP951	●	○			●														
293		JHP993	●	○			●														
423		JHP994									●	●									
504	HFM	JHF181	○	○			●				●	●	●								
504		SHF712																			
230		JHF980	●	○	●	●	●				●	●	○								
531	MINI	JMB112											●								
524		JME142											●								
529		JME144											●								
494		JM403/404/406						●	●												
496		JM413/416						●	●	●				●		●					
496		SMB413/414/416						●	●					●		●					
264		JMB542	●	●	●	●		○	○	○		●	○								○
267		JMB562	●	●	●	●		○	○	○		●	○								○
271		JMB563	●	●	●	●		○	○	○		●	○								○
254		JME542	●	●	●	●		○	○	○		●	○								○
257		JME562	●	●	●	●		○	○	○		●	○								○
261		JME564	●	●	●	●		○	○	○		●	○								○
261		SMB713/714/416																			
261		JME714/716									●	●									
606	MINI DIAMOND	JMB642/JMB662																			●
606		JMB662																			●
604		JME642																			●
604		SMB614/616																			●
594	DIAMOND	JD620																			●
596		JD630																			●
598		JD640																			●
600		JD660																			●
539	COMPOSITE	D8961													●		●				
542		JC845													●		●				
544		JC850													●		●				
546		JC860													●		●			●	
548		JC870													●		●			●	
554		JC871													●		●			●	
560		JC875													●		●				
564		JC876													●		●				
568		JC877													●		●				
572		JC880													●		●				
574		JC885													●		●				
576		JC898																●	●		
578		JC899																●	●		
581	PCD	JPD850													●		●				
583		JPD880													●		●				
585		JPD890													●		●				

Riassunto

Pagina(e)	Famiglia	Nome	P1-8	P11-12	M1-3	M4-5	K1-7	N1	N2-3	N11	S1-3	S11-13	H3-31	TS1	TS2-3	TS4	TP1	TP2-3	TP4	A nido d'ape	GR
589	VHM	J28												●							
237		J36	○	●	○	○	○	○	●	●	○	○		○			○				
240		HK/HKM	●		●	●	●	●	○		●	●	●	●			●				
251		V31	●	○	●	○	●	●	●	●	●	●	●	●			●				●
234		J29	●	●	●	●	●	●	●	●	●	●	○	●			●				●
587		J93F												●			●				
399	Ceramic	JCG790									●										
669	X-HEADS SOLID²	XS5021	●	●	●	●	●	○	○	○	○	○	●	●			●				○
671		XS5061	●	●	●	●	●	○	○	○	○	○	●	●			●				○
620		XSE550	●	●	●	●	●	●	●	●	●	●	●	●			●				○
637		XSB540	●	○	●	●	●	●	●	●	○	●	○	●			●				○
639		XSE720	○	●	●	●					●	●									
651		XSE450						●	●	●				●			●				
645		XSB720	○	●	●	●					●	●									
655	X-HEADS HSM/TORNADO	XHT740	○	●	●						○	●									
658	X-HEADS HFM	XHF580	●	●	●	●	●				○	○	○								
663		XHF780	○	○	●	●					●	●	○								
680	X-HEADS VHM	XVE540	●	●	●	●	●	●	●	●	○	○	○	●			●				○
685		XVE510	●	●	●	●	●	○	○	○	○	○		●			●				○
688		XVB510	●	●	●	●	●	○	○	○	○	○		●			●				○
692		XVC506/509/512	●	●	●	●	●	○	○	○	○	○		●			●				○
696		XVK310	●	●	●	●	●	●	●	●	○	○	○	●			●				○

● Prima scelta ○ Scelta alternativa

Chiave di codifica

Frese in metallo duro integrale (novità)

R	S	4321	-	100	D	2	R050	.0	Z3	C	,	AXT
1	2	3		5	6	7	8	9	10	11		12

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

CAMPO VUOTO = Prodotto standard (da catalogo)
R = Prodotto ripristinato (completamente)
RK = Prodotto ripristinato (frontalmente)

2. Gamma prodotti

J = VHM
JC = Compositi
JD = Diamante
JH = HSM/Tornado
JHF = HFM
JHP = HPM
JM = Mini
JS = SOLID²
JPD = PCD (diamante policristallino)
JCO = HSS-Co
JCG = Ceramico
C = serie C
ST = Stabilizer
XS* = X-Head SOLID²
XH* = X-Head HSM/Tornado
XV* = X-Head VHM
XHF = X-Head HFM

3. Geometria

Combinazione di tre cifre per specificare la geometria di taglio. Esempio: 111, 950, 553, 514, ecc.

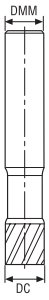
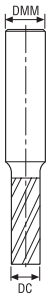
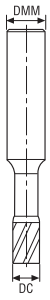
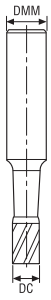
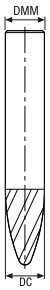
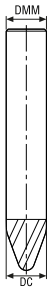
4. Dimensione filetto di connessione

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

5. Diametro

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

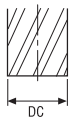
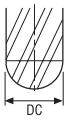
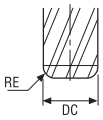
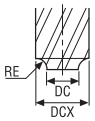
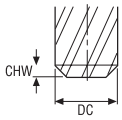
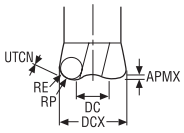
12. Qualità

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

X = stelo cilindrico X-Head

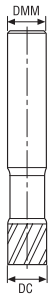
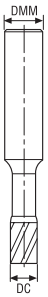
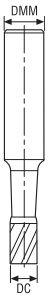
2. Dimensione filetto di connessione

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

3. Diametro dello stelo

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

Cifra che indica la lunghezza della fresa rispetto ad altre frese con la stessa geometria di taglio.

6. Lunghezza totale

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

Indica il semi-angolo di conicità del corpo.
Esempio: (00 = 0°;0°; 05 = 5°; 10 = 10°)

8. Tipo di stelo

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

9. Tipo di materiale

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.

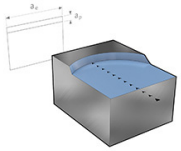
Benefici del ripristino

- 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:

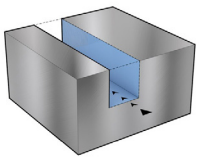
Spianatura:

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.



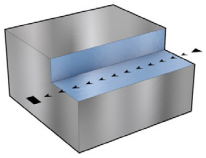
Scanalatura:

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.



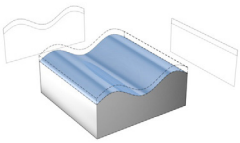
Contornatura:

Operazione in cui viene impegnato il fianco dell'utensile, a_p è grande mentre a_e è piccolo.



Copiatura:

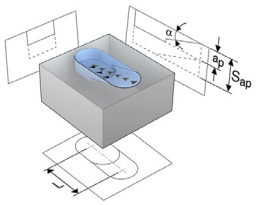
Operazione in cui il raggio utensile è completamente impegnato, a_p ed a_e sono entrambi piccoli.



Strategie di lavorazione avanzate:

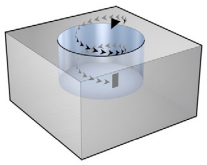
Entrata in rampa:

Apertura di una tasca sull'asse Z con un certo angolo.



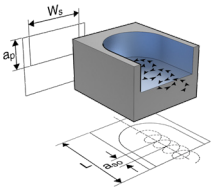
Interpolazione elicoidale:

Apertura di una tasca attraverso un movimento circolare con l'utensile mentre è in rampa sull'asse Z.



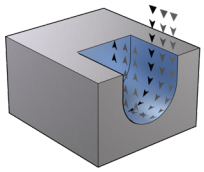
Fresatura trocoidale:

Apertura di una scanalatura attraverso una contornatura, con movimenti circolari parziali sugli assi X o Y. (si passa da scanalatura a contornatura).



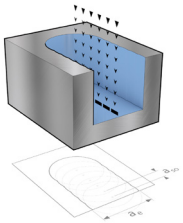
Push-pull (spingi-tira):

Lavorazione di una forma 3D in copiatura, contornatura invece di scanalatura, seguendo il profilo del pezzo.



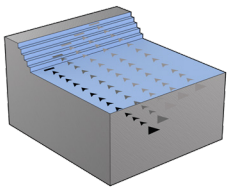
Penetrazione assiale:

Apertura di una scanalatura tramite movimento in Z.



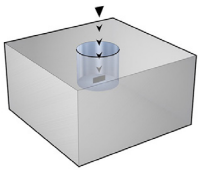
Per piani paralleli:

Lavorazione di una superficie mediante una piccola foratura o rampa in Z e quindi apertura della tasca con movimenti X e Y.



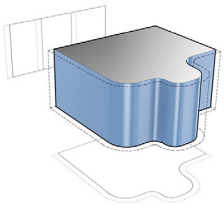
Foratura:

Realizzazione di un foro sull'asse Z.



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 (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 tagliente 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?

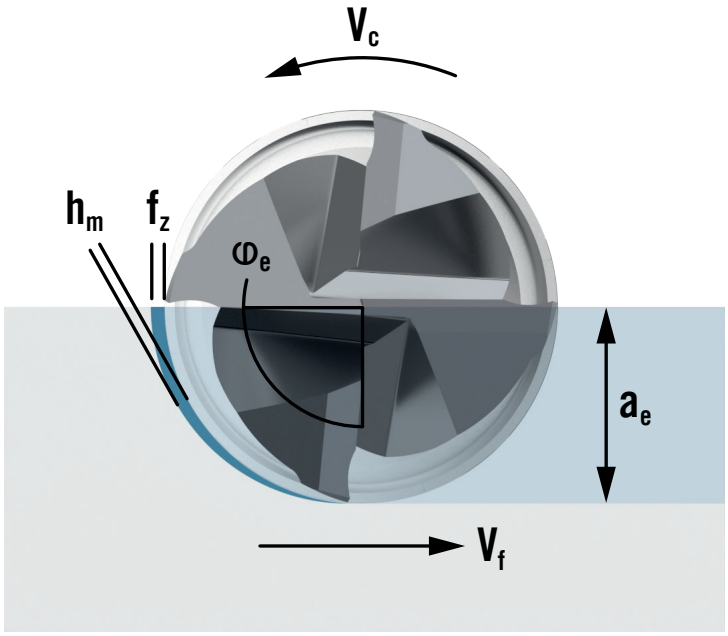
I pacchetti CAM di oggi offrono strategie di lavorazione specifiche per raggi sia interni che esterni, dove il cambiamento degli archi di contatto è comune, utilizzando strategie tradizionali. Questi pacchetti software applicano automaticamente avanzamenti differenti per controllare l'arco di contatto 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 Seco 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 necessario 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, scanalatura, 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 Seco Ceramic sono disponibili a pagina 399.

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

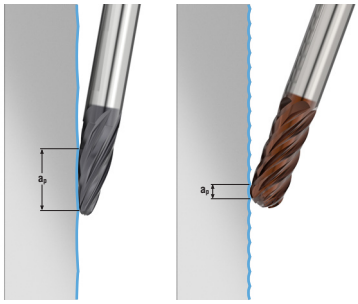


JC899 dispone di una geometria doppia "due in uno" , soluzione brevettata, progettata per la lavorazione di materiali stratificati ibridi come CFRP-Ti e CFRP-Alu. Grazie alla geometria di taglio destra con elica sinistrorsa, questo utensile evita la delaminazione, lo strappo delle fibre e segni di truciolo sulla 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 ad 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.

Seco JC898/JC899 sono disponibili alle pagine 576 - 578.

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

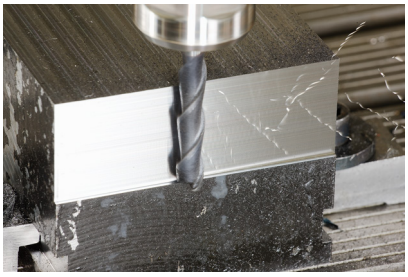


Ottenete accuratezza, precisione e un'elevata qualità della finitura superficiale fin dall'inizio della lavorazione di superfici piccole, con dimensioni micro, grazie alla gamma di frese integrali Seco. Le nuove gamme di prodotti SECO Mini garantiscono una maggiore durata utensile, stabilità e tranquillità 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 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 Seco Mini è disponibile a pagina 12.

Finitore ad elica lunga JS522



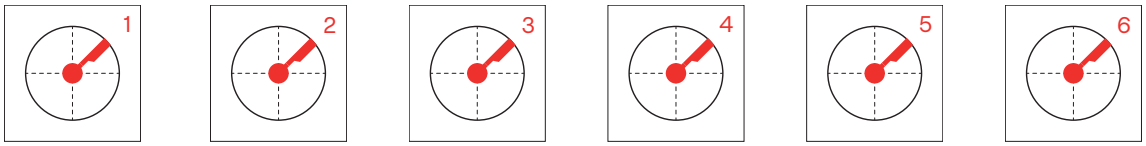
La fresa di finitura ad elica lunga JS522 è in grado di soddisfare i severi requisiti di perpendicolarità dell'industria aerospaziale e garantisce un'ottima finitura superficiale, un'elevata asportazione e lavorazioni più efficienti.

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.

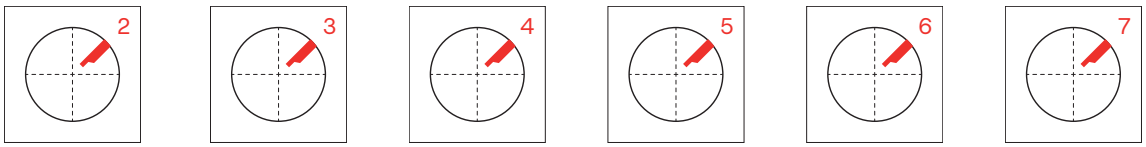
Una volta posizionato e ottimizzato, si è dimostrato la soluzione migliore in termini di risparmio economico in molteplici applicazioni.

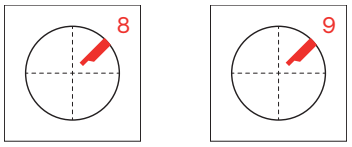
Gli utensili Seco JS522 sono disponibili alla pagina 178.

Tagliente al centro PCEDC

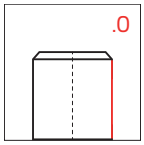


No tagliente al centro PCEDC

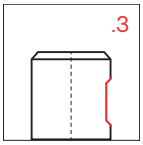




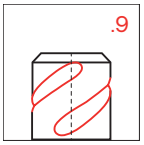
Codolo cilindrico



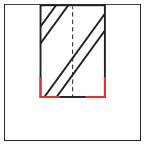
Attacco Weldon



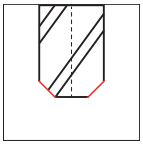
Attacco Safelock



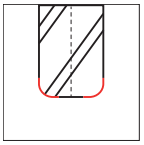
Spigolo vivo



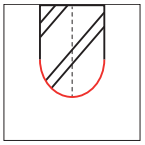
Smusso



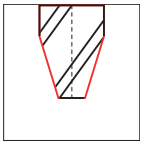
Raggio di punta



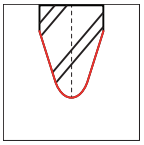
A testa sferica



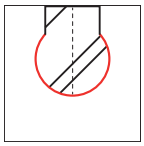
Spigolo vivo conico



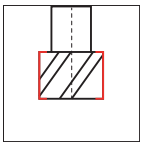
Frese sferico-



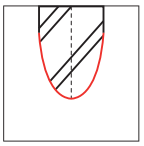
Fresa 250°



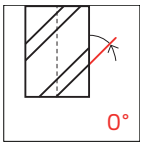
Frese a T

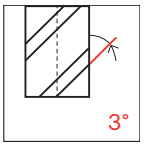


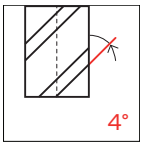
A barile

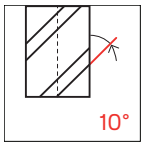


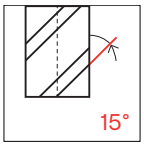
Angolo dell'elica

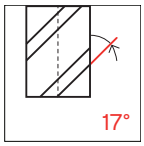


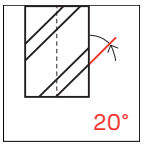


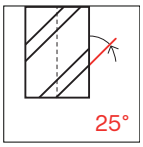


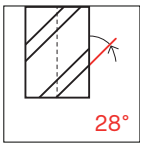


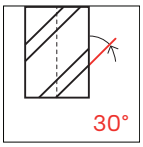


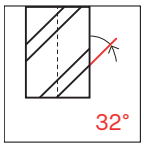


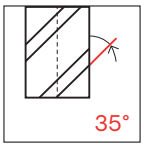


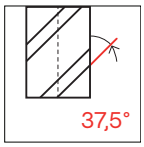


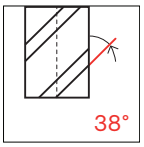


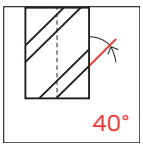


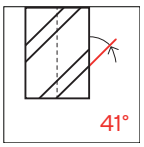


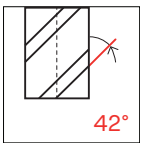


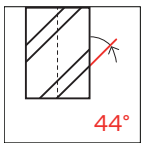


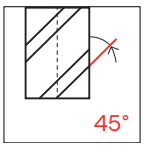


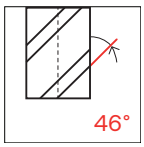


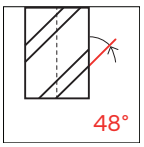


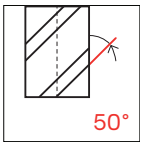




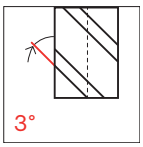


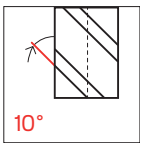


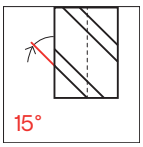




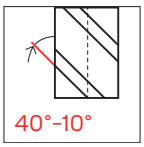
Angolo dell'elica Sinistro



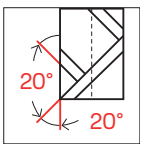


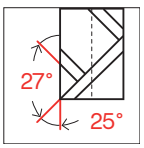


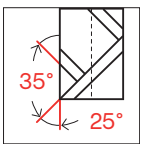
Doppia elica sinistra

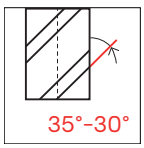


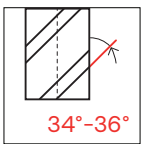
Doppia elica

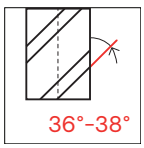


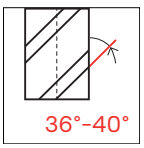


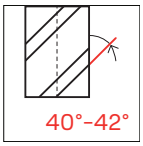




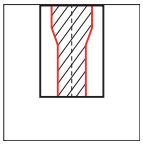




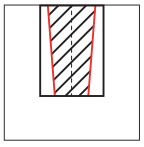




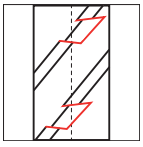
Doppia anima



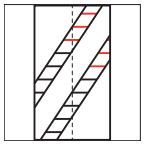
Anima conica



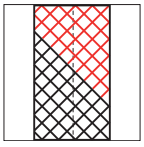
Rompitruciolo



Profilo di sgros-



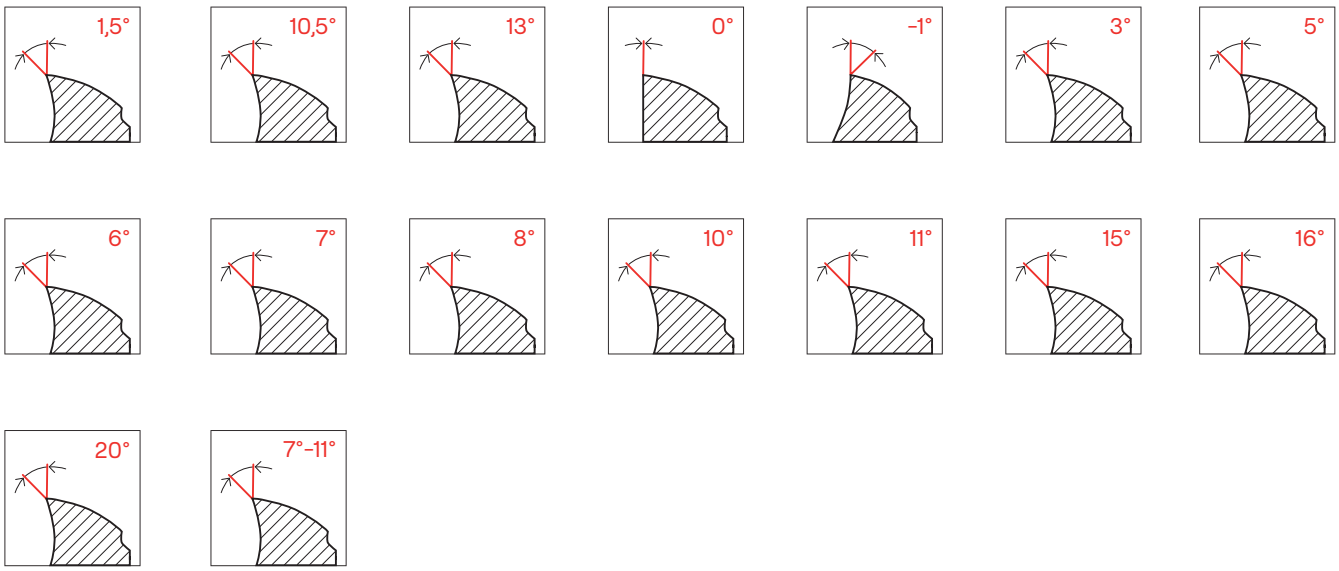
Geometria di



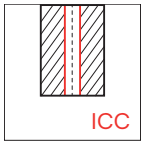
Angolo di taglio Rinforzo angolare



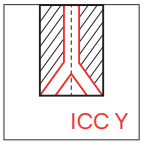
Angolo di taglio Rinforzo radiale



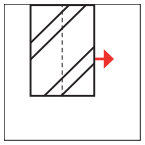
ICC dritto



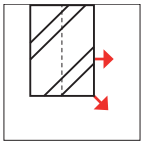
ICC e Y



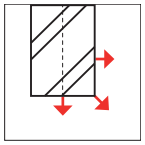
Radiale



Radiale/Entrata in



Radiale/Entrata in



Simboli chiave

DIAMOND

DIAMOND

DURA

DURA

HEMI

HEMI

HSCO

HSCO

HXT

HXT

MEGA

MEGA

MEGA-T

MEGA-T

MEGA-64

MEGA-64

MEGA-64-T

MEGA-64-T

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PCD

PCD

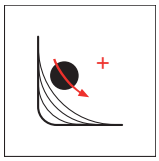
M9

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
CSP	Proprietà di alimentazione del 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.

- C5121, C5131, C5141, C5231, C5241 e ST5551 con tagliente a spigolo vivo.
- JSE512, JSE513, JSE514, JS553, JS554, ST5551, JS564, JS565 e JS520 con smusso a 45°.
- C5121, C5141, JS522, JS553, JS554, ST5551, JH910, JH930, JHF980, J36, V31, JME542, JME562 e JME564 con raggio frontale.
- C5021, C5041, JS506, JS509, HK, HKM e J29 coniche.
- C5321, C5341, JSB512, JS532, JS533, JS534, JHB970, JMB542, JMB562 e JMB563 a testa sferica.

Selezione utensile universale

									
Nome		C5121	C5131	C5141	C5231	C5241	JSE512	JSE513	JSE514
Pag.		38	50	56	73	73	75	79	85
Famiglia		C-Series	C-Series	C-Series	C-Series	C-Series	SOLID²	SOLID²	SOLID²
Tipo di fresa									
Attacco	Cilindrico	■	■	■	■	■	■	■	■
	Weldon	■		■			■	■	■
Numero di eliche		2	3	4	3	4	2	2	4
CSP									
	Metrico	2-12	2-12	1-20			2-12	2-20	2-25
	Pollici	1/32-1	1/32-1	1/64-1 1/4	1/-5/8	3/4			
Lunghezze disponibili		1,2,3,4,5,6,7,8	1,2,3,4	1,2,3,4,5,6,7,8,9	2,3	3	2	2,3	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		JS553	JS554	ST5551	JS564	JS565	JS520	JS522	C5321	C5341
Pag.		95	115	140	166	170	174	178	181	189
Famiglia		SOLID²	SOLID²	Stabilizer	SOLID²	SOLID²	SOLID²	SOLID²	C-Series	C-Series
Tipo di fresa										
Attacco	Cilindrico	■	■	■	■	■	■	■	■	■
	Weldon	■	■	□	■	■	□			
Numero di eliche		3	4	5	4	5	5,6,8	2	2	4
CSP										
	Metrico	2-25	3-25	6-25	3-20	4-20	4-25	6-32	1-12	1-20
	Pollici	1/8 - 1/2	1/4-1	1/4-1					1/64-1	1/64-1
Lunghezze disponibili		1,2,3	1,2,3	1,2,3,4,5,6,8	2,3,4	2,3,4	2,3	4	1,2,3,4,5,6,7	1,2,3,4,5,6,7,8
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		JSB512	JS532	JS533	JS534	C5021	C5041	JS506	JS509
Pag.		196	198	202	206	210	212	214	218
Famiglia		SOLID²	SOLID²	SOLID²	SOLID²	C-Series	C-Series	SOLID²	SOLID²
Tipo di fresa									
Attacco	Cilindrico	■	■	■	■	■	■	■	■
	Weldon		□	■	■			■	■
Numero di eliche		2	2	3	4	2	4	3-4	3-4
CSP									
	Metrico	2-12	1-20	1-20	2-20			3-12	3-12
	Pollici					1/4-1/2	1/4-3/4		
Lunghezze disponibili		2	1,2,3	1,2	1,2,3	1	1	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.		222	226, 511	228, 311	230
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
CSP					
	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.		234	237	240	251
Famiglia		VHM	VHM	VHM	VHM
Tipo di fresa					
Attacco	Cilindrico	■	■	■	■
	Weldon				
Numero di eliche		1	3	2,3,4	4
CSP					
	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

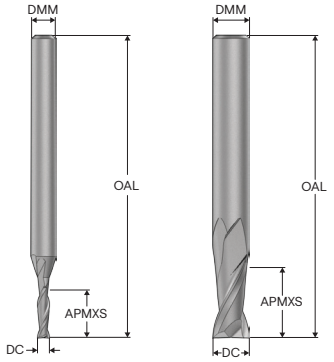
							
Nome		JME542	JME562	JME564	JMB542	JMB562	JMB563
Pag.		254	257	261	264	267	271
Famiglia		MINI	MINI	MINI	MINI	MINI	MINI
Tipo di fresa							
Attacco	Cilindrico	■	■	■	■	■	■
	Weldon						
Numero di eliche		2	2	4	2	2	3
CSP							
	Metrico	2-20	0,5-3,0	0,5-3,0	0,2-3,0	0,5-3,0	1,0-3,0
	Pollici						
Lunghezze 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

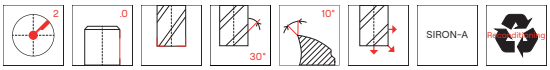
C5121

Uso generico – Universale – Spallamento – 2 Eliche – Cilindrico – Spigolo vivo





—Tolleranze:
—DMM=h5
—DC= h10
—Riaffilatura possibile se DC è ≥Ø10



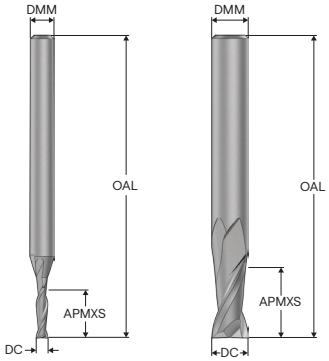
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm			
C5121-060D1S.0Z2	SIRA	10269100	1	D	6,0	6,0	9,0	57,0	2	Cylindrical	■
C5121-020F2S.0Z2	SIRA	10269091	2	F	2,0	3,0	4,0	38,0	2	Cylindrical	■
C5121-030D2S.0Z2	SIRA	10269093	2	D	3,0	3,0	6,0	38,0	2	Cylindrical	■
C5121-040D2S.0Z2	SIRA	10269096	2	D	4,0	4,0	8,0	50,0	2	Cylindrical	■
C5121-050F2S.0Z2	SIRA	10269098	2	F	5,0	6,0	10,0	57,0	2	Cylindrical	■
C5121-060D2S.0Z2	SIRA	10269101	2	D	6,0	6,0	12,0	57,0	2	Cylindrical	■
C5121-080D2S.0Z2	SIRA	10269103	2	D	8,0	8,0	16,0	63,0	2	Cylindrical	■
C5121-090F2S.0Z2	SIRA	10269105	2	F	9,0	10,0	22,0	72,0	2	Cylindrical	■
C5121-100D2S.0Z2	SIRA	10269106	2	D	10,0	10,0	22,0	72,0	2	Cylindrical	■
C5121-120D2S.0Z2	SIRA	10269108	2	D	12,0	12,0	25,0	83,0	2	Cylindrical	■
C5121-015F3S.0Z2	SIRA	10269090	3	F	1,5	3,0	4,5	38,0	2	Cylindrical	■
C5121-020F3S.0Z2	SIRA	10269092	3	F	2,0	3,0	6,3	38,0	2	Cylindrical	■
C5121-035F3S.0Z2	SIRA	10269095	3	F	3,5	4,0	12,0	50,0	2	Cylindrical	■
C5121-050F3S.0Z2	SIRA	10269099	3	F	5,0	6,0	16,0	57,0	2	Cylindrical	■
C5121-060D3S.0Z2	SIRA	10269102	3	D	6,0	6,0	19,0	63,0	2	Cylindrical	■
C5121-080D3S.0Z2	SIRA	10269104	3	D	8,0	8,0	20,0	63,0	2	Cylindrical	■
C5121-010F4S.0Z2	SIRA	10269089	4	F	1,0	3,0	4,0	38,0	2	Cylindrical	■
C5121-030D4S.0Z2	SIRA	10269094	4	D	3,0	3,0	12,0	38,0	2	Cylindrical	■
C5121-040D4S.0Z2	SIRA	10269097	4	D	4,0	4,0	14,0	50,0	2	Cylindrical	■
C5121-100D4S.0Z2	SIRA	10269107	4	D	10,0	10,0	35,0	89,0	2	Cylindrical	■
C5121-120D4S.0Z2	SIRA	10269109	4	D	12,0	12,0	50,0	100,0	2	Cylindrical	■

■ **Prodotto standard.**

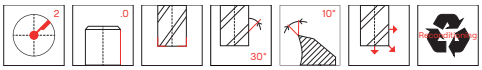
C5121

Uso generico – Universale – Spallamento – 2 Eliche – Cilindrico – Spigolo vivo – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Riaffilatura possibile se DC è ≥Ø.375

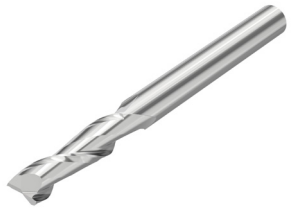


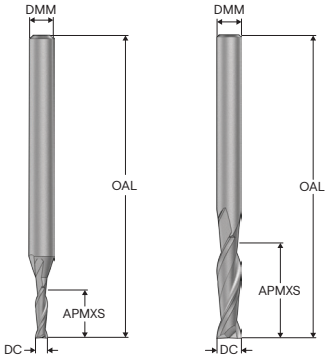
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
				inch	inch	inch	inch			
C5121-.375D1S.0Z2	10268850	1	D	0.375	0.375	0.625	2.000	2	Cylindrical	■
C5121-.500D1S.0Z2	10268858	1	D	0.500	0.500	0.625	2.500	2	Cylindrical	■
C5121-.047F2S.0Z2	10268818	2	F	0.047	0.125	0.109	1.500	2	Cylindrical	■
C5121-.063F2S.0Z2	10268820	2	F	0.063	0.125	0.125	1.500	2	Cylindrical	■
C5121-.094F2S.0Z2	10268824	2	F	0.094	0.125	0.188	1.500	2	Cylindrical	■
C5121-.125D2S.0Z2	10268828	2	D	0.125	0.125	0.250	1.500	2	Cylindrical	■
C5121-.156F2S.0Z2	10268833	2	F	0.156	0.188	0.313	2.000	2	Cylindrical	■
C5121-.188D2S.0Z2	10268835	2	D	0.188	0.188	0.375	2.000	2	Cylindrical	■
C5121-.250D2S.0Z2	10268841	2	D	0.250	0.250	0.500	2.000	2	Cylindrical	■
C5121-.313D2S.0Z2	10268846	2	D	0.313	0.313	0.500	2.000	2	Cylindrical	■
C5121-.375D2S.0Z2	10268851	2	D	0.375	0.375	1.000	2.500	2	Cylindrical	■
C5121-.438D2S.0Z2	10268856	2	D	0.438	0.438	1.000	2.750	2	Cylindrical	■
C5121-.500D2S.0Z2	10268859	2	D	0.500	0.500	1.000	3.000	2	Cylindrical	■
C5121-.563D2S.0Z2	10268864	2	D	0.563	0.563	1.125	3.500	2	Cylindrical	■
C5121-.625D2S.0Z2	10268865	2	D	0.625	0.625	1.250	3.500	2	Cylindrical	■
C5121-.750D2S.0Z2	10268869	2	D	0.750	0.750	1.500	4.000	2	Cylindrical	■
C5121-.875D2S.0Z2	10268872	2	D	0.875	0.875	1.500	4.000	2	Cylindrical	■
C5121-1.000D2S.0Z2	10268873	2	D	1.000	1.000	1.500	4.000	2	Cylindrical	■
C5121-.031F3S.0Z2	10268690	3	F	0.031	0.125	0.078	1.500	2	Cylindrical	■
C5121-.047F3S.0Z2	10268819	3	F	0.047	0.125	0.125	1.500	2	Cylindrical	■
C5121-.063F3S.0Z2	10268821	3	F	0.063	0.125	0.188	1.500	2	Cylindrical	■
C5121-.078F3S.0Z2	10268823	3	F	0.078	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F3S.0Z2	10268825	3	F	0.094	0.125	0.281	1.500	2	Cylindrical	■
C5121-.109F3S.0Z2	10268827	3	F	0.109	0.125	0.375	1.500	2	Cylindrical	■
C5121-.156F3S.0Z2	10268834	3	F	0.156	0.188	0.500	2.000	2	Cylindrical	■
C5121-.188D3S.0Z2	10268836	3	D	0.188	0.188	0.625	2.000	2	Cylindrical	■
C5121-.203F3S.0Z2	10268839	3	F	0.203	0.250	0.625	2.500	2	Cylindrical	■
C5121-.219F3S.0Z2	10268840	3	F	0.219	0.250	0.625	2.500	2	Cylindrical	■
C5121-.250D3S.0Z2	10268842	3	D	0.250	0.250	0.750	2.500	2	Cylindrical	■
C5121-.281F3S.0Z2	10268845	3	F	0.281	0.313	0.750	2.500	2	Cylindrical	■
C5121-.313D3S.0Z2	10268847	3	D	0.313	0.313	0.813	2.500	2	Cylindrical	■
C5121-.375D3S.0Z2	10268852	3	D	0.375	0.375	1.000	3.000	2	Cylindrical	■
C5121-.500D3S.0Z2	10268860	3	D	0.500	0.500	1.000	4.000	2	Cylindrical	■

■ **Prodotto standard.**

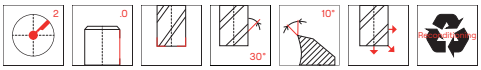
C5121

Uso generico – Universale – Spallamento – 2 Eliche – Cilindrico – Spigolo vivo – Pollici





– Tolleranze:
– DMM=-.0001"/-.0004"
– DC ≤ Ø7/64" = ±.0005"
– DC > Ø7/64" = +.000"/-.002"
– Riaffilatura possibile se DC è ≥Ø.375



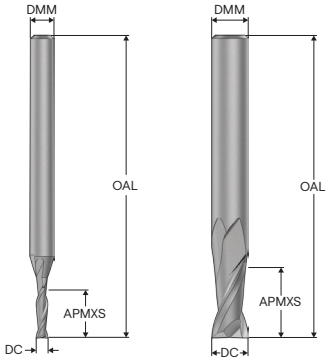
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
				inch	inch	inch	inch			
C5121-.031F4S.0Z2	10268817	4	F	0.031	0.125	0.094	1.500	2	Cylindrical	■
C5121-.063F4S.0Z2	10268822	4	F	0.063	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F4S.0Z2	10268826	4	F	0.094	0.125	0.375	1.500	2	Cylindrical	■
C5121-.125D4S.0Z2	10268829	4	D	0.125	0.125	0.500	1.500	2	Cylindrical	■
C5121-.188D4S.0Z2	10268837	4	D	0.188	0.188	0.750	2.500	2	Cylindrical	■
C5121-.250D4S.0Z2	10268843	4	D	0.250	0.250	1.000	3.000	2	Cylindrical	■
C5121-.313D4S.0Z2	10268848	4	D	0.313	0.313	1.000	3.000	2	Cylindrical	■
C5121-.375D4S.0Z2	10268853	4	D	0.375	0.375	1.000	4.000	2	Cylindrical	■
C5121-.500D4S.0Z2	10268861	4	D	0.500	0.500	1.500	6.000	2	Cylindrical	■
C5121-.625D4S.0Z2	10268866	4	D	0.625	0.625	2.250	5.000	2	Cylindrical	■
C5121-.750D4S.0Z2	10268870	4	D	0.750	0.750	2.250	5.000	2	Cylindrical	■
C5121-.125D5S.0Z2	10268830	5	D	0.125	0.125	0.625	2.000	2	Cylindrical	■
C5121-.375D5S.0Z2	10268854	5	D	0.375	0.375	1.125	3.000	2	Cylindrical	■
C5121-.438D5S.0Z2	10268857	5	D	0.438	0.438	2.000	4.000	2	Cylindrical	■
C5121-.500D5S.0Z2	10268862	5	D	0.500	0.500	2.000	4.000	2	Cylindrical	■
C5121-.625D5S.0Z2	10268867	5	D	0.625	0.625	3.000	6.000	2	Cylindrical	■
C5121-.750D5S.0Z2	10268871	5	D	0.750	0.750	3.000	6.000	2	Cylindrical	■
C5121-.125D6S.0Z2	10268831	6	D	0.125	0.125	0.750	3.000	2	Cylindrical	■
C5121-.188D6S.0Z2	10268838	6	D	0.188	0.188	1.000	4.000	2	Cylindrical	■
C5121-.375D6S.0Z2	10268855	6	D	0.375	0.375	1.500	6.000	2	Cylindrical	■
C5121-.250D7S.0Z2	10268844	7	D	0.250	0.250	1.500	4.000	2	Cylindrical	■
C5121-.500D7S.0Z2	10268863	7	D	0.500	0.500	3.000	6.000	2	Cylindrical	■
C5121-.125D8S.0Z2	10268832	8	D	0.125	0.125	1.000	3.000	2	Cylindrical	■

■ **Prodotto standard.**

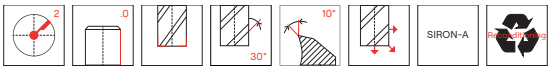
C5121

Uso generico – Universale – Spallamento – 2 Eliche – Cilindrico – Spigolo vivo – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Riaffilatura possibile se DC è ≥Ø.375



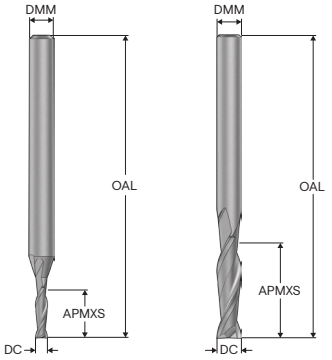
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5121-.375D1S.0Z2	SIRA	10268726	1	D	0.375	0.375	0.625	2.000	2	Cylindrical	■
C5121-.500D1S.0Z2	SIRA	10268734	1	D	0.500	0.500	0.625	2.500	2	Cylindrical	■
C5121-.047F2S.0Z2	SIRA	10268693	2	F	0.047	0.125	0.109	1.500	2	Cylindrical	■
C5121-.063F2S.0Z2	SIRA	10268695	2	F	0.063	0.125	0.125	1.500	2	Cylindrical	■
C5121-.094F2S.0Z2	SIRA	10268699	2	F	0.094	0.125	0.188	1.500	2	Cylindrical	■
C5121-.125D2S.0Z2	SIRA	10268703	2	D	0.125	0.125	0.250	1.500	2	Cylindrical	■
C5121-.156F2S.0Z2	SIRA	10268708	2	F	0.156	0.188	0.313	2.000	2	Cylindrical	■
C5121-.188D2S.0Z2	SIRA	10268710	2	D	0.188	0.188	0.375	2.000	2	Cylindrical	■
C5121-.250D2S.0Z2	SIRA	10268716	2	D	0.250	0.250	0.500	2.000	2	Cylindrical	■
C5121-.313D2S.0Z2	SIRA	10268722	2	D	0.313	0.313	0.500	2.000	2	Cylindrical	■
C5121-.375D2S.0Z2	SIRA	10268727	2	D	0.375	0.375	1.000	2.500	2	Cylindrical	■
C5121-.438D2S.0Z2	SIRA	10268732	2	D	0.438	0.438	1.000	2.750	2	Cylindrical	■
C5121-.500D2S.0Z2	SIRA	10268735	2	D	0.500	0.500	1.000	3.000	2	Cylindrical	■
C5121-.563D2S.0Z2	SIRA	10268740	2	D	0.563	0.563	1.125	3.500	2	Cylindrical	■
C5121-.625D2S.0Z2	SIRA	10268741	2	D	0.625	0.625	1.250	3.500	2	Cylindrical	■
C5121-.750D2S.0Z2	SIRA	10268745	2	D	0.750	0.750	1.500	4.000	2	Cylindrical	■
C5121-.875D2S.0Z2	SIRA	10268748	2	D	0.875	0.875	1.500	4.000	2	Cylindrical	■
C5121-1.000D2S.0Z2	SIRA	10268749	2	D	1.000	1.000	1.500	4.000	2	Cylindrical	■
C5121-.031F3S.0Z2	SIRA	10268691	3	F	0.031	0.125	0.078	1.500	2	Cylindrical	■
C5121-.047F3S.0Z2	SIRA	10268694	3	F	0.047	0.125	0.125	1.500	2	Cylindrical	■
C5121-.063F3S.0Z2	SIRA	10268696	3	F	0.063	0.125	0.188	1.500	2	Cylindrical	■
C5121-.078F3S.0Z2	SIRA	10268698	3	F	0.078	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F3S.0Z2	SIRA	10268700	3	F	0.094	0.125	0.281	1.500	2	Cylindrical	■
C5121-.109F3S.0Z2	SIRA	10268702	3	F	0.109	0.125	0.375	1.500	2	Cylindrical	■
C5121-.156F3S.0Z2	SIRA	10268709	3	F	0.156	0.188	0.500	2.000	2	Cylindrical	■
C5121-.188D3S.0Z2	SIRA	10268711	3	D	0.188	0.188	0.625	2.000	2	Cylindrical	■
C5121-.203F3S.0Z2	SIRA	10268714	3	F	0.203	0.250	0.625	2.500	2	Cylindrical	■
C5121-.219F3S.0Z2	SIRA	10268715	3	F	0.219	0.250	0.625	2.500	2	Cylindrical	■
C5121-.250D3S.0Z2	SIRA	10268717	3	D	0.250	0.250	0.750	2.500	2	Cylindrical	■
C5121-.281F3S.0Z2	SIRA	10268721	3	F	0.281	0.313	0.750	2.500	2	Cylindrical	■
C5121-.313D3S.0Z2	SIRA	10268723	3	D	0.313	0.313	0.813	2.500	2	Cylindrical	■
C5121-.344F3S.0Z2	SIRA	10268725	3	F	0.344	0.375	1.000	2.500	2	Cylindrical	■
C5121-.375D3S.0Z2	SIRA	10268728	3	D	0.375	0.375	1.000	3.000	2	Cylindrical	■
C5121-.500D3S.0Z2	SIRA	10268736	3	D	0.500	0.500	1.000	4.000	2	Cylindrical	■

■ **Prodotto standard.**

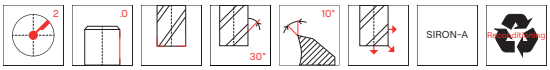
C5121

Uso generico – Universale – Spallamento – 2 Eliche – Cilindrico – Spigolo vivo – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Riaffilatura possibile se DC è ≥Ø.375



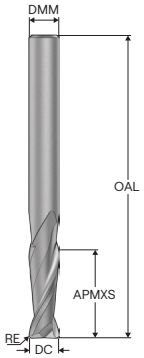
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5121-.031F4S.0Z2	SIRA	10268692	4	F	0.031	0.125	0.094	1.500	2	Cylindrical	■
C5121-.063F4S.0Z2	SIRA	10268697	4	F	0.063	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F4S.0Z2	SIRA	10268701	4	F	0.094	0.125	0.375	1.500	2	Cylindrical	■
C5121-.125D4S.0Z2	SIRA	10268704	4	D	0.125	0.125	0.500	1.500	2	Cylindrical	■
C5121-.188D4S.0Z2	SIRA	10268712	4	D	0.188	0.188	0.750	2.500	2	Cylindrical	■
C5121-.250D4S.0Z2	SIRA	10268718	4	D	0.250	0.250	1.000	3.000	2	Cylindrical	■
C5121-.313D4S.0Z2	SIRA	10268724	4	D	0.313	0.313	1.000	3.000	2	Cylindrical	■
C5121-.375D4S.0Z2	SIRA	10268729	4	D	0.375	0.375	1.000	4.000	2	Cylindrical	■
C5121-.500D4S.0Z2	SIRA	10268737	4	D	0.500	0.500	1.500	6.000	2	Cylindrical	■
C5121-.750D4S.0Z2	SIRA	10268746	4	D	0.750	0.750	2.250	5.000	2	Cylindrical	■
C5121-.125D5S.0Z2	SIRA	10268705	5	D	0.125	0.125	0.625	2.000	2	Cylindrical	■
C5121-.375D5S.0Z2	SIRA	10268730	5	D	0.375	0.375	1.125	3.000	2	Cylindrical	■
C5121-.500D5S.0Z2	SIRA	10268738	5	D	0.500	0.500	2.000	4.000	2	Cylindrical	■
C5121-.750D5S.0Z2	SIRA	10268747	5	D	0.750	0.750	3.000	6.000	2	Cylindrical	■
C5121-.125D6S.0Z2	SIRA	10268706	6	D	0.125	0.125	0.750	3.000	2	Cylindrical	■
C5121-.188D6S.0Z2	SIRA	10268713	6	D	0.188	0.188	1.000	4.000	2	Cylindrical	■
C5121-.375D6S.0Z2	SIRA	10268731	6	D	0.375	0.375	1.500	6.000	2	Cylindrical	■
C5121-.250D7S.0Z2	SIRA	10268719	7	D	0.250	0.250	1.500	4.000	2	Cylindrical	■
C5121-.500D7S.0Z2	SIRA	10268739	7	D	0.500	0.500	3.000	6.000	2	Cylindrical	■
C5121-.125D8S.0Z2	SIRA	10268707	8	D	0.125	0.125	1.000	3.000	2	Cylindrical	■

■ **Prodotto standard.**

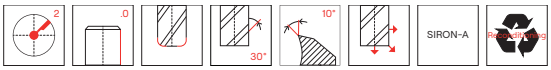
C5121

Uso generico – Universale – Spallamento – 2 Eliche – Cilindrico – Raggio di punta – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.001"
—Riaffilatura possibile se DC è ≥Ø.375



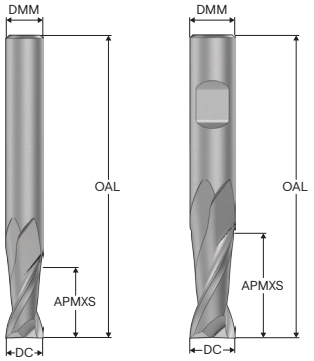
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
C5121-.500D2R015.0Z2	SIRA	10268755	2	D	0.500	0.500	1.000	3.000	0.015	2	Cylindrical	■
C5121-.500D2R030.0Z2	SIRA	10268756	2	D	0.500	0.500	1.000	3.000	0.030	2	Cylindrical	■
C5121-.500D2R060.0Z2	SIRA	10268757	2	D	0.500	0.500	1.000	3.000	0.060	2	Cylindrical	■
C5121-.500D2R125.0Z2	SIRA	10268758	2	D	0.500	0.500	1.000	3.000	0.125	2	Cylindrical	■
C5121-.625D2R015.0Z2	SIRA	10268759	2	D	0.625	0.625	1.250	3.500	0.015	2	Cylindrical	■
C5121-.625D2R030.0Z2	SIRA	10268760	2	D	0.625	0.625	1.250	3.500	0.030	2	Cylindrical	■
C5121-.625D2R125.0Z2	SIRA	10268762	2	D	0.625	0.625	1.250	3.500	0.125	2	Cylindrical	■
C5121-.750D2R015.0Z2	SIRA	10268763	2	D	0.750	0.750	1.500	4.000	0.015	2	Cylindrical	■
C5121-.750D2R030.0Z2	SIRA	10268764	2	D	0.750	0.750	1.500	4.000	0.030	2	Cylindrical	■
C5121-.750D2R060.0Z2	SIRA	10268765	2	D	0.750	0.750	1.500	4.000	0.060	2	Cylindrical	■
C5121-.750D2R125.0Z2	SIRA	10268766	2	D	0.750	0.750	1.500	4.000	0.125	2	Cylindrical	■
C5121-.250D3R015.0Z2	SIRA	10268750	3	D	0.250	0.250	0.750	2.500	0.015	2	Cylindrical	■
C5121-.250D3R030.0Z2	SIRA	10268751	3	D	0.250	0.250	0.750	2.500	0.030	2	Cylindrical	■
C5121-.375D3R015.0Z2	SIRA	10268752	3	D	0.375	0.375	1.000	2.500	0.015	2	Cylindrical	■
C5121-.375D3R030.0Z2	SIRA	10268753	3	D	0.375	0.375	1.000	2.500	0.030	2	Cylindrical	■

■ **Prodotto standard.**

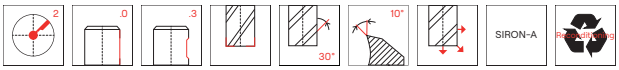
C5121

Uso generico – Universale – Spallamento – 2 Eliche – Cilindrico/Weldon – Spigolo vivo – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.001"/-.000"
—Tolleranza NC
—Riaffilatura possibile se DC è ≥Ø.375



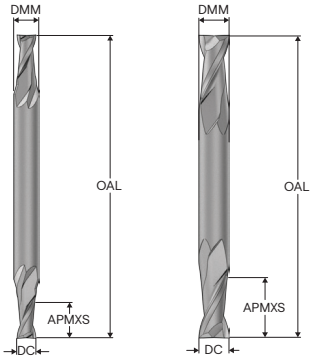
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5121-.375D2S.3Z2NC	SIRA	10269074	2	D	0.375	0.375	0.875	2.500	2	Weldon	■
C5121-.500D2S.3Z2NC	SIRA	10269075	2	D	0.500	0.500	1.000	3.000	2	Weldon	■
C5121-.625D2S.3Z2NC	SIRA	10269076	2	D	0.625	0.625	1.250	3.500	2	Weldon	■
C5121-.750D2S.3Z2NC	SIRA	10269077	2	D	0.750	0.750	1.500	4.000	2	Weldon	■
C5121-.250D3S.0Z2NC	SIRA	10269072	3	D	0.250	0.250	0.750	2.500	2	Cylindrical	■
C5121-.313D3S.0Z2NC	SIRA	10269073	3	D	0.313	0.313	0.813	2.500	2	Cylindrical	■

■ **Prodotto standard.**

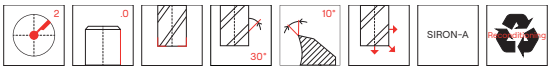
C5121

Uso generico – Universale – Spallamento – 2 Eliche – Cilindrico – Spigolo vivo – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Fresa integrale bilaterale
—Riaffilatura possibile se DC è ≥Ø.375



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5121-.500D1S.0Z2D	SIRA	10269088	1	D	0.500	0.500	0.625	3.000	2	Cylindrical	■
C5121-.031F2S.0Z2D	SIRA	10269078	2	F	0.031	0.125	0.063	1.500	2	Cylindrical	■
C5121-.047F2S.0Z2D	SIRA	10269079	2	F	0.047	0.125	0.094	1.500	2	Cylindrical	■
C5121-.063F2S.0Z2D	SIRA	10269080	2	F	0.063	0.125	0.125	1.500	2	Cylindrical	■
C5121-.078F2S.0Z2D	SIRA	10269081	2	F	0.078	0.125	0.125	1.500	2	Cylindrical	■
C5121-.094F2S.0Z2D	SIRA	10269082	2	F	0.094	0.125	0.188	1.500	2	Cylindrical	■
C5121-.125D2S.0Z2D	SIRA	10269083	2	D	0.125	0.125	0.250	1.500	2	Cylindrical	■
C5121-.188D2S.0Z2D	SIRA	10269084	2	D	0.188	0.188	0.375	2.000	2	Cylindrical	■
C5121-.250D2S.0Z2D	SIRA	10269085	2	D	0.250	0.250	0.500	2.500	2	Cylindrical	■
C5121-.313D2S.0Z2D	SIRA	10269086	2	D	0.313	0.313	0.500	2.500	2	Cylindrical	■
C5121-.375D2S.0Z2D	SIRA	10269087	2	D	0.375	0.375	0.563	2.500	2	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – C5121 Contornatura

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	0,1 *0.10*	2 *2.0*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	150 (135 — 165) *490 (440— 540)*
P2	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	58 (45— 70) *190 (147 — 230)*
P3	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	55 (45— 65) *180 (147 — 213)*
M1	E	0,1 *0.10*	2 *2.0*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,1 *0.10*	2 *2.0*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,1 *0.10*	2 *2.0*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	55 (45 —65) *180 (147 — 213)*
M4	E	0,1 *0.10*	2 *2.0*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,1 *0.10*	2 *2.0*	0,0044 *0.00017*	0,0065 *0.00026*	0,0085 *0.00034*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,034 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	0,05 *0.0020*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,1 *0.10*	2 *2.0*	0,0055 *0.00022*	0,0085 *0.00034*	0,011 *0.00044*	0,017 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,1 *0.10*	2 *2.0*	0,002 *0.000080*	0,0032 *0.00013*	0,0042 *0.00017*	0,0065 *0.00026*	0,0075 *0.00030*	0,0085 *0.00034*	0,01 *0.00040*	0,013 *0.00050*	0,017 *0.00065*	0,019 *0.00075*	0,02 *0.00080*	0,025 *0.0010*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	110 (95— 120) *360 (311 — 390)*
S12	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	30 (20 — 40) *100 (65 — 130)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – JH450 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	150 (135 — 165) *490 (440— 540)*
P2	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	58 (45— 70) *190 (147 — 230)*
P3	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	55 (45— 65) *180 (147 — 213)*
M1	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	55 (45 —65) *180 (147 — 213)*
M4	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,1 *0.10*	2 *2.0*	0,0034 *0.00013*	0,007 *0.00028*	0,014 *0.00055*	0,017 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,11 *0.0044*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,1 *0.10*	2 *2.0*	0,0044 *0.00017*	0,009 *0.00036*	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*	0,07 *0.0028*	0,09 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,1 *0.10*	2 *2.0*	0,0017 *0.000065*	0,0034 *0.00013*	0,0065 *0.00026*	0,0085 *0.00034*	0,01 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	0,017 *0.00065*	0,02 *0.00080*	0,026 *0.0010*	0,034 *0.0013*	0,04 *0.0016*	0,055 *0.0022*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	110 (95— 120) *360 (311 — 390)*
S12	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	30 (20 — 40) *100 (65 — 130)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – C5121 Scanalatura

SMG		a_p/DC	f_z												v_c
			1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	1 *1.0*	0,0024 *0.000095*	0,0034 *0.00013*	0,0046 *0.00018*	0,007 *0.00028*	0,008 *0.00032*	0,009 *0.00036*	0,012 *0.00048*	0,014 *0.00055*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	75 (50 — 85) *245 (170 — 270)*
P2	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (20 —40) *100 (66 — 130)*
P3	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	45 (30 — 60) *147 (98— 196)*
P4	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	55 (40 — 65) *180 (130 —210)*
P5	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 45) *115 (65— 145)*
P6	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	45 (30 — 60) *145 (180 — 195)*
P7	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 50) *115 (65 — 165)*
P8	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	25 (15 — 35) *80 (50 — 110)*
P11	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (20 — 42) *105 (65 — 138)*
P12	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	30 (20 — 40) *100 (65 — 130)*
M1	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	42 (21 — 52) *138 (69 — 170)*
M2	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (20 — 42) *105 (65 — 138)*
M3	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	30 (15 — 40) *100 (50 — 130)*
M4	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	22 (10 — 35) *72 (33 — 115)*
M5	E	1 *1.0*	0,0013 *0.000050*	0,002 *0.000080*	0,0026 *0.00010*	0,004 *0.00016*	0,0046 *0.00018*	0,005 *0.00020*	0,0065 *0.00026*	0,008 *0.00032*	0,01 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	0,016 *0.00065*	19 (16 — 30) *62 (52 — 100)*
K1	E	1 *1.0*	0,0024 *0.000095*	0,0034 *0.00013*	0,0046 *0.00018*	0,007 *0.00028*	0,008 *0.00032*	0,009 *0.00036*	0,012 *0.00048*	0,014 *0.00055*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	30 (20 — 45) *100 (65 — 147)*
K2	E	1 *1.0*	0,0024 *0.000095*	0,0034 *0.00013*	0,0046 *0.00018*	0,007 *0.00028*	0,008 *0.00032*	0,009 *0.00036*	0,012 *0.00048*	0,014 *0.00055*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	40 (30 — 50) *130 (100 — 165)*
K3	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (26 — 45) *105 (85 — 148)*
K4	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	22 (18 — 30) *72 (60 — 100)*
K5	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	20 (15 — 30) *65 (50 — 100)*
K6	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 50) *115 (65 — 165)*
K7	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 50) *115 (65 — 165)*
S1	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	25 (18 — 30) *80 (60 — 100)*
S2	E	1 *1.0*	0,001 *0.000040*	0,0015 *0.000060*	0,002 *0.000080*	0,003 *0.00012*	0,0036 *0.00014*	0,004 *0.00016*	0,005 *0.00020*	0,006 *0.00024*	0,008 *0.00032*	0,009 *0.00036*	0,01 *0.00040*	0,012 *0.00048*	13 (9 — 18) *62 (30 — 60)*
S3	E	1 *1.0*	0,001 *0.000040*	0,0015 *0.000060*	0,002 *0.000080*	0,003 *0.00012*	0,0036 *0.00014*	0,004 *0.00016*	0,005 *0.00020*	0,006 *0.00024*	0,008 *0.00032*	0,009 *0.00036*	0,01 *0.00040*	0,012 *0.00048*	7,0 (5 — 12) *23 (15— 39)*
S11	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (25 — 40) *114 (82— 130)*
S12	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (22 — 40) *105 (72 — 130)*
S13	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	10 (8— 15) *33 (26 — 50)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – C5121 Scanalatura – Pollici

SMG		a_p/DC	f_z													v_c
			1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	75 (50 — 85)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*245 (170 — 270)*
P2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 —40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (66 — 130)*
P3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*147 (98— 196)*
P4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	55 (40 — 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*180 (130 —210)*
P5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65— 145)*
P6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*145 (180 — 195)*
P7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
P8	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (15 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (50 — 110)*
P11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
P12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (20 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (65 — 130)*
M1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	42 (21 — 52)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*138 (69 — 170)*
M2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
M3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (15 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (50 — 130)*
M4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (10 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (33 — 115)*
M5	E	1	0,001	0,002	0,0042	0,005	0,006	0,007	0,0085	0,01	0,012	0,017	0,02	0,025	0,034	19 (16 — 30)
		1.0	*0.000040*	*0.000080*	*0.00017*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*62 (52 — 100)*
K1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	30 (20 — 45)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*100 (65 — 147)*
K2	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	40 (30 — 50)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*130 (100 — 165)*
K3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (26 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (85 — 148)*
K4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (60 — 100)*
K5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	20 (15 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*65 (50 — 100)*
K6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
K7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
S1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (60 — 100)*
S2	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	13 (9 — 18)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*62 (30 — 60)*
S3	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	7,0 (5 — 12)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*23 (15— 39)*
S11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (25 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*114 (82— 130)*
S12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (22 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (72 — 130)*
S13	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	10 (8— 15)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*33 (26 — 50)*

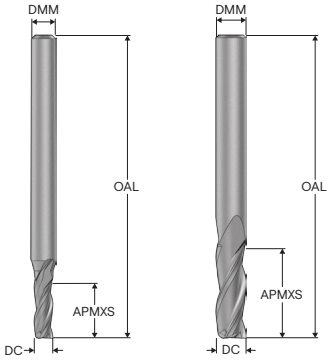
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

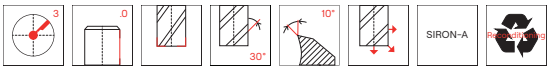
C5131

Uso generico – Universale – Spallamento – 3 Eliche – Cilindrico – Spigolo vivo





—Tolleranze:
—DMM=h5
—DC= h10
—Riaffilatura possibile se DC è ≥Ø10



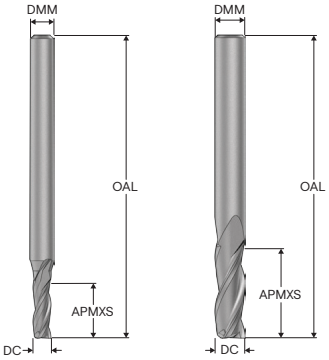
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm			
C5131-060D1S.0Z3	SIRA	10268801	1	D	6,0	6,0	9,0	57,0	3	Cylindrical	■
C5131-020F2S.0Z3	SIRA	10268792	2	F	2,0	3,0	4,0	38,0	3	Cylindrical	■
C5131-030D2S.0Z3	SIRA	10268794	2	D	3,0	3,0	6,0	38,0	3	Cylindrical	■
C5131-040D2S.0Z3	SIRA	10268797	2	D	4,0	4,0	8,0	50,0	3	Cylindrical	■
C5131-050F2S.0Z3	SIRA	10268799	2	F	5,0	6,0	10,0	57,0	3	Cylindrical	■
C5131-060D2S.0Z3	SIRA	10268802	2	D	6,0	6,0	12,0	57,0	3	Cylindrical	■
C5131-080D2S.0Z3	SIRA	10268804	2	D	8,0	8,0	16,0	63,0	3	Cylindrical	■
C5131-090F2S.0Z3	SIRA	10268806	2	F	9,0	10,0	22,0	72,0	3	Cylindrical	■
C5131-100D2S.0Z3	SIRA	10268807	2	D	10,0	10,0	22,0	72,0	3	Cylindrical	■
C5131-120D2S.0Z3	SIRA	10268809	2	D	12,0	12,0	25,0	83,0	3	Cylindrical	■
C5131-015F3S.0Z3	SIRA	10268791	3	F	1,5	3,0	4,5	38,0	3	Cylindrical	■
C5131-020F3S.0Z3	SIRA	10268793	3	F	2,0	3,0	6,3	38,0	3	Cylindrical	■
C5131-035F3S.0Z3	SIRA	10268796	3	F	3,5	4,0	12,0	50,0	3	Cylindrical	■
C5131-050F3S.0Z3	SIRA	10268800	3	F	5,0	6,0	16,0	57,0	3	Cylindrical	■
C5131-060D3S.0Z3	SIRA	10268803	3	D	6,0	6,0	19,0	63,0	3	Cylindrical	■
C5131-080D3S.0Z3	SIRA	10268805	3	D	8,0	8,0	20,0	63,0	3	Cylindrical	■
C5131-010F4S.0Z3	SIRA	10268790	4	F	1,0	3,0	4,0	38,0	3	Cylindrical	■
C5131-030D4S.0Z3	SIRA	10268795	4	D	3,0	3,0	12,0	38,0	3	Cylindrical	■
C5131-040D4S.0Z3	SIRA	10268798	4	D	4,0	4,0	14,0	50,0	3	Cylindrical	■
C5131-100D4S.0Z3	SIRA	10268808	4	D	10,0	10,0	35,0	89,0	3	Cylindrical	■
C5131-120D4S.0Z3	SIRA	10268810	4	D	12,0	12,0	50,0	100,0	3	Cylindrical	■

■ **Prodotto standard.**

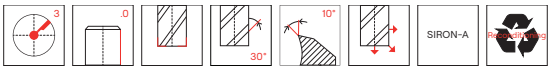
C5131

Uso generico – Universale – Spallamento – 3 Eliche – Cilindrico – Spigolo vivo – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Riaffilatura possibile se DC è ≥Ø.375



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5131-.047F2S.0Z3	SIRA	10268772	2	F	0.047	0.125	0.109	1.500	3	Cylindrical	■
C5131-.078F2S.0Z3	SIRA	10268774	2	F	0.078	0.125	0.188	1.500	3	Cylindrical	■
C5131-.438D2S.0Z3	SIRA	10268784	2	D	0.438	0.438	1.000	2.750	3	Cylindrical	■
C5131-.500D2S.0Z3	SIRA	10268785	2	D	0.500	0.500	1.000	3.000	3	Cylindrical	■
C5131-.563D2S.0Z3	SIRA	10268786	2	D	0.563	0.563	1.125	3.500	3	Cylindrical	■
C5131-.625D2S.0Z3	SIRA	10268787	2	D	0.625	0.625	1.250	3.500	3	Cylindrical	■
C5131-.750D2S.0Z3	SIRA	10268788	2	D	0.750	0.750	1.500	4.000	3	Cylindrical	■
C5131-1.000D2S.0Z3	SIRA	10268789	2	D	1.000	1.000	1.500	4.000	3	Cylindrical	■
C5131-.031F3S.0Z3	SIRA	10268771	3	F	0.031	0.125	0.078	1.500	3	Cylindrical	■
C5131-.063F3S.0Z3	SIRA	10268773	3	F	0.063	0.125	0.188	1.500	3	Cylindrical	■
C5131-.094F3S.0Z3	SIRA	10268775	3	F	0.094	0.125	0.281	1.500	3	Cylindrical	■
C5131-.109F3S.0Z3	SIRA	10268776	3	F	0.109	0.125	0.375	1.500	3	Cylindrical	■
C5131-.156F3S.0Z3	SIRA	10268778	3	F	0.156	0.188	0.500	2.000	3	Cylindrical	■
C5131-.188D3S.0Z3	SIRA	10268779	3	D	0.188	0.188	0.625	2.000	3	Cylindrical	■
C5131-.250D3S.0Z3	SIRA	10268781	3	D	0.250	0.250	0.750	2.500	3	Cylindrical	■
C5131-.313D3S.0Z3	SIRA	10268782	3	D	0.313	0.313	0.813	2.500	3	Cylindrical	■
C5131-.375D3S.0Z3	SIRA	10268783	3	D	0.375	0.375	1.000	2.500	3	Cylindrical	■
C5131-.125D4S.0Z3	SIRA	10268777	4	D	0.125	0.125	0.500	1.500	3	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – C5131 Contornatura

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	0,1	1,9	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	150 (135 — 165)
		0.10	*1.9*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*490 (440— 540)*
P2	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	58 (45— 70)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*190 (147 — 230)*
P3	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	85 (70 — 95)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*279 (246 — 312)*
P4	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	100 (90 — 110)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*330 (295 — 360)*
P5	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	68 (50 — 75)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*223 (165 — 245)*
P6	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	87 (77 — 100)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*285 (250 — 330)*
P7	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	65 (55 — 75)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*213 (180 — 245)*
P8	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	65 (50 — 75)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*213 (165 — 245)*
P11	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	85 (70 — 95)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*280 (230 — 310)*
P12	E	0,1	1,9	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	55 (45— 65)
		0.10	*1.9*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*180 (147 — 213)*
M1	E	0,1	1,9	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	93 (83 — 100)
		0.10	*1.9*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*305 (270 — 360)*
M2	E	0,1	1,9	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	60 (50 — 70)
		0.10	*1.9*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*200 (165 — 230)*
M3	E	0,1	1,9	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	55 (45 —65)
		0.10	*1.9*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*180 (147 — 213)*
M4	E	0,1	1,9	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	45 (35 — 55)
		0.10	*1.9*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*147 (115 — 180)*
M5	E	0,1	1,9	0,0044	0,0065	0,0085	0,013	0,015	0,017	0,022	0,026	0,034	0,038	0,042	0,05	35 (20 — 45)
		0.10	*1.9*	*0.00017*	*0.00026*	*0.00034*	*0.00050*	*0.00060*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*114 (65 — 147)*
K1	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	80 (70 — 90)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*260 (230 — 290)*
K2	E	0,1	1,9	0,0055	0,0085	0,011	0,017	0,02	0,022	0,028	0,034	0,044	0,05	0,055	0,065	87 (75 — 100)
		0.10	*1.9*	*0.00022*	*0.00034*	*0.00044*	*0.00065*	*0.00080*	*0.00085*	*0.0011*	*0.0013*	*0.0017*	*0.0020*	*0.0022*	*0.0026*	*285 (245 — 330)*
K3	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	65 (55 — 75)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*213 (180 — 245)*
K4	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	50 (35 — 65)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*165 (115 — 213)*
K5	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	45 (30 — 55)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*147 (100 — 180)*
K6	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	77 (65 — 85)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*250 (210 — 280)*
K7	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	77 (60 — 90)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*250 (200 — 290)*
S1	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	50 (35 — 60)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*165 (115 — 200)*
S2	E	0,1	1,9	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	25 (15 — 35)
		0.10	*1.9*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*82 (50 — 115)*
S3	E	0,1	1,9	0,002	0,0032	0,0042	0,0065	0,0075	0,0085	0,01	0,013	0,017	0,019	0,02	0,025	11 (7,5 — 16)
		0.10	*1.9*	*0.000080*	*0.00013*	*0.00017*	*0.00026*	*0.00030*	*0.00034*	*0.00040*	*0.00050*	*0.00065*	*0.00075*	*0.00080*	*0.0010*	*35 (25 — 52)*
S11	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	110 (95— 120)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*360 (311 — 390)*
S12	E	0,1	1,9	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	77 (60 — 90)
		0.10	*1.9*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*250 (190 — 290)*
S13	E	0,1	1,9	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	30 (20 — 40)
		0.10	*1.9*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*100 (65 — 130)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – C5131 Contornatura – Pollici

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	150 (135 — 165)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*490 (440— 540)*
P2	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	58 (45— 70)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*190 (147 — 230)*
P3	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	85 (70 — 95)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*279 (246 — 312)*
P4	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	100 (90 — 110)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*330 (295 — 360)*
P5	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	68 (50 — 75)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*223 (165 — 245)*
P6	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	87 (77 — 100)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*285 (250 — 330)*
P7	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	65 (55 — 75)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*213 (180 — 245)*
P8	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	65 (50 — 75)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*213 (165 — 245)*
P11	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	85 (70 — 95)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*280 (230 — 310)*
P12	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	55 (45— 65)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*180 (147 — 213)*
M1	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	93 (83 — 100)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*305 (270 — 360)*
M2	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	60 (50 — 70)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*200 (165 — 230)*
M3	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	55 (45 —65)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*180 (147 — 213)*
M4	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,09	0,1	45 (35 — 55)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0036*	*0.0040*	*147 (115 — 180)*
M5	E	0,1	2	0,0034	0,007	0,014	0,017	0,02	0,024	0,028	0,034	0,04	0,055	0,07	0,08	0,11	35 (20 — 45)
		0.10	*2.0*	*0.00013*	*0.00028*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0011*	*0.0013*	*0.0016*	*0.0022*	*0.0028*	*0.0032*	*0.0044*	*114 (65 — 147)*
K1	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	80 (70 — 90)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*260 (230 — 290)*
K2	E	0,1	2	0,0044	0,009	0,018	0,022	0,026	0,032	0,036	0,044	0,055	0,07	0,09	0,11	0,14	87 (75 — 100)
		0.10	*2.0*	*0.00017*	*0.00036*	*0.00070*	*0.00085*	*0.0010*	*0.0013*	*0.0014*	*0.0017*	*0.0022*	*0.0028*	*0.0036*	*0.0044*	*0.0055*	*285 (245 — 330)*
K3	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	65 (55 — 75)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*213 (180 — 245)*
K4	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	50 (35 — 65)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*165 (115 — 213)*
K5	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	45 (30 — 55)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*147 (100 — 180)*
K6	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	77 (65 — 85)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*250 (210 — 280)*
K7	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	77 (60 — 90)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*250 (200 — 290)*
S1	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	50 (35 — 60)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*165 (115 — 200)*
S2	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	25 (15 — 35)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*82 (50 — 115)*
S3	E	0,1	2	0,0017	0,0034	0,0065	0,0085	0,01	0,012	0,013	0,017	0,02	0,026	0,034	0,04	0,055	11 (7,5 — 16)
		0.10	*2.0*	*0.000065*	*0.00013*	*0.00026*	*0.00034*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0016*	*0.0022*	*35 (25 — 52)*
S11	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	110 (95— 120)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*360 (311 — 390)*
S12	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	77 (60 — 90)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*250 (190 — 290)*
S13	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	30 (20 — 40)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*100 (65 — 130)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – C5131 Scanalatura

SMG		a_p/DC	f_z												v_c
			1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	1 *1.0*	0,0024 *0.000095*	0,0034 *0.00013*	0,0046 *0.00018*	0,007 *0.00028*	0,008 *0.00032*	0,009 *0.00036*	0,012 *0.00048*	0,014 *0.00055*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	75 (50 — 85) *245 (170 — 270)*
P2	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (20 —40) *100 (66 — 130)*
P3	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	45 (30 — 60) *147 (98— 196)*
P4	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	55 (40 — 65) *180 (130 —210)*
P5	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 45) *115 (65— 145)*
P6	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	45 (30 — 60) *145 (180 — 195)*
P7	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 50) *115 (65 — 165)*
P8	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	25 (15 — 35) *80 (50 — 110)*
P11	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (20 — 42) *105 (65 — 138)*
P12	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	30 (20 — 40) *100 (65 — 130)*
M1	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	42 (21 — 52) *138 (69 — 170)*
M2	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (20 — 42) *105 (65 — 138)*
M3	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	30 (15 — 40) *100 (50 — 130)*
M4	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	22 (10 — 35) *72 (33 — 115)*
M5	E	1 *1.0*	0,0013 *0.000050*	0,002 *0.000080*	0,0026 *0.00010*	0,004 *0.00016*	0,0046 *0.00018*	0,005 *0.00020*	0,0065 *0.00026*	0,008 *0.00032*	0,01 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	0,016 *0.00065*	19 (16 — 30) *62 (52 — 100)*
K1	E	1 *1.0*	0,0024 *0.000095*	0,0034 *0.00013*	0,0046 *0.00018*	0,007 *0.00028*	0,008 *0.00032*	0,009 *0.00036*	0,012 *0.00048*	0,014 *0.00055*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	30 (20 — 45) *100 (65 — 147)*
K2	E	1 *1.0*	0,0024 *0.000095*	0,0034 *0.00013*	0,0046 *0.00018*	0,007 *0.00028*	0,008 *0.00032*	0,009 *0.00036*	0,012 *0.00048*	0,014 *0.00055*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	40 (30 — 50) *130 (100 — 165)*
K3	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (26 — 45) *105 (85 — 148)*
K4	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	22 (18 — 30) *72 (60 — 100)*
K5	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	20 (15 — 30) *65 (50 — 100)*
K6	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 50) *115 (65 — 165)*
K7	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 50) *115 (65 — 165)*
S1	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	25 (18 — 30) *80 (60 — 100)*
S2	E	1 *1.0*	0,001 *0.000040*	0,0015 *0.000060*	0,002 *0.000080*	0,003 *0.00012*	0,0036 *0.00014*	0,004 *0.00016*	0,005 *0.00020*	0,006 *0.00024*	0,008 *0.00032*	0,009 *0.00036*	0,01 *0.00040*	0,012 *0.00048*	13 (9 — 18) *62 (30 — 60)*
S3	E	1 *1.0*	0,001 *0.000040*	0,0015 *0.000060*	0,002 *0.000080*	0,003 *0.00012*	0,0036 *0.00014*	0,004 *0.00016*	0,005 *0.00020*	0,006 *0.00024*	0,008 *0.00032*	0,009 *0.00036*	0,01 *0.00040*	0,012 *0.00048*	7,0 (5 — 12) *23 (15— 39)*
S11	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (25 — 40) *114 (82— 130)*
S12	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (22 — 40) *105 (72 — 130)*
S13	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	10 (8— 15) *33 (26 — 50)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – C5131 Scanalatura – Pollici

SMG		a_p/DC	f_z													v_c
			1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	75 (50 — 85)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*245 (170 — 270)*
P2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 —40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (66 — 130)*
P3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*147 (98— 196)*
P4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	55 (40 — 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*180 (130 —210)*
P5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65— 145)*
P6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*145 (180 — 195)*
P7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
P8	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (15 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (50 — 110)*
P11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
P12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (20 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (65 — 130)*
M1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	42 (21 — 52)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*138 (69 — 170)*
M2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
M3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (15 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (50 — 130)*
M4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (10 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (33 — 115)*
M5	E	1	0,001	0,002	0,0042	0,005	0,006	0,007	0,0085	0,01	0,012	0,017	0,02	0,025	0,034	19 (16 — 30)
		1.0	*0.000040*	*0.000080*	*0.00017*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*62 (52 — 100)*
K1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	30 (20 — 45)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*100 (65 — 147)*
K2	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	40 (30 — 50)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*130 (100 — 165)*
K3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (26 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (85 — 148)*
K4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (60 — 100)*
K5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	20 (15 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*65 (50 — 100)*
K6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
K7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
S1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (60 — 100)*
S2	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	13 (9 — 18)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*62 (30 — 60)*
S3	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	7,0 (5 — 12)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*23 (15— 39)*
S11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (25 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*114 (82— 130)*
S12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (22 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (72 — 130)*
S13	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	10 (8— 15)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*33 (26 — 50)*

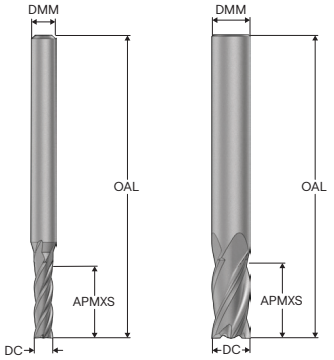
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

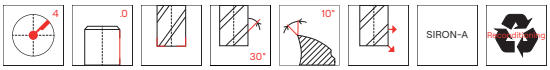
C5141

Uso generico – Universale – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo





—Tolleranze:
—DMM=h5
—DC= h10
—Riaffilatura possibile se DC è ≥Ø10



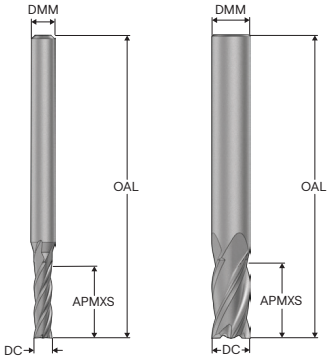
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm			
C5141-060D1S.0Z4	SIRA	10268459	1	D	6,0	6,0	9,0	57,0	4	Cylindrical	■
C5141-020F2S.0Z4	SIRA	10268450	2	F	2,0	3,0	4,0	39,0	4	Cylindrical	■
C5141-030D2S.0Z4	SIRA	10268452	2	D	3,0	3,0	6,0	38,0	4	Cylindrical	■
C5141-040D2S.0Z4	SIRA	10268455	2	D	4,0	4,0	8,0	50,0	4	Cylindrical	■
C5141-050F2S.0Z4	SIRA	10268457	2	F	5,0	6,0	10,0	57,0	4	Cylindrical	■
C5141-060D2S.0Z4	SIRA	10268460	2	D	6,0	6,0	12,0	57,0	4	Cylindrical	■
C5141-080D2S.0Z4	SIRA	10268462	2	D	8,0	8,0	16,0	63,0	4	Cylindrical	■
C5141-080D3S.0Z4	SIRA	10268463	2	D	8,0	8,0	20,0	64,0	4	Cylindrical	■
C5141-090F2S.0Z4	SIRA	10268464	2	F	9,0	10,0	22,0	73,0	4	Cylindrical	■
C5141-100D2S.0Z4	SIRA	10268465	2	D	10,0	10,0	22,0	73,0	4	Cylindrical	■
C5141-120D2S.0Z4	SIRA	10268467	2	D	12,0	12,0	25,0	74,0	4	Cylindrical	■
C5141-160D2S.0Z4	SIRA	10268469	2	D	16,0	16,0	32,0	92,0	4	Cylindrical	■
C5141-200D2S.0Z4	SIRA	10268471	2	D	20,0	20,0	35,0	104,0	4	Cylindrical	■
C5141-015F3S.0Z4	SIRA	10268449	3	F	1,5	3,0	4,5	39,0	4	Cylindrical	■
C5141-020F3S.0Z4	SIRA	10268451	3	F	2,0	3,0	6,3	39,0	4	Cylindrical	■
C5141-035F3S.0Z4	SIRA	10268454	3	F	3,5	4,0	12,0	51,0	4	Cylindrical	■
C5141-050F3S.0Z4	SIRA	10268458	3	F	5,0	6,0	16,0	51,0	4	Cylindrical	■
C5141-060D3S.0Z4	SIRA	10268461	3	D	6,0	6,0	19,0	51,0	4	Cylindrical	■
C5141-160D3S.0Z4	SIRA	10268470	3	D	16,0	16,0	50,0	115,0	4	Cylindrical	■
C5141-200D3S.0Z4	SIRA	10268472	3	D	20,0	20,0	60,0	125,0	4	Cylindrical	■
C5141-010F4S.0Z4	SIRA	10268448	4	F	1,0	3,0	4,0	39,0	4	Cylindrical	■
C5141-030D4S.0Z4	SIRA	10268453	4	D	3,0	3,0	12,0	39,0	4	Cylindrical	■
C5141-040D4S.0Z4	SIRA	10268456	4	D	4,0	4,0	14,0	51,0	4	Cylindrical	■
C5141-100D4S.0Z4	SIRA	10268466	4	D	10,0	10,0	35,0	89,0	4	Cylindrical	■
C5141-120D4S.0Z4	SIRA	10268468	4	D	12,0	12,0	50,0	100,0	4	Cylindrical	■

■ **Prodotto standard.**

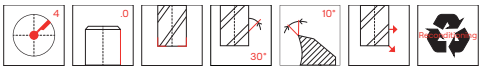
C5141

Uso generico – Universale – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo – Pollici





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—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
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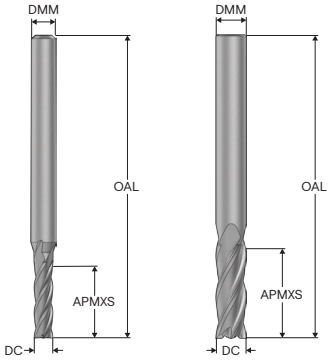
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
				inch	inch	inch	inch			
C5141-.375D1S.0Z4	10268208	1	D	0.375	0.375	0.625	2.000	4	Cylindrical	■
C5141-.438D1S.0Z4	10268220	1	D	0.438	0.438	0.625	2.500	4	Cylindrical	■
C5141-.500D1S.0Z4	10268228	1	D	0.500	0.500	0.625	2.500	4	Cylindrical	■
C5141-.625D1S.0Z4	10268236	1	D	0.625	0.625	0.750	3.000	4	Cylindrical	■
C5141-.750D1S.0Z4	10268242	1	D	0.750	0.750	1.000	3.000	4	Cylindrical	■
C5141-1.000D1S.0Z4	10268249	1	D	1.000	1.000	1.000	3.000	4	Cylindrical	■
C5141-.016F2S.0Z4	10268152	2	F	0.016	0.125	0.031	1.500	4	Cylindrical	■
C5141-.047F2S.0Z4	10268155	2	F	0.047	0.125	0.109	1.500	4	Cylindrical	■
C5141-.063F2S.0Z4	10268157	2	F	0.063	0.125	0.125	1.500	4	Cylindrical	■
C5141-.078F2S.0Z4	10268161	2	F	0.078	0.125	0.188	1.500	4	Cylindrical	■
C5141-.094F2S.0Z4	10268163	2	F	0.094	0.125	0.188	1.500	4	Cylindrical	■
C5141-.125D2S.0Z4	10268168	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
C5141-.156F2S.0Z4	10268175	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
C5141-.188D2S.0Z4	10268178	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
C5141-.219F2S.0Z4	10268185	2	F	0.219	0.250	0.438	2.000	4	Cylindrical	■
C5141-.250D2S.0Z4	10268188	2	D	0.250	0.250	0.500	2.000	4	Cylindrical	■
C5141-.313D2S.0Z4	10268198	2	D	0.313	0.313	0.500	2.000	4	Cylindrical	■
C5141-.375D2S.0Z4	10268209	2	D	0.375	0.375	1.000	2.500	4	Cylindrical	■
C5141-.406F2S.0Z4	10268218	2	F	0.406	0.438	1.000	2.750	4	Cylindrical	■
C5141-.438D2S.0Z4	10268221	2	D	0.438	0.438	1.000	2.750	4	Cylindrical	■
C5141-.500D2S.0Z4	10268229	2	D	0.500	0.500	1.000	3.000	4	Cylindrical	■
C5141-.563D2S.0Z4	10268235	2	D	0.563	0.563	1.125	3.500	4	Cylindrical	■
C5141-.625D2S.0Z4	10268237	2	D	0.625	0.625	1.250	3.500	4	Cylindrical	■
C5141-.688F2S.0Z4	10268241	2	F	0.688	0.750	1.375	4.000	4	Cylindrical	■
C5141-.750D2S.0Z4	10268243	2	D	0.750	0.750	1.500	4.000	4	Cylindrical	■
C5141-.875D2S.0Z4	10268248	2	D	0.875	0.875	1.500	4.000	4	Cylindrical	■
C5141-1.000D2S.0Z4	10268250	2	D	1.000	1.000	1.500	4.000	4	Cylindrical	■
C5141-1.250D2S.0Z4	10268255	2	D	1.250	1.250	2.000	4.500	4	Cylindrical	■
C5141-.031F3S.0Z4	10268153	3	F	0.031	0.125	0.078	1.500	4	Cylindrical	■
C5141-.047F3S.0Z4	10268156	3	F	0.047	0.125	0.125	1.500	4	Cylindrical	■
C5141-.063F3S.0Z4	10268158	3	F	0.063	0.125	0.188	1.500	4	Cylindrical	■
C5141-.078F3S.0Z4	10268162	3	F	0.078	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F3S.0Z4	10268164	3	F	0.094	0.125	0.281	1.500	4	Cylindrical	■
C5141-.109F3S.0Z4	10268167	3	F	0.109	0.125	0.375	1.500	4	Cylindrical	■

■ **Prodotto standard.**

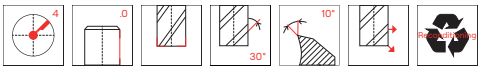
C5141

Uso generico – Universale – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo – Pollici





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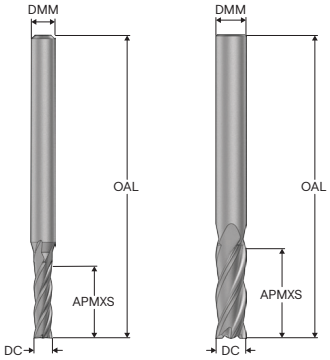
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
				inch	inch	inch	inch			
C5141-.156F3S.0Z4	10268176	3	F	0.156	0.188	0.500	2.000	4	Cylindrical	■
C5141-.188D3S.0Z4	10268179	3	D	0.188	0.188	0.625	2.000	4	Cylindrical	■
C5141-.203F3S.0Z4	10268184	3	F	0.203	0.250	0.625	2.500	4	Cylindrical	■
C5141-.219F3S.0Z4	10268186	3	F	0.219	0.250	0.625	2.500	4	Cylindrical	■
C5141-.234F3S.0Z4	10268187	3	F	0.234	0.250	0.750	2.500	4	Cylindrical	■
C5141-.250D3S.0Z4	10268189	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
C5141-.281F3S.0Z4	10268196	3	F	0.281	0.313	0.750	2.500	4	Cylindrical	■
C5141-.313D3S.0Z4	10268199	3	D	0.313	0.313	0.813	2.500	4	Cylindrical	■
C5141-.344F3S.0Z4	10268206	3	F	0.344	0.375	1.000	2.500	4	Cylindrical	■
C5141-.375D3S.0Z4	10268210	3	D	0.375	0.375	1.000	3.000	4	Cylindrical	■
C5141-.438D3S.0Z4	10268222	3	D	0.438	0.438	1.000	4.000	4	Cylindrical	■
C5141-.500D3S.0Z4	10268230	3	D	0.500	0.500	1.000	4.000	4	Cylindrical	■
C5141-.625D3S.0Z4	10268238	3	D	0.625	0.625	2.000	6.000	4	Cylindrical	■
C5141-.750D3S.0Z4	10268244	3	D	0.750	0.750	2.000	6.000	4	Cylindrical	■
C5141-1.000D3S.0Z4	10268251	3	D	1.000	1.000	2.000	6.000	4	Cylindrical	■
C5141-.031F4S.0Z4	10268154	4	F	0.031	0.125	0.094	1.500	4	Cylindrical	■
C5141-.063F4S.0Z4	10268159	4	F	0.063	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F4S.0Z4	10268165	4	F	0.094	0.125	0.375	1.500	4	Cylindrical	■
C5141-.125D4S.0Z4	10268169	4	D	0.125	0.125	0.500	1.500	4	Cylindrical	■
C5141-.141F4S.0Z4	10268174	4	F	0.141	0.188	0.500	2.000	4	Cylindrical	■
C5141-.172F4S.0Z4	10268177	4	F	0.172	0.188	0.625	2.000	4	Cylindrical	■
C5141-.188D4S.0Z4	10268180	4	D	0.188	0.188	0.750	2.500	4	Cylindrical	■
C5141-.250D4S.0Z4	10268190	4	D	0.250	0.250	1.000	3.000	4	Cylindrical	■
C5141-.313D4S.0Z4	10268200	4	D	0.313	0.313	1.000	3.000	4	Cylindrical	■
C5141-.375D4S.0Z4	10268211	4	D	0.375	0.375	1.000	4.000	4	Cylindrical	■
C5141-.438D4S.0Z4	10268223	4	D	0.438	0.438	1.500	6.000	4	Cylindrical	■
C5141-.500D4S.0Z4	10268231	4	D	0.500	0.500	1.500	6.000	4	Cylindrical	■
C5141-.625D4S.0Z4	10268239	4	D	0.625	0.625	2.250	5.000	4	Cylindrical	■
C5141-.750D4S.0Z4	10268245	4	D	0.750	0.750	2.250	5.000	4	Cylindrical	■
C5141-1.000D4S.0Z4	10268252	4	D	1.000	1.000	2.250	5.000	4	Cylindrical	■

■ **Prodotto standard.**

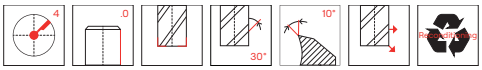
C5141

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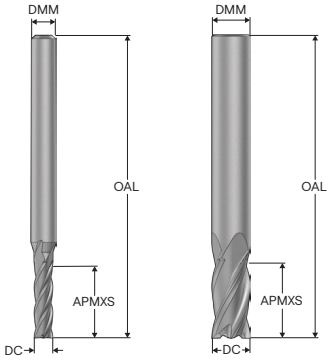
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
				inch	inch	inch	inch			
C5141-.125D5S.0Z4	10268170	5	D	0.125	0.125	0.625	2.000	4	Cylindrical	■
C5141-.188D5S.0Z4	10268181	5	D	0.188	0.188	1.000	3.000	4	Cylindrical	■
C5141-.250D5S.0Z4	10268191	5	D	0.250	0.250	1.000	4.000	4	Cylindrical	■
C5141-.313D5S.0Z4	10268201	5	D	0.313	0.313	1.000	4.000	4	Cylindrical	■
C5141-.375D5S.0Z4	10268212	5	D	0.375	0.375	1.125	3.000	4	Cylindrical	■
C5141-.438D5S.0Z4	10268224	5	D	0.438	0.438	2.000	4.000	4	Cylindrical	■
C5141-.500D5S.0Z4	10268232	5	D	0.500	0.500	2.000	4.000	4	Cylindrical	■
C5141-.625D5S.0Z4	10268240	5	D	0.625	0.625	3.000	6.000	4	Cylindrical	■
C5141-.750D5S.0Z4	10268246	5	D	0.750	0.750	3.000	6.000	4	Cylindrical	■
C5141-1.000D5S.0Z4	10268253	5	D	1.000	1.000	3.000	6.000	4	Cylindrical	■
C5141-.125D6S.0Z4	10268171	6	D	0.125	0.125	0.750	3.000	4	Cylindrical	■
C5141-.188D6S.0Z4	10268182	6	D	0.188	0.188	1.000	4.000	4	Cylindrical	■
C5141-.250D6S.0Z4	10268192	6	D	0.250	0.250	1.125	3.000	4	Cylindrical	■
C5141-.313D6S.0Z4	10268202	6	D	0.313	0.313	1.125	3.000	4	Cylindrical	■
C5141-.375D6S.0Z4	10268213	6	D	0.375	0.375	1.500	6.000	4	Cylindrical	■
C5141-.438D6S.0Z4	10268225	6	D	0.438	0.438	2.000	4.500	4	Cylindrical	■
C5141-.500D6S.0Z4	10268233	6	D	0.500	0.500	2.000	4.500	4	Cylindrical	■
C5141-.750D6S.0Z4	10268247	6	D	0.750	0.750	4.000	6.000	4	Cylindrical	■
C5141-1.000D6S.0Z4	10268254	6	D	1.000	1.000	4.000	7.000	4	Cylindrical	■
C5141-.188D7S.0Z4	10268183	7	D	0.188	0.188	1.125	3.000	4	Cylindrical	■
C5141-.250D7S.0Z4	10268193	7	D	0.250	0.250	1.500	4.000	4	Cylindrical	■
C5141-.313D7S.0Z4	10268203	7	D	0.313	0.313	1.500	6.000	4	Cylindrical	■
C5141-.375D7S.0Z4	10268214	7	D	0.375	0.375	1.750	4.000	4	Cylindrical	■
C5141-.438D7S.0Z4	10268226	7	D	0.438	0.438	3.000	6.000	4	Cylindrical	■
C5141-.500D7S.0Z4	10268234	7	D	0.500	0.500	3.000	6.000	4	Cylindrical	■
C5141-.063F8S.0Z4	10268160	8	F	0.063	0.125	1.000	3.000	4	Cylindrical	■
C5141-.094F8S.0Z4	10268166	8	F	0.094	0.125	1.000	3.000	4	Cylindrical	■
C5141-.125D8S.0Z4	10268172	8	D	0.125	0.125	1.000	3.000	4	Cylindrical	■
C5141-.250D8S.0Z4	10268194	8	D	0.250	0.250	1.500	6.000	4	Cylindrical	■
C5141-.313D8S.0Z4	10268204	8	D	0.313	0.313	1.625	4.000	4	Cylindrical	■
C5141-.375D8S.0Z4	10268215	8	D	0.375	0.375	2.000	4.000	4	Cylindrical	■
C5141-.125D9S.0Z4	10268173	9	D	0.125	0.125	1.000	4.000	4	Cylindrical	■
C5141-.375D9S.0Z4	10268216	9	D	0.375	0.375	3.000	6.000	4	Cylindrical	■

■ **Prodotto standard.**

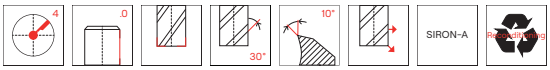
C5141

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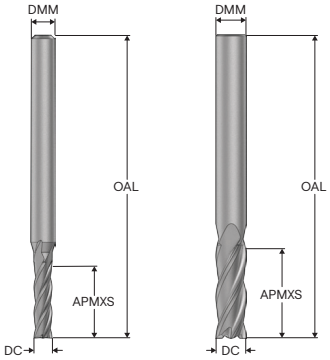
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5141-.375D1S.0Z4	SIRA	10268312	1	D	0.375	0.375	0.625	2.000	4	Cylindrical	■
C5141-.438D1S.0Z4	SIRA	10268324	1	D	0.438	0.438	0.625	2.500	4	Cylindrical	■
C5141-.500D1S.0Z4	SIRA	10268332	1	D	0.500	0.500	0.625	2.500	4	Cylindrical	■
C5141-.625D1S.0Z4	SIRA	10268340	1	D	0.625	0.625	0.750	3.000	4	Cylindrical	■
C5141-.750D1S.0Z4	SIRA	10268346	1	D	0.750	0.750	1.000	3.000	4	Cylindrical	■
C5141-1.000D1S.0Z4	SIRA	10268353	1	D	1.000	1.000	1.000	3.000	4	Cylindrical	■
C5141-.016F2S.0Z4	SIRA	10268256	2	F	0.016	0.125	0.031	1.500	4	Cylindrical	■
C5141-.047F2S.0Z4	SIRA	10268259	2	F	0.047	0.125	0.109	1.500	4	Cylindrical	■
C5141-.063F2S.0Z4	SIRA	10268261	2	F	0.063	0.125	0.125	1.500	4	Cylindrical	■
C5141-.078F2S.0Z4	SIRA	10268265	2	F	0.078	0.125	0.188	1.500	4	Cylindrical	■
C5141-.094F2S.0Z4	SIRA	10268267	2	F	0.094	0.125	0.188	1.500	4	Cylindrical	■
C5141-.125D2S.0Z4	SIRA	10268272	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
C5141-.156F2S.0Z4	SIRA	10268279	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
C5141-.188D2S.0Z4	SIRA	10268282	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
C5141-.219F2S.0Z4	SIRA	10268289	2	F	0.219	0.250	0.438	2.000	4	Cylindrical	■
C5141-.250D2S.0Z4	SIRA	10268292	2	D	0.250	0.250	0.500	2.000	4	Cylindrical	■
C5141-.313D2S.0Z4	SIRA	10268302	2	D	0.313	0.313	0.500	2.000	4	Cylindrical	■
C5141-.375D2S.0Z4	SIRA	10268313	2	D	0.375	0.375	1.000	2.500	4	Cylindrical	■
C5141-.406F2S.0Z4	SIRA	10268322	2	F	0.406	0.438	1.000	2.750	4	Cylindrical	■
C5141-.438D2S.0Z4	SIRA	10268325	2	D	0.438	0.438	1.000	2.750	4	Cylindrical	■
C5141-.469F2S.0Z4	SIRA	10268331	2	F	0.469	0.500	1.000	3.000	4	Cylindrical	■
C5141-.500D2S.0Z4	SIRA	10268333	2	D	0.500	0.500	1.000	3.000	4	Cylindrical	■
C5141-.563D2S.0Z4	SIRA	10268339	2	D	0.563	0.563	1.125	3.500	4	Cylindrical	■
C5141-.625D2S.0Z4	SIRA	10268341	2	D	0.625	0.625	1.250	3.500	4	Cylindrical	■
C5141-.688F2S.0Z4	SIRA	10268345	2	F	0.688	0.750	1.375	4.000	4	Cylindrical	■
C5141-.750D2S.0Z4	SIRA	10268347	2	D	0.750	0.750	1.500	4.000	4	Cylindrical	■
C5141-.875D2S.0Z4	SIRA	10268352	2	D	0.875	0.875	1.500	4.000	4	Cylindrical	■
C5141-1.000D2S.0Z4	SIRA	10268354	2	D	1.000	1.000	1.500	4.000	4	Cylindrical	■
C5141-1.250D2S.0Z4	SIRA	10268359	2	D	1.250	1.250	2.000	4.500	4	Cylindrical	■

■ **Prodotto standard.**

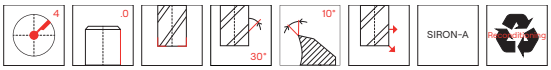
C5141

Uso generico – Universale – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo – Pollici





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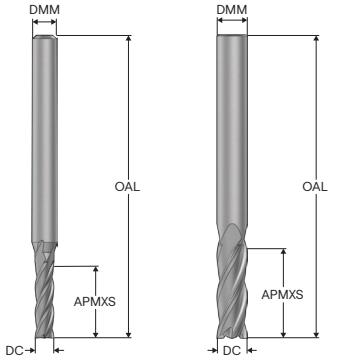
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5141-.031F3S.0Z4	SIRA	10268257	3	F	0.031	0.125	0.078	1.500	4	Cylindrical	■
C5141-.047F3S.0Z4	SIRA	10268260	3	F	0.047	0.125	0.125	1.500	4	Cylindrical	■
C5141-.063F3S.0Z4	SIRA	10268262	3	F	0.063	0.125	0.188	1.500	4	Cylindrical	■
C5141-.078F3S.0Z4	SIRA	10268266	3	F	0.078	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F3S.0Z4	SIRA	10268268	3	F	0.094	0.125	0.281	1.500	4	Cylindrical	■
C5141-.109F3S.0Z4	SIRA	10268271	3	F	0.109	0.125	0.375	1.500	4	Cylindrical	■
C5141-.156F3S.0Z4	SIRA	10268280	3	F	0.156	0.188	0.500	2.000	4	Cylindrical	■
C5141-.188D3S.0Z4	SIRA	10268283	3	D	0.188	0.188	0.625	2.000	4	Cylindrical	■
C5141-.203F3S.0Z4	SIRA	10268288	3	F	0.203	0.250	0.625	2.500	4	Cylindrical	■
C5141-.219F3S.0Z4	SIRA	10268290	3	F	0.219	0.250	0.625	2.500	4	Cylindrical	■
C5141-.234F3S.0Z4	SIRA	10268291	3	F	0.234	0.250	0.750	2.500	4	Cylindrical	■
C5141-.250D3S.0Z4	SIRA	10268293	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
C5141-.266F3S.0Z4	SIRA	10268299	3	F	0.266	0.313	0.750	2.500	4	Cylindrical	■
C5141-.281F3S.0Z4	SIRA	10268300	3	F	0.281	0.313	0.750	2.500	4	Cylindrical	■
C5141-.297F3S.0Z4	SIRA	10268301	3	F	0.297	0.313	0.813	2.500	4	Cylindrical	■
C5141-.313D3S.0Z4	SIRA	10268303	3	D	0.313	0.313	0.813	2.500	4	Cylindrical	■
C5141-.328F3S.0Z4	SIRA	10268309	3	F	0.328	0.375	1.000	2.500	4	Cylindrical	■
C5141-.344F3S.0Z4	SIRA	10268310	3	F	0.344	0.375	1.000	2.500	4	Cylindrical	■
C5141-.359F3S.0Z4	SIRA	10268311	3	F	0.359	0.375	1.000	2.500	4	Cylindrical	■
C5141-.375D3S.0Z4	SIRA	10268314	3	D	0.375	0.375	1.000	3.000	4	Cylindrical	■
C5141-.391F3S.0Z4	SIRA	10268321	3	F	0.391	0.438	1.000	2.750	4	Cylindrical	■
C5141-.438D3S.0Z4	SIRA	10268326	3	D	0.438	0.438	1.000	4.000	4	Cylindrical	■
C5141-.500D3S.0Z4	SIRA	10268334	3	D	0.500	0.500	1.000	4.000	4	Cylindrical	■
C5141-.625D3S.0Z4	SIRA	10268342	3	D	0.625	0.625	2.000	6.000	4	Cylindrical	■
C5141-.750D3S.0Z4	SIRA	10268348	3	D	0.750	0.750	2.000	6.000	4	Cylindrical	■
C5141-1.000D3S.0Z4	SIRA	10268355	3	D	1.000	1.000	2.000	6.000	4	Cylindrical	■

■ **Prodotto standard.**

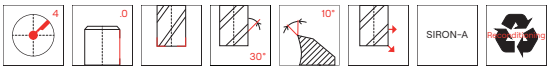
C5141

Uso generico – Universale – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo – Pollici





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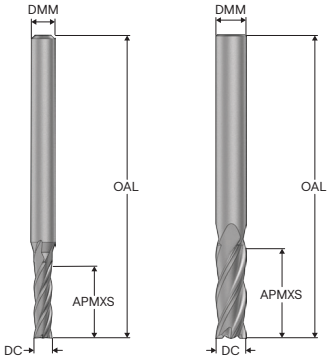
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5141-.031F4S.0Z4	SIRA	10268258	4	F	0.031	0.125	0.094	1.500	4	Cylindrical	■
C5141-.063F4S.0Z4	SIRA	10268263	4	F	0.063	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F4S.0Z4	SIRA	10268269	4	F	0.094	0.125	0.375	1.500	4	Cylindrical	■
C5141-.125D4S.0Z4	SIRA	10268273	4	D	0.125	0.125	0.500	1.500	4	Cylindrical	■
C5141-.141F4S.0Z4	SIRA	10268278	4	F	0.141	0.188	0.500	2.000	4	Cylindrical	■
C5141-.172F4S.0Z4	SIRA	10268281	4	F	0.172	0.188	0.625	2.000	4	Cylindrical	■
C5141-.188D4S.0Z4	SIRA	10268284	4	D	0.188	0.188	0.750	2.500	4	Cylindrical	■
C5141-.250D4S.0Z4	SIRA	10268294	4	D	0.250	0.250	1.000	3.000	4	Cylindrical	■
C5141-.313D4S.0Z4	SIRA	10268304	4	D	0.313	0.313	1.000	3.000	4	Cylindrical	■
C5141-.375D4S.0Z4	SIRA	10268315	4	D	0.375	0.375	1.000	4.000	4	Cylindrical	■
C5141-.438D4S.0Z4	SIRA	10268327	4	D	0.438	0.438	1.500	6.000	4	Cylindrical	■
C5141-.500D4S.0Z4	SIRA	10268335	4	D	0.500	0.500	1.500	6.000	4	Cylindrical	■
C5141-.625D4S.0Z4	SIRA	10268343	4	D	0.625	0.625	2.250	5.000	4	Cylindrical	■
C5141-.750D4S.0Z4	SIRA	10268349	4	D	0.750	0.750	2.250	5.000	4	Cylindrical	■
C5141-1.000D4S.0Z4	SIRA	10268356	4	D	1.000	1.000	2.250	5.000	4	Cylindrical	■
C5141-.125D5S.0Z4	SIRA	10268274	5	D	0.125	0.125	0.625	2.000	4	Cylindrical	■
C5141-.188D5S.0Z4	SIRA	10268285	5	D	0.188	0.188	1.000	3.000	4	Cylindrical	■
C5141-.250D5S.0Z4	SIRA	10268295	5	D	0.250	0.250	1.000	4.000	4	Cylindrical	■
C5141-.313D5S.0Z4	SIRA	10268305	5	D	0.313	0.313	1.000	4.000	4	Cylindrical	■
C5141-.375D5S.0Z4	SIRA	10268316	5	D	0.375	0.375	1.125	3.000	4	Cylindrical	■
C5141-.438D5S.0Z4	SIRA	10268328	5	D	0.438	0.438	2.000	4.000	4	Cylindrical	■
C5141-.500D5S.0Z4	SIRA	10268336	5	D	0.500	0.500	2.000	4.000	4	Cylindrical	■
C5141-.625D5S.0Z4	SIRA	10268344	5	D	0.625	0.625	3.000	6.000	4	Cylindrical	■
C5141-.750D5S.0Z4	SIRA	10268350	5	D	0.750	0.750	3.000	6.000	4	Cylindrical	■
C5141-1.000D5S.0Z4	SIRA	10268357	5	D	1.000	1.000	3.000	6.000	4	Cylindrical	■
C5141-1.000D6S.0Z4	SIRA	10268358	6	D	1.000	1.000	4.000	7.000	4	Cylindrical	■

■ **Prodotto standard.**

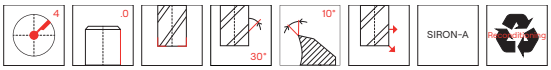
C5141

Uso generico – Universale – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo – Pollici





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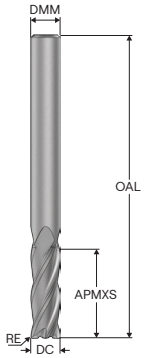
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5141-.125D6S.0Z4	SIRA	10268275	6	D	0.125	0.125	0.750	3.000	4	Cylindrical	■
C5141-.188D6S.0Z4	SIRA	10268286	6	D	0.188	0.188	1.000	4.000	4	Cylindrical	■
C5141-.250D6S.0Z4	SIRA	10268296	6	D	0.250	0.250	1.125	3.000	4	Cylindrical	■
C5141-.313D6S.0Z4	SIRA	10268306	6	D	0.313	0.313	1.125	3.000	4	Cylindrical	■
C5141-.375D6S.0Z4	SIRA	10268317	6	D	0.375	0.375	1.500	6.000	4	Cylindrical	■
C5141-.438D6S.0Z4	SIRA	10268329	6	D	0.438	0.438	2.000	4.500	4	Cylindrical	■
C5141-.500D6S.0Z4	SIRA	10268337	6	D	0.500	0.500	2.000	4.500	4	Cylindrical	■
C5141-.750D6S.0Z4	SIRA	10268351	6	D	0.750	0.750	4.000	6.000	4	Cylindrical	■
C5141-.188D7S.0Z4	SIRA	10268287	7	D	0.188	0.188	1.125	3.000	4	Cylindrical	■
C5141-.250D7S.0Z4	SIRA	10268297	7	D	0.250	0.250	1.500	4.000	4	Cylindrical	■
C5141-.313D7S.0Z4	SIRA	10268307	7	D	0.313	0.313	1.500	6.000	4	Cylindrical	■
C5141-.375D7S.0Z4	SIRA	10268318	7	D	0.375	0.375	1.750	4.000	4	Cylindrical	■
C5141-.438D7S.0Z4	SIRA	10268330	7	D	0.438	0.438	3.000	6.000	4	Cylindrical	■
C5141-.500D7S.0Z4	SIRA	10268338	7	D	0.500	0.500	3.000	6.000	4	Cylindrical	■
C5141-.063F8S.0Z4	SIRA	10268264	8	F	0.063	0.125	1.000	3.000	4	Cylindrical	■
C5141-.094F8S.0Z4	SIRA	10268270	8	F	0.094	0.125	1.000	3.000	4	Cylindrical	■
C5141-.125D8S.0Z4	SIRA	10268276	8	D	0.125	0.125	1.000	3.000	4	Cylindrical	■
C5141-.250D8S.0Z4	SIRA	10268298	8	D	0.250	0.250	1.500	6.000	4	Cylindrical	■
C5141-.313D8S.0Z4	SIRA	10268308	8	D	0.313	0.313	1.625	4.000	4	Cylindrical	■
C5141-.375D8S.0Z4	SIRA	10268319	8	D	0.375	0.375	2.000	4.000	4	Cylindrical	■
C5141-.125D9S.0Z4	SIRA	10268277	9	D	0.125	0.125	1.000	4.000	4	Cylindrical	■
C5141-.375D9S.0Z4	SIRA	10268320	9	D	0.375	0.375	3.000	6.000	4	Cylindrical	■

■ **Prodotto standard.**

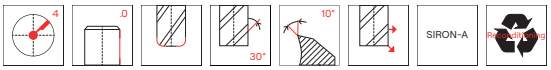
C5141

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





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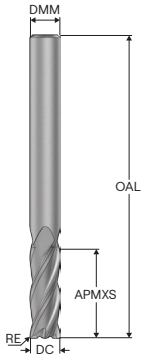
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
C5141-.438D2R015.0Z4	SIRA	10268379	2	D	0.438	0.438	1.000	2.750	0.015	4	Cylindrical	■
C5141-.438D2R030.0Z4	SIRA	10268380	2	D	0.438	0.438	1.000	2.750	0.030	4	Cylindrical	■
C5141-.438D2R060.0Z4	SIRA	10268381	2	D	0.438	0.438	1.000	2.750	0.060	4	Cylindrical	■
C5141-.438D2R125.0Z4	SIRA	10268382	2	D	0.438	0.438	1.000	2.750	0.125	4	Cylindrical	■
C5141-.500D2R015.0Z4	SIRA	10268383	2	D	0.500	0.500	1.000	3.000	0.015	4	Cylindrical	■
C5141-.500D2R020.0Z4	SIRA	10268384	2	D	0.500	0.500	1.000	3.000	0.020	4	Cylindrical	■
C5141-.500D2R030.0Z4	SIRA	10268385	2	D	0.500	0.500	1.000	3.000	0.030	4	Cylindrical	■
C5141-.500D2R045.0Z4	SIRA	10268386	2	D	0.500	0.500	1.000	3.000	0.045	4	Cylindrical	■
C5141-.500D2R060.0Z4	SIRA	10268387	2	D	0.500	0.500	1.000	3.000	0.060	4	Cylindrical	■
C5141-.500D2R090.0Z4	SIRA	10268388	2	D	0.500	0.500	1.000	3.000	0.090	4	Cylindrical	■
C5141-.500D2R125.0Z4	SIRA	10268389	2	D	0.500	0.500	1.000	3.000	0.125	4	Cylindrical	■
C5141-.625D2R015.0Z4	SIRA	10268390	2	D	0.625	0.625	1.250	3.500	0.015	4	Cylindrical	■
C5141-.625D2R030.0Z4	SIRA	10268391	2	D	0.625	0.625	1.250	3.500	0.030	4	Cylindrical	■
C5141-.625D2R060.0Z4	SIRA	10268392	2	D	0.625	0.625	1.250	3.500	0.060	4	Cylindrical	■
C5141-.625D2R125.0Z4	SIRA	10268393	2	D	0.625	0.625	1.250	3.500	0.125	4	Cylindrical	■
C5141-.750D2R015.0Z4	SIRA	10268394	2	D	0.750	0.750	1.500	4.000	0.015	4	Cylindrical	■
C5141-.750D2R020.0Z4	SIRA	10268395	2	D	0.750	0.750	1.500	4.000	0.020	4	Cylindrical	■
C5141-.750D2R030.0Z4	SIRA	10268396	2	D	0.750	0.750	1.500	4.000	0.030	4	Cylindrical	■
C5141-.750D2R045.0Z4	SIRA	10268397	2	D	0.750	0.750	1.500	4.000	0.045	4	Cylindrical	■
C5141-.750D2R060.0Z4	SIRA	10268398	2	D	0.750	0.750	1.500	4.000	0.060	4	Cylindrical	■
C5141-.750D2R090.0Z4	SIRA	10268399	2	D	0.750	0.750	1.500	4.000	0.090	4	Cylindrical	■
C5141-.750D2R125.0Z4	SIRA	10268400	2	D	0.750	0.750	1.500	4.000	0.125	4	Cylindrical	■
C5141-.750D2R190.0Z4	SIRA	10268402	2	D	0.750	0.750	1.500	4.000	0.190	4	Cylindrical	■
C5141-1.000D2R030.0Z4	SIRA	10268405	2	D	1.000	1.000	1.500	4.000	0.030	4	Cylindrical	■
C5141-1.000D2R060.0Z4	SIRA	10268406	2	D	1.000	1.000	1.500	4.000	0.060	4	Cylindrical	■
C5141-1.000D2R090.0Z4	SIRA	10268407	2	D	1.000	1.000	1.500	4.000	0.090	4	Cylindrical	■
C5141-1.000D2R125.0Z4	SIRA	10268408	2	D	1.000	1.000	1.500	4.000	0.125	4	Cylindrical	■
C5141-1.000D2R190.0Z4	SIRA	10268409	2	D	1.000	1.000	1.500	4.000	0.190	4	Cylindrical	■

■ **Prodotto standard.**

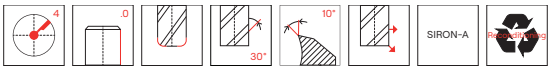
C5141

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





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.001"
—Riaffilatura possibile se DC è ≥Ø.375



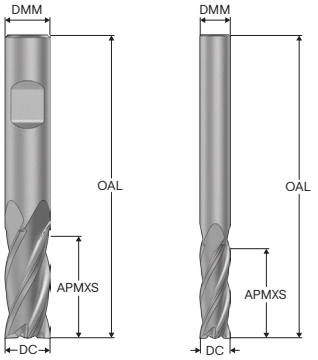
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
C5141-.188D3R015.0Z4	SIRA	10268363	3	D	0.188	0.188	0.625	2.000	0.015	4	Cylindrical	■
C5141-.188D3R020.0Z4	SIRA	10268364	3	D	0.188	0.188	0.625	2.000	0.020	4	Cylindrical	■
C5141-.188D3R030.0Z4	SIRA	10268365	3	D	0.188	0.188	0.625	2.000	0.030	4	Cylindrical	■
C5141-.250D3R015.0Z4	SIRA	10268366	3	D	0.250	0.250	0.750	2.500	0.015	4	Cylindrical	■
C5141-.250D3R020.0Z4	SIRA	10268367	3	D	0.250	0.250	0.750	2.500	0.020	4	Cylindrical	■
C5141-.250D3R030.0Z4	SIRA	10268368	3	D	0.250	0.250	0.750	2.500	0.030	4	Cylindrical	■
C5141-.250D3R045.0Z4	SIRA	10268369	3	D	0.250	0.250	0.750	2.500	0.045	4	Cylindrical	■
C5141-.313D3R015.0Z4	SIRA	10268370	3	D	0.313	0.313	0.813	2.500	0.015	4	Cylindrical	■
C5141-.313D3R020.0Z4	SIRA	10268371	3	D	0.313	0.313	0.813	2.500	0.020	4	Cylindrical	■
C5141-.313D3R030.0Z4	SIRA	10268372	3	D	0.313	0.313	0.813	2.500	0.030	4	Cylindrical	■
C5141-.313D3R045.0Z4	SIRA	10268373	3	D	0.313	0.313	0.813	2.500	0.045	4	Cylindrical	■
C5141-.375D3R015.0Z4	SIRA	10268374	3	D	0.375	0.375	1.000	2.500	0.015	4	Cylindrical	■
C5141-.375D3R020.0Z4	SIRA	10268375	3	D	0.375	0.375	1.000	2.500	0.020	4	Cylindrical	■
C5141-.375D3R030.0Z4	SIRA	10268376	3	D	0.375	0.375	1.000	2.500	0.030	4	Cylindrical	■
C5141-.375D3R045.0Z4	SIRA	10268377	3	D	0.375	0.375	1.000	2.500	0.045	4	Cylindrical	■
C5141-.125D4R015.0Z4	SIRA	10268360	4	D	0.125	0.125	0.500	1.500	0.015	4	Cylindrical	■
C5141-.125D4R020.0Z4	SIRA	10268361	4	D	0.125	0.125	0.500	1.500	0.020	4	Cylindrical	■
C5141-.125D4R030.0Z4	SIRA	10268362	4	D	0.125	0.125	0.500	1.500	0.030	4	Cylindrical	■

■ Prodotto standard.

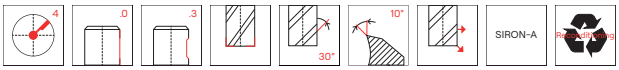
C5141

Uso generico – Universale – Spallamento – 4 Eliche – Cilindrico/Weldon – Spigolo vivo – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.001"/-.000"
—Tolleranza NC
—Riaffilatura possibile se DC è ≥Ø.375



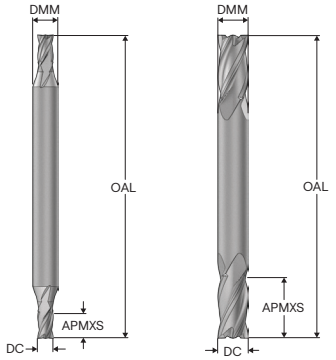
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5141-.375D2S.3Z4NC	SIRA	10268423	2	D	0.375	0.375	0.875	2.500	4	Weldon	■
C5141-.500D2S.3Z4NC	SIRA	10268424	2	D	0.500	0.500	1.000	3.000	4	Weldon	■
C5141-.625D2S.3Z4NC	SIRA	10268425	2	D	0.625	0.625	1.250	3.500	4	Weldon	■
C5141-.750D2S.3Z4NC	SIRA	10268426	2	D	0.750	0.750	1.500	4.000	4	Weldon	■
C5141-1.000D2S.3Z4NC	SIRA	10268427	2	D	1.000	1.000	1.500	4.000	4	Weldon	■
C5141-.250D3S.0Z4NC	SIRA	10268421	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
C5141-.313D3S.0Z4NC	SIRA	10268422	3	D	0.313	0.313	0.813	2.500	4	Cylindrical	■

■ **Prodotto standard.**

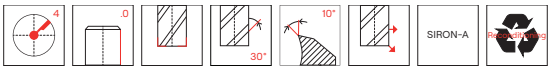
C5141

Uso generico – Universale – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Fresa integrale bilaterale
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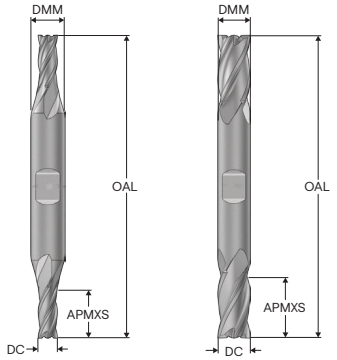
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5141-.438D1S.0Z4D	SIRA	10268446	1	D	0.438	0.438	0.563	2.750	4	Cylindrical	■
C5141-.500D1S.0Z4D	SIRA	10268447	1	D	0.500	0.500	0.625	3.000	4	Cylindrical	■
C5141-.031F2S.0Z4D	SIRA	10268428	2	F	0.031	0.125	0.063	1.500	4	Cylindrical	■
C5141-.047F2S.0Z4D	SIRA	10268429	2	F	0.047	0.125	0.094	1.500	4	Cylindrical	■
C5141-.063F2S.0Z4D	SIRA	10268430	2	F	0.063	0.125	0.125	1.500	4	Cylindrical	■
C5141-.078F2S.0Z4D	SIRA	10268431	2	F	0.078	0.125	0.125	1.500	4	Cylindrical	■
C5141-.094F2S.0Z4D	SIRA	10268432	2	F	0.094	0.125	0.188	1.500	4	Cylindrical	■
C5141-.109F2S.0Z4D	SIRA	10268433	2	F	0.109	0.125	0.188	1.500	4	Cylindrical	■
C5141-.125D2S.0Z4D	SIRA	10268434	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
C5141-.141F2S.0Z4D	SIRA	10268435	2	F	0.141	0.188	0.313	2.000	4	Cylindrical	■
C5141-.156F2S.0Z4D	SIRA	10268436	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
C5141-.172F2S.0Z4D	SIRA	10268437	2	F	0.172	0.188	0.313	2.000	4	Cylindrical	■
C5141-.188D2S.0Z4D	SIRA	10268438	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
C5141-.203F2S.0Z4D	SIRA	10268439	2	F	0.203	0.250	0.500	2.500	4	Cylindrical	■
C5141-.219F2S.0Z4D	SIRA	10268440	2	F	0.219	0.250	0.500	2.500	4	Cylindrical	■
C5141-.234F2S.0Z4D	SIRA	10268441	2	F	0.234	0.250	0.500	2.500	4	Cylindrical	■
C5141-.250D2S.0Z4D	SIRA	10268442	2	D	0.250	0.250	0.500	2.500	4	Cylindrical	■
C5141-.281F2S.0Z4D	SIRA	10268443	2	F	0.281	0.313	0.500	2.500	4	Cylindrical	■
C5141-.313D2S.0Z4D	SIRA	10268444	2	D	0.313	0.313	0.500	2.500	4	Cylindrical	■
C5141-.375D2S.0Z4D	SIRA	10268445	2	D	0.375	0.375	0.563	2.500	4	Cylindrical	■

■ **Prodotto standard.**

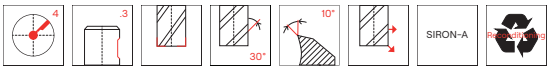
C5141

Uso generico – Universale – Spallamento – 4 Eliche – Weldon – Spigolo vivo – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Fresa integrale bilaterale
—Riaffilatura possibile se DC è ≥Ø.375



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5141-.281F2S.3Z4D	SIRA	10268415	2	F	0.281	0.375	0.688	3.500	4	Weldon	■
C5141-.313F2S.3Z4D	SIRA	10268416	2	F	0.313	0.375	0.750	3.500	4	Weldon	■
C5141-.344F2S.3Z4D	SIRA	10268417	2	F	0.344	0.375	0.750	3.500	4	Weldon	■
C5141-.375D2S.3Z4D	SIRA	10268418	2	D	0.375	0.375	0.750	3.500	4	Weldon	■
C5141-.438F2S.3Z4D	SIRA	10268419	2	F	0.438	0.500	0.875	4.000	4	Weldon	■
C5141-.500D2S.3Z4D	SIRA	10268420	2	D	0.500	0.500	1.000	4.000	4	Weldon	■
C5141-.125F3S.3Z4D	SIRA	10268410	3	F	0.125	0.375	0.375	3.063	4	Weldon	■
C5141-.156F3S.3Z4D	SIRA	10268411	3	F	0.156	0.375	0.438	3.125	4	Weldon	■
C5141-.188F3S.3Z4D	SIRA	10268412	3	F	0.188	0.375	0.500	3.250	4	Weldon	■
C5141-.219F3S.3Z4D	SIRA	10268413	3	F	0.219	0.375	0.563	3.375	4	Weldon	■
C5141-.250F3S.3Z4D	SIRA	10268414	3	F	0.250	0.375	0.625	3.375	4	Weldon	■

■ **Prodotto standard.**

Parametri di taglio – C5141 Contornatura

SMG		a_e/DC	a_p/DC	f_z														v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	16	20	
P1	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	150 (135 — 165)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*490 (440— 540)*
P2	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	58 (45— 70)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*190 (147 — 230)*
P3	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	85 (70 — 95)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*279 (246 — 312)*
P4	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	100 (90 — 110)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*330 (295 — 360)*
P5	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	68 (50 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*223 (165 — 245)*
P6	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	87 (77 — 100)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*285 (250 — 330)*
P7	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	65 (55 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*213 (180 — 245)*
P8	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	65 (50 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*213 (165 — 245)*
P11	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	85 (70 — 95)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*280 (230 — 310)*
P12	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	55 (45— 65)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*180 (147 — 213)*
M1	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	93 (83 — 100)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*305 (270 — 360)*
M2	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	60 (50 — 70)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*200 (165 — 230)*
M3	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	55 (45 —65)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*180 (147 — 213)*
M4	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,09	45 (35 — 55)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0036*	*147 (115 — 180)*
M5	E	0,1	2	0,0044	0,0065	0,0085	0,013	0,015	0,017	0,022	0,026	0,034	0,038	0,042	0,05	0,07	0,085	35 (20 — 45)
		0.10	*2.0*	*0.00017*	*0.00026*	*0.00034*	*0.00050*	*0.00060*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0028*	*0.0034*	*114 (65 — 147)*
K1	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	80 (70 — 90)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*260 (230 — 290)*
K2	E	0,1	2	0,0055	0,0085	0,011	0,017	0,02	0,022	0,028	0,034	0,044	0,05	0,055	0,065	0,09	0,11	87 (75 — 100)
		0.10	*2.0*	*0.00022*	*0.00034*	*0.00044*	*0.00065*	*0.00080*	*0.00085*	*0.0011*	*0.0013*	*0.0017*	*0.0020*	*0.0022*	*0.0026*	*0.0036*	*0.0044*	*285 (245 — 330)*
K3	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	65 (55 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*213 (180 — 245)*
K4	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	50 (35 — 65)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*165 (115 — 213)*
K5	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	45 (30 — 55)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*147 (100 — 180)*
K6	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	77 (65 — 85)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*250 (210 — 280)*
K7	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	77 (60 — 90)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*250 (200 — 290)*
S1	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	50 (35 — 60)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*165 (115 — 200)*
S2	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	25 (15 — 35)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*82 (50 — 115)*
S3	E	0,1	2	0,002	0,0032	0,0042	0,0065	0,0075	0,0085	0,01	0,013	0,017	0,019	0,02	0,025	0,034	0,042	11 (7,5 — 16)
		0.10	*2.0*	*0.000080*	*0.00013*	*0.00017*	*0.00026*	*0.00030*	*0.00034*	*0.00040*	*0.00050*	*0.00065*	*0.00075*	*0.00080*	*0.0010*	*0.0013*	*0.0017*	*35 (25 — 52)*
S11	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	110 (95— 120)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*360 (311 — 390)*
S12	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	77 (60 — 90)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*250 (190 — 290)*
S13	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	30 (20 — 40)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*100 (65 — 130)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – C5141 Contornatura – Pollici

SMG		a_p/DC	f_z														v_c
			1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	1 1/4	
P1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	0,075	150 (135 — 165)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*0.0030*	*490 (440— 540)*
P2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	58 (45— 70)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*190 (147 — 230)*
P3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	85 (70 — 95)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*279 (246 — 312)*
P4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	100 (90 — 110)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*330 (295 — 360)*
P5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	68 (50 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*223 (165 — 245)*
P6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	87 (77 — 100)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*285 (250 — 330)*
P7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	65 (55 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*213 (180 — 245)*
P8	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	65 (50 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*213 (165 — 245)*
P11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	85 (70 — 95)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*280 (230 — 310)*
P12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	55 (45— 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*180 (147 — 213)*
M1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	93 (83 — 100)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*305 (270 — 360)*
M2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	60 (50 — 70)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*200 (165 — 230)*
M3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	55 (45 —65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*180 (147 — 213)*
M4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	45 (35 — 55)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*147 (115 — 180)*
M5	E	1	0,001	0,002	0,0042	0,005	0,006	0,007	0,0085	0,01	0,012	0,017	0,02	0,025	0,034	0,042	35 (20 — 45)
		1.0	*0.000040*	*0.000080*	*0.00017*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0017*	*114 (65 — 147)*
K1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	0,075	80 (70 — 90)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*0.0030*	*260 (230 — 290)*
K2	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	0,075	87 (75 — 100)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*0.0030*	*285 (245 — 330)*
K3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	65 (55 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*213 (180 — 245)*
K4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	50 (35 — 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*165 (115 — 213)*
K5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	45 (30 — 55)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*147 (100 — 180)*
K6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	77 (65 — 85)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*250 (210 — 280)*
K7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	77 (60 — 90)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*250 (200 — 290)*
S1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	50 (35 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*165 (115 — 200)*
S2	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	0,032	25 (15 — 35)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0013*	*82 (50 — 115)*
S3	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	0,032	11 (7,5 — 16)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0013*	*35 (25 — 52)*
S11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	110 (95— 120)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*360 (311 — 390)*
S12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	77 (60 — 90)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*250 (190 — 290)*
S13	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	30 (20 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*100 (65 — 130)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – C5141 Scanalatura

SMG		a_p/DC	f_z														v_c
			1	1,5	2	3	3,5	4	5	6	8	9	10	12	16	20	
P1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	0,036	0,046	75 (50 — 85)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*0.0014*	*0.0018*	*245 (170 — 270)*
P2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (20 —40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*100 (66 — 130)*
P3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*147 (98— 196)*
P4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	55 (40 — 65)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*180 (130 —210)*
P5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65— 145)*
P6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*145 (180 — 195)*
P7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65 — 165)*
P8	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	25 (15 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*80 (50 — 110)*
P11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (65 — 138)*
P12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	30 (20 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*100 (65 — 130)*
M1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	42 (21 — 52)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*138 (69 — 170)*
M2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (65 — 138)*
M3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	30 (15 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*100 (50 — 130)*
M4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	22 (10 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*72 (33 — 115)*
M5	E	1	0,0013	0,002	0,0026	0,004	0,0046	0,005	0,0065	0,008	0,01	0,012	0,013	0,016	0,02	0,026	19 (16 — 30)
		1.0	*0.000050*	*0.000080*	*0.00010*	*0.00016*	*0.00018*	*0.00020*	*0.00026*	*0.00032*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*0.00080*	*0.0010*	*62 (52 — 100)*
K1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	0,036	0,046	30 (20 — 45)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*0.0014*	*0.0018*	*100 (65 — 147)*
K2	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	0,036	0,046	40 (30 — 50)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*0.0014*	*0.0018*	*130 (100 — 165)*
K3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (26 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (85 — 148)*
K4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	22 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*72 (60 — 100)*
K5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	20 (15 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*65 (50 — 100)*
K6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65 — 165)*
K7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65 — 165)*
S1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	25 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*80 (60 — 100)*
S2	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	0,016	0,02	13 (9 — 18)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*62 (30 — 60)*
S3	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	0,016	0,02	7,0 (5 — 12)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*23 (15— 39)*
S11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (25 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*114 (82— 130)*
S12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (22 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (72 — 130)*
S13	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	10 (8— 15)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*33 (26 — 50)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – C5141 Scanalatura – Pollici

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	1 1/4	
P1	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,16	75 (50 — 85)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0065*	*245 (170 — 270)*
P2	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	32 (20 —40)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*100 (66 — 130)*
P3	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	45 (30 — 60)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*147 (98— 196)*
P4	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	55 (40 — 65)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*180 (130 —210)*
P5	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 45)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65— 145)*
P6	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	45 (30 — 60)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*145 (180 — 195)*
P7	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 50)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65 — 165)*
P8	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	25 (15 — 35)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*80 (50 — 110)*
P11	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	32 (20 — 42)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*105 (65 — 138)*
P12	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	30 (20 — 40)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*100 (65 — 130)*
M1	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,16	42 (21 — 52)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0065*	*138 (69 — 170)*
M2	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,16	32 (20 — 42)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0065*	*105 (65 — 138)*
M3	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,13	30 (15 — 40)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0050*	*100 (50 — 130)*
M4	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,09	0,1	0,11	22 (10 — 35)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*72 (33 — 115)*
M5	E	0,1	2	0,0034	0,007	0,014	0,017	0,02	0,024	0,028	0,034	0,04	0,055	0,07	0,08	0,11	0,14	19 (16 — 30)
		0.10	*2.0*	*0.00013*	*0.00028*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0011*	*0.0013*	*0.0016*	*0.0022*	*0.0028*	*0.0032*	*0.0044*	*0.0055*	*62 (52 — 100)*
K1	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	30 (20 — 45)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*100 (65 — 147)*
K2	E	0,1	2	0,0044	0,009	0,018	0,022	0,026	0,032	0,036	0,044	0,055	0,07	0,09	0,11	0,14	0,18	40 (30 — 50)
		0.10	*2.0*	*0.00017*	*0.00036*	*0.00070*	*0.00085*	*0.0010*	*0.0013*	*0.0014*	*0.0017*	*0.0022*	*0.0028*	*0.0036*	*0.0044*	*0.0055*	*0.0070*	*130 (100 — 165)*
K3	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	32 (26 — 45)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*105 (85 — 148)*
K4	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	22 (18 — 30)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*72 (60 — 100)*
K5	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	20 (15 — 30)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*65 (50 — 100)*
K6	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 50)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65 — 165)*
K7	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 50)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65 — 165)*
S1	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	25 (18 — 30)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*80 (60 — 100)*
S2	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	13 (9 — 18)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*62 (30 — 60)*
S3	E	0,1	2	0,0017	0,0034	0,0065	0,0085	0,01	0,012	0,013	0,017	0,02	0,026	0,034	0,04	0,055	0,065	7,0 (5 — 12)
		0.10	*2.0*	*0.000065*	*0.00013*	*0.00026*	*0.00034*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0016*	*0.0022*	*0.0026*	*23 (15— 39)*
S11	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (25 — 40)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*114 (82— 130)*
S12	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	32 (22 — 40)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*105 (72 — 130)*
S13	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	10 (8— 15)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*33 (26 — 50)*

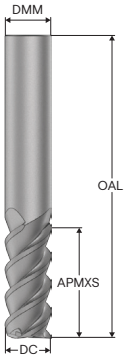
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

C5231/C5241

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





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Riaffilatura possibile se DC è ≥Ø.375



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
C5231-.375D2S.0Z3	SIRA	10268591	2	D	0.375	0.375	0.875	2.500	3	Cylindrical	■
C5231-.500D2S.0Z3	SIRA	10268592	2	D	0.500	0.500	1.000	3.000	3	Cylindrical	■
C5231-.625D2S.0Z3	SIRA	10268593	2	D	0.625	0.625	1.250	3.500	3	Cylindrical	■
C5231-.250D3S.0Z3	SIRA	10268590	3	D	0.250	0.250	0.750	2.500	3	Cylindrical	■
C5241-.750D3S.0Z4	SIRA	10268594	3	D	0.750	0.750	1.500	4.000	4	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – C5231-C5241 Contornatura – Pollici

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/4	3/8	1/2	5/8	3/4	1	
P1	E	0,1 *0.10*	2 *2.0*	0,04 *0.0016*	0,058 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	150 (135 — 165) *490 (440— 540)*
P2	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	58 (45— 70) *190 (147 — 230)*
P3	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	55 (45— 65) *180 (147 — 213)*
M1	E	0,1 *0.10*	2 *2.0*	0,04 *0.0016*	0,0575 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,1 *0.10*	2 *2.0*	0,04 *0.0016*	0,0023 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,1 *0.10*	2 *2.0*	0,0016 *0.0016*	0,0023 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	55 (45 —65) *180 (147 — 213)*
M4	E	0,1 *0.10*	2 *2.0*	0,0016 *0.0016*	0,058 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0045*	0,13 *0.005*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,1 *0.10*	2 *2.0*	0,035 *0.0014*	0,05 *0.002*	0,069 *0.0028*	0,088 *0.0035*	0,1 *0.004*	0,14 *0.0055*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,1 *0.10*	2 *2.0*	0,045 *0.0018*	0,069 *0.0028*	0,063 *0.0035*	0,11 *0.0045*	0,14 *0.0055*	0,18 *0.0069*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,1 *0.10*	2 *2.0*	0,016 *0.00063*	0,025 *0.001*	0,033 *0.0013*	0,043 *0.0016*	0,05 *0.002*	0,069 *0.0028*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	110 (95— 120) *360 (311 — 390)*
S12	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	30 (20 — 40) *100 (65 — 130)*

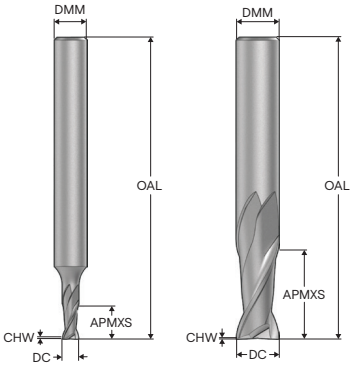
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

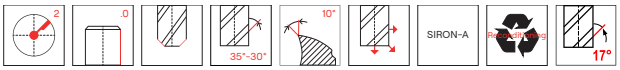
JSE512

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





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



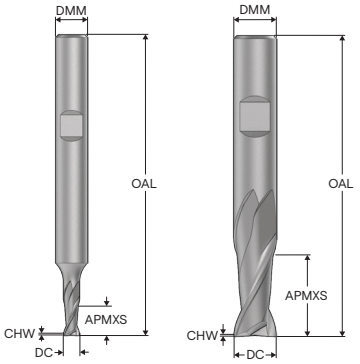
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JSE512021F2C.0Z2	SIRA	10052986	2	F	2,0	3,0	4,0	50,0	0,02	2	Cylindrical	■
JSE512020F2C.0Z2	SIRA	10052990	2	F	2,0	6,0	4,0	57,0	0,02	2	Cylindrical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

■ **Prodotto standard.**

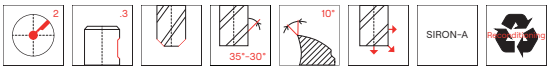
JSE512

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	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JSE512020F2C.3Z2	SIRA	10053113	2	F	2,0	6,0	4,0	57,0	0,02	2	Weldon	■
JSE512030F2C.3Z2	SIRA	10053114	2	F	3,0	6,0	6,0	57,0	0,03	2	Weldon	■
JSE512040F2C.3Z2	SIRA	10053115	2	F	4,0	6,0	8,0	57,0	0,04	2	Weldon	■
JSE512060D2C.3Z2	SIRA	10053116	2	D	6,0	6,0	12,0	57,0	0,06	2	Weldon	■
JSE512080D2C.3Z2	SIRA	10053117	2	D	8,0	8,0	16,0	63,0	0,08	2	Weldon	■
JSE512100D2C.3Z2	SIRA	10053118	2	D	10,0	10,0	20,0	72,0	0,1	2	Weldon	■
JSE512120D2C.3Z2	SIRA	10053119	2	D	12,0	12,0	24,0	83,0	0,12	2	Weldon	■

■ **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 699 - 707

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)*

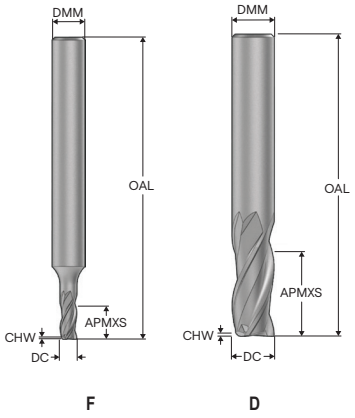
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

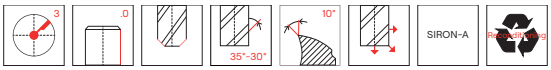
JSE513

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





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



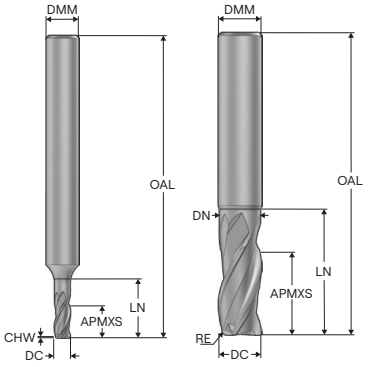
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JSE513020F2C.0Z3	SIRA	10053000	2	F	2,0	6,0	4,0	57,0	0,02	3	Cylindrical	■
JSE513025F2C.0Z3	SIRA	10053001	2	F	2,5	6,0	5,0	57,0	0,025	3	Cylindrical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

■ **Prodotto standard.**

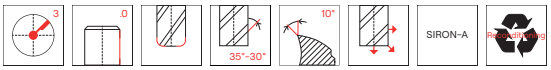
JSE513

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





G E



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

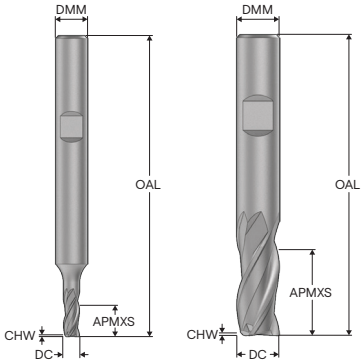
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JSE513030G2R050.0Z3	SIRA	10053023	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	3	Cylindrical	■
JSE513040G2R050.0Z3	SIRA	10053024	2	G	4,0	6,0	8,0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

■ **Prodotto standard.**

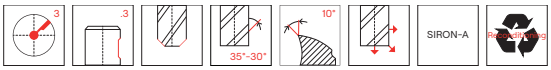
JSE513

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





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



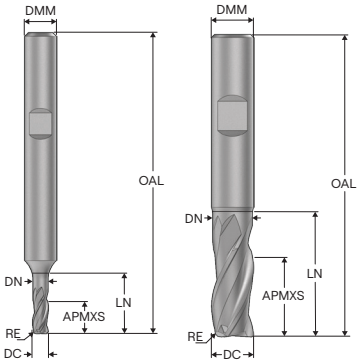
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JSE513020F2C.3Z3	SIRA	10053120	2	F	2,0	6,0	4,0	57,0	0,02	3	Weldon	■
JSE513025F2C.3Z3	SIRA	10053121	2	F	2,5	6,0	5,0	57,0	0,025	3	Weldon	■
JSE513030F2C.3Z3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

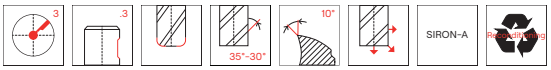
■ **Prodotto standard.**

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	Attacco	Prodotto standard
					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	Weldon	■
JSE513040G2R050.3Z3	SIRA	10053261	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	3	Weldon	■
JSE513050G2R050.3Z3	SIRA	10053262	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	3	Weldon	■
JSE513060E2R050.3Z3	SIRA	10053263	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	3	Weldon	■
JSE513060E2R100.3Z3	SIRA	10053269	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	3	Weldon	■
JSE513080E2R050.3Z3	SIRA	10053264	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	Weldon	■
JSE513080E2R100.3Z3	SIRA	10053270	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	Weldon	■
JSE513100E2R050.3Z3	SIRA	10053265	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	3	Weldon	■
JSE513100E2R100.3Z3	SIRA	10053271	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	3	Weldon	■
JSE513120E2R050.3Z3	SIRA	10053266	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	3	Weldon	■
JSE513120E2R100.3Z3	SIRA	10053272	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	3	Weldon	■
JSE513160E2R050.3Z3	SIRA	10053267	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	3	Weldon	■
JSE513200E2R050.3Z3	SIRA	10053268	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	3	Weldon	■

■ **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 699 - 707

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)*

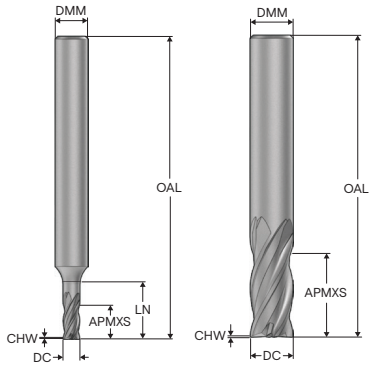
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

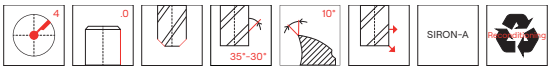
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

JSE514

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







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

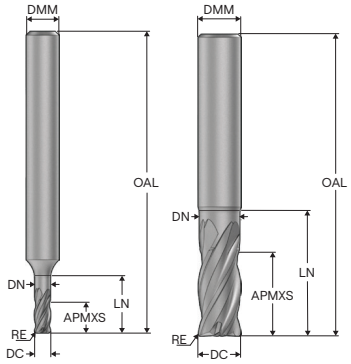
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JSE514021F2C.0Z4	SIRA	10053053	2	F	2,0	3,0	4,0	50,0	0,02	4	Cylindrical	■
JSE514020F2C.0Z4	SIRA	10053057	2	F	2,0	6,0	4,0	57,0	0,02	4	Cylindrical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

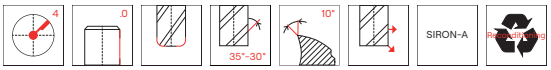
■ **Prodotto standard.**

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

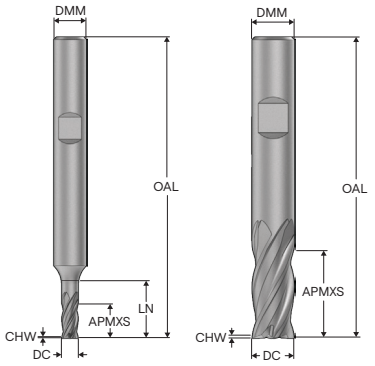
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JSE514030G2R050.0Z4	SIRA	10053071	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	Cylindrical	■
JSE514040G2R050.0Z4	SIRA	10053072	2	G	4,0	6,0	8,0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

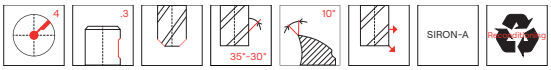
■ **Prodotto standard.**

JSE514

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







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

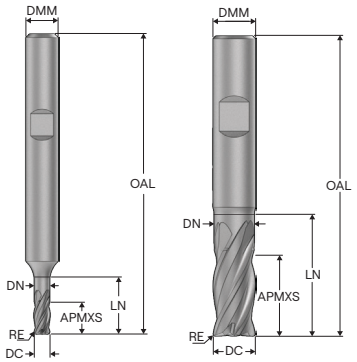
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JSE514020F2C.3Z4	SIRA	10053289	2	F	2,0	6,0	4,0	57,0	0,02	4	Weldon	■
JSE514030F2C.3Z4	SIRA	10053290	2	F	3,0	6,0	6,0	57,0	0,03	4	Weldon	■
JSE514040F2C.3Z4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

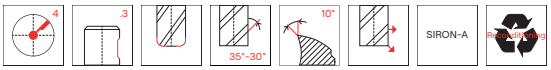
■ **Prodotto standard.**

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

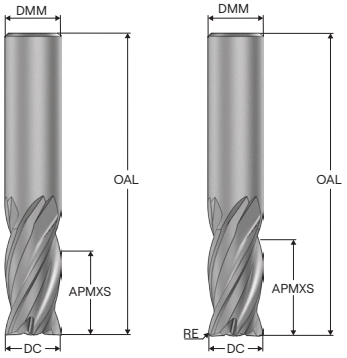
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JSE514030G2R050.3Z4	SIRA	10053301	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	Weldon	■
JSE514040G2R050.3Z4	SIRA	10053302	2	G	4,0	6,0	8,0	57,0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

■ **Prodotto standard.**

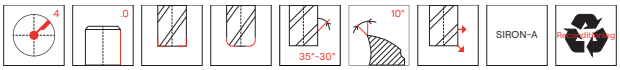
JSE514

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



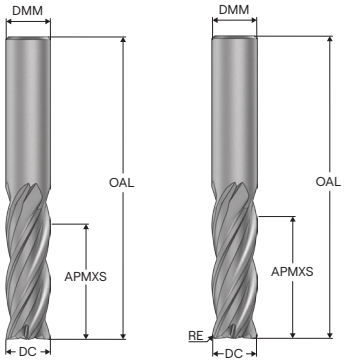
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
JSE514.250D1S.0Z4	SIRA	10201805	1	D	0.250	0.250	0.375	2.000	–	4	Cylindrical	■
JSE514.250D1R030.0Z4	SIRA	10201812	1	D	0.250	0.250	0.375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

■ **Prodotto standard.**

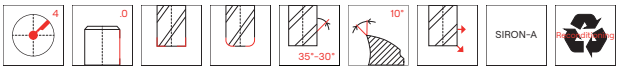
JSE514

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	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
JSE514.125D3S.0Z4	SIRA	10201820	3	D	0.125	0.125	0.500	1.500	–	4	Cylindrical	■
JSE514.125D3R015.0Z4	SIRA	10201827	3	D	0.125	0.125	0.500	1.500	0.015	4	Cylindrical	■
JSE514.188D3S.0Z4	SIRA	10201821	3	D	0.188	0.188	0.625	2.000	–	4	Cylindrical	■
JSE514.188D3R020.0Z4	SIRA	10201828	3	D	0.188	0.188	0.625	2.000	0.020	4	Cylindrical	■
JSE514.250D3S.0Z4	SIRA	10201837	3	D	0.250	0.250	0.750	2.500	–	4	Cylindrical	■
JSE514.250D3R030.0Z4	SIRA	10201842	3	D	0.250	0.250	0.750	2.500	0.030	4	Cylindrical	■
JSE514.375D3S.0Z4	SIRA	10201838	3	D	0.375	0.375	1.000	2.500	–	4	Cylindrical	■
JSE514.375D3R030.0Z4	SIRA	10201843	3	D	0.375	0.375	1.000	2.500	0.030	4	Cylindrical	■
JSE514.500D3S.0Z4	SIRA	10201839	3	D	0.500	0.500	2.000	4.000	–	4	Cylindrical	■
JSE514.500D3R030.0Z4	SIRA	10201844	3	D	0.500	0.500	2.000	4.000	0.030	4	Cylindrical	■
JSE514.500D3R060.0Z4	SIRA	10201845	3	D	0.500	0.500	2.000	4.000	0.060	4	Cylindrical	■
JSE514.625D3S.0Z4	SIRA	10201840	3	D	0.625	0.625	2.250	5.000	–	4	Cylindrical	■
JSE514.625D3R030.0Z4	SIRA	10201846	3	D	0.625	0.625	2.250	5.000	0.030	4	Cylindrical	■
JSE514.625D3R060.0Z4	SIRA	10201847	3	D	0.625	0.625	2.250	5.000	0.060	4	Cylindrical	■
JSE514.750D3S.0Z4	SIRA	10201841	3	D	0.750	0.750	2.250	5.000	–	4	Cylindrical	■
JSE514.750D3R030.0Z4	SIRA	10201848	3	D	0.750	0.750	2.250	5.000	0.030	4	Cylindrical	■
JSE514.750D3R060.0Z4	SIRA	10201849	3	D	0.750	0.750	2.250	5.000	0.060	4	Cylindrical	■

■ **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 699 - 707

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 699 - 707

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 699 - 707

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)*

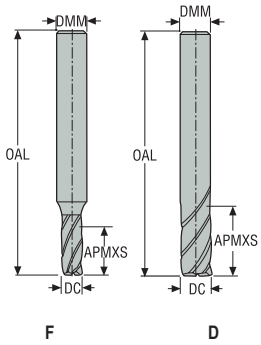
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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



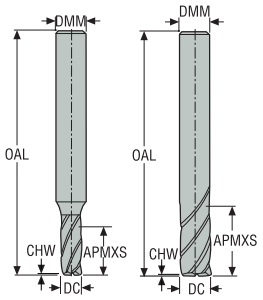
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm			
553020SZ3.0-SIRON-A	02733903	2	F	2,0	6,0	5,0	50,0	3	Cylindrical	■
553030SZ3.0-SIRON-A	02733906	2	F	3,0	6,0	7,0	50,0	3	Cylindrical	■
553040SZ3.0-SIRON-A	02733910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

■ **Prodotto standard.**

JS553

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





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



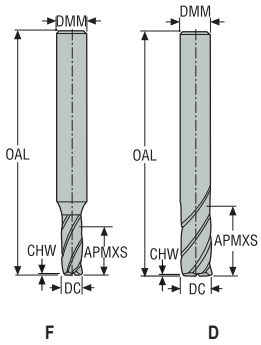
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS553020F1C.0Z3-SIRA	10041466	1	F	2,0	6,0	3,0	40,0	0,025	3	Cylindrical	■
JS553030F1C.0Z3-SIRA	10041467	1	F	3,0	6,0	4,0	40,0	0,035	3	Cylindrical	■
JS553040F1C.0Z3-SIRA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

■ **Prodotto standard.**

JS553

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





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



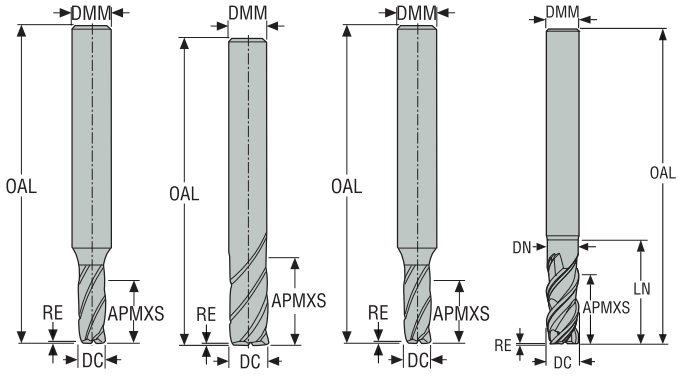
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
553L020Z3.0-SIRON-A	02733962	3	F	2,0	6,0	7,0	50,0	0,025	3	Cylindrical	■
553L030Z3.0-SIRON-A	02733971	3	F	3,0	6,0	10,0	55,0	0,035	3	Cylindrical	■
553L040Z3.0-SIRON-A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

■ **Prodotto standard.**

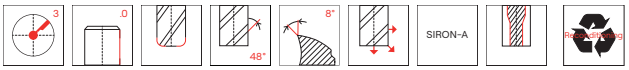
JS553

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





F



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

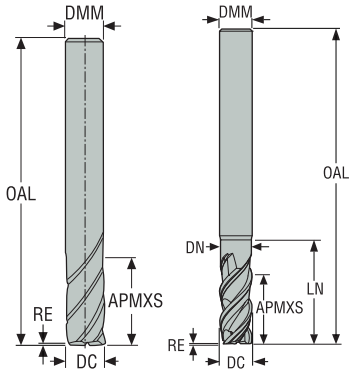
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS553020F1R020.0Z3-SIRA	10194458	1	F	2,0	6,0	3,0	40,0	–	–	0,2	3	Cylindrical	■
JS553030F1R020.0Z3-SIRA	10194459	1	F	3,0	6,0	4,0	40,0	–	–	0,2	3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

■ **Prodotto standard.**

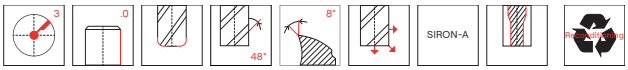
JS553

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





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



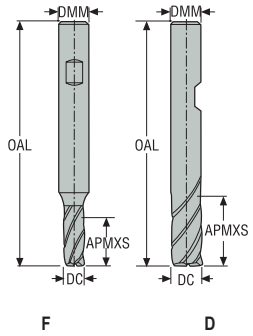
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
553160R050Z3.0-SIRON-A	02679385	2	D	16,0	16,0	34,0	90,0	–	–	0,5	3	Cylindrical	■
553160R100Z3.0-SIRON-A	02679386	2	D	16,0	16,0	34,0	90,0	–	–	1,0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

■ **Prodotto standard.**

JS553

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





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



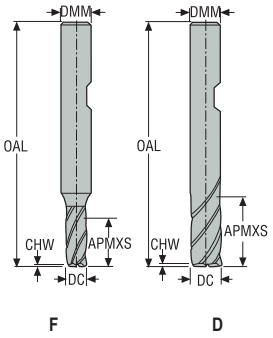
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm			
553020SZ3.0-SIRON-AW	02733936	2	F	2,0	6,0	5,0	50,0	3	Weldon	■
553030SZ3.0-SIRON-AW	02733939	2	F	3,0	6,0	7,0	50,0	3	Weldon	■
553040SZ3.0-SIRON-AW	02733943	2	F	4,0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

■ **Prodotto standard.**

JS553

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





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



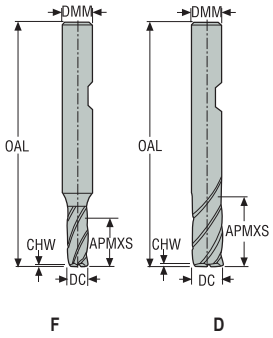
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS553020F1C.3Z3-SIRA	10041477	1	F	2,0	6,0	3,0	40,0	0,025	3	Weldon	■
JS553030F1C.3Z3-SIRA	10041478	1	F	3,0	6,0	4,0	40,0	0,035	3	Weldon	■
JS553040F1C.3Z3-SIRA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

■ **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



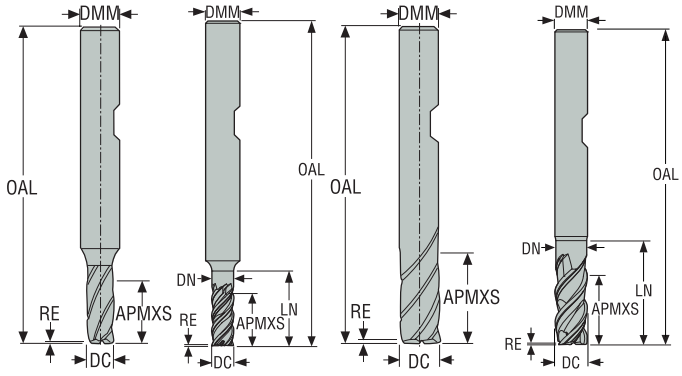
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
553L020Z3.0-SIRON-AW	02734001	3	F	2,0	6,0	7,0	50,0	0,025	3	Weldon	■
553L030Z3.0-SIRON-AW	02734006	3	F	3,0	6,0	10,0	55,0	0,035	3	Weldon	■
553L040Z3.0-SIRON-AW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

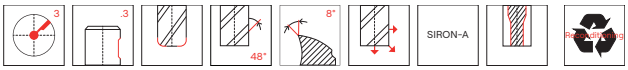
■ **Prodotto standard.** □ Weldon disponibile. Il tempo di consegna è di 3 giorni.

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

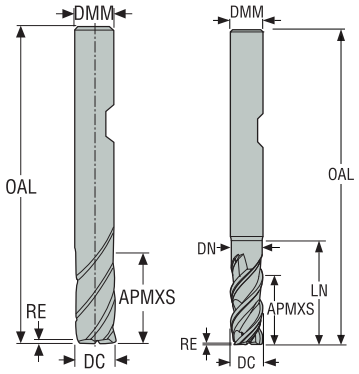
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS553080D1R050.3Z3-SIRA	10194469	1	D	8,0	8,0	11,0	50,0	–	–	0,5	3	Weldon	□
JS553100D1R050.3Z3-SIRA	10194470	1	D	10,0	10,0	13,0	57,0	–	–	0,5	3	Weldon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

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

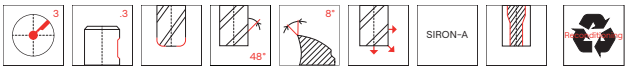
JS553

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





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



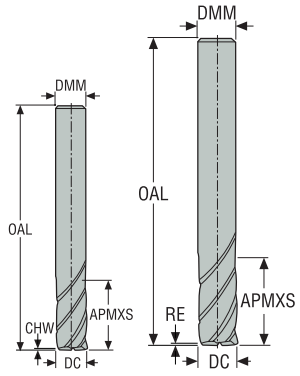
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
553160R050Z3.0-SIRON-AW	02700378	2	D	16,0	16,0	34,0	90,0	–	–	0,5	3	Weldon	□
553160R100Z3.0-SIRON-AW	02700381	2	D	16,0	16,0	34,0	90,0	–	–	1,0	3	Weldon	□
553160R200Z3.3-SIRON-A	02810428	2	D	16,0	16,0	34,0	90,0	–	–	2,0	3	Weldon	□
553160R250Z3.3-SIRON-A	02810429	2	D	16,0	16,0	34,0	90,0	–	–	2,5	3	Weldon	□
553160R310Z3.3-SIRON-A	02810430	2	D	16,0	16,0	34,0	90,0	–	–	3,1	3	Weldon	□
553160R400Z3.3-SIRON-A	02810431	2	D	16,0	16,0	34,0	90,0	–	–	4,0	3	Weldon	□
553200R050Z3.0-SIRON-AW	02700383	2	D	20,0	20,0	42,0	110,0	–	–	0,5	3	Weldon	■
553200R100Z3.0-SIRON-AW	02700384	2	D	20,0	20,0	42,0	110,0	–	–	1,0	3	Weldon	□
JS553200E2R200.3Z3-SIRA	02881696	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	3	Weldon	□
553250R050Z3.0-SIRON-AW	02700386	2	D	25,0	25,0	52,0	125,0	–	–	0,5	3	Weldon	□
553250R100Z3.0-SIRON-AW	02700385	2	D	25,0	25,0	52,0	125,0	–	–	1,0	3	Weldon	□

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

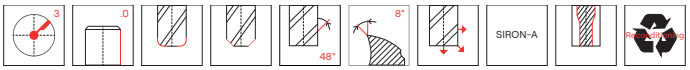
JS553

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



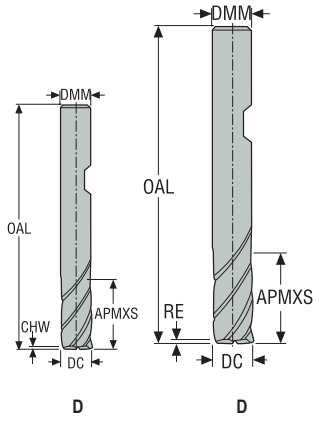
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Attacco	Prodotto standard
				inch	inch	inch	inch	inch	inch			
5530125Z3.0-SIRON-A	02712684	2	D	0.125	0.125	0.250	2.000	0.001	–	3	Cylindrical	■
5530187Z3.0-SIRON-A	02712687	2	D	0.188	0.188	0.375	2.000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

■ **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	Attacco	Prodotto standard
				inch	inch	inch	inch	inch	inch			
5530500Z3.3-SIRON-A	02712697	2	D	0.500	0.500	1.000	3.500	0.006	–	3	Weldon	■
5530500R015Z3.3-SIRON-A	02712700	2	D	0.500	0.500	1.000	3.500	–	0.015	3	Weldon	■
5530500R030Z3.3-SIRON-A	02712702	2	D	0.500	0.500	1.000	3.500	–	0.030	3	Weldon	■

■ **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 699 - 707

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 699 - 707

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 *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*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	195 (170 — 220) *640 (560 — 720)*
P2	M/A/D/E	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*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	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*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	165 (140 — 180) *540 (460 — 590)*
P4	M/A/D/E	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*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	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*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	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*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	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*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	145 (130 — 160) *475 (430 — 520)*
P8	M/A/D/E	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*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	135 (120 — 150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	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*	130 (120 — 140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	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*	0.11 *0,0044*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	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*	95 (85 — 100) *310 (280 — 320)*
M2	E	0.80 *0,80*	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*	0.11 *0,0044*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.70 *0,70*	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*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	48 (39 — 58) *155 (130 — 190)*
M4	E	0.70 *0,70*	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*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	36 (30 — 43) *120 (99 — 140)*
M5	E	0.70 *0,70*	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*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	30 (25 — 36) *100 (83 — 110)*
K1	E	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	145 (140 — 170) *475 (460 — 550)*
K2	E	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	125 (120 — 150) *410 (400 — 490)*
K3	E	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	110 (110 — 120) *360 (370 — 390)*
K4	E	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	105 (96 — 120) *345 (320 — 390)*
K5	E	0.80 *0,80*	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*	135 (120 — 150) *445 (400 — 490)*
K6	E	0.80 *0,80*	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*	200 (180 — 230) *660 (600 — 750)*
K7	E	0.80 *0,80*	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*	175 (150 — 190) *570 (500 — 620)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 699 - 707

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 699 - 707

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 699 - 707

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 699 - 707

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)*

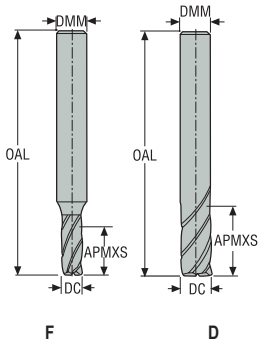
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

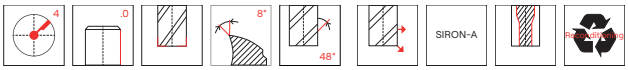
JS554

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





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



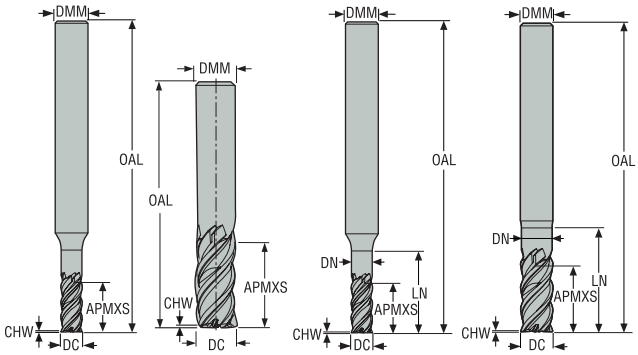
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm			
554030SZ4.0-SIRON-A	02733453	2	F	3,0	6,0	7,0	50,0	4	Cylindrical	■
554040SZ4.0-SIRON-A	02733458	2	F	4,0	6,0	10,0	55,0	4	Cylindrical	■
554050SZ4.0-SIRON-A	02733812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

■ **Prodotto standard.**

JS554

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





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



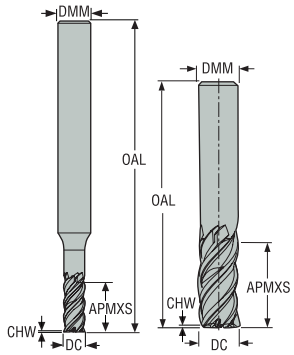
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS554030F1C.0Z4-SIRA	10194615	1	F	3,0	6,0	4,0	40,0	–	–	0,035	4	Cylindrical	■
JS554040F1C.0Z4-SIRA	10041454	1	F	4,0	6,0	6,0	40,0	–	–	0,045	4	Cylindrical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

■ **Prodotto standard.**

JS554

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





F D

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



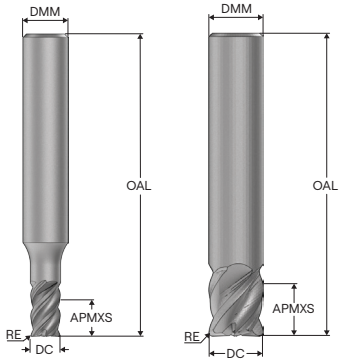
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
554L030Z4.0-SIRON-A	02733818	3	F	3,0	6,0	12,0	55,0	0,035	4	Cylindrical	■
554L040Z4.0-SIRON-A	02733823	3	F	4,0	6,0	16,0	60,0	0,045	4	Cylindrical	■
554L050Z4.0-SIRON-A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

■ **Prodotto standard.**

JS554

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





F D



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

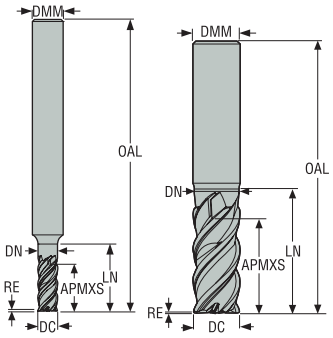
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS554030F1R020.0Z4-SIRA	10194617	1	F	3,0	6,0	4,0	40,0	0,2	4	Cylindrical	■
JS554040F1R020.0Z4-SIRA	10194618	1	F	4,0	6,0	6,0	40,0	0,2	4	Cylindrical	■
JS554050F1R020.0Z4-SIRA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

■ **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



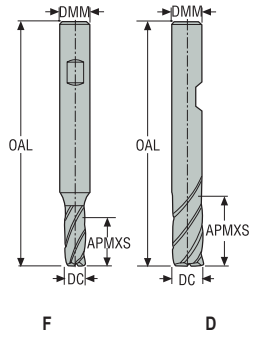
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS554030G2R015.0Z4-SIRA	02881697	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	Cylindrical	■
JS554040G2R020.0Z4-SIRA	02881698	2	G	4,0	6,0	10,0	57,0	13,0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

■ **Prodotto standard.**

JS554

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





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



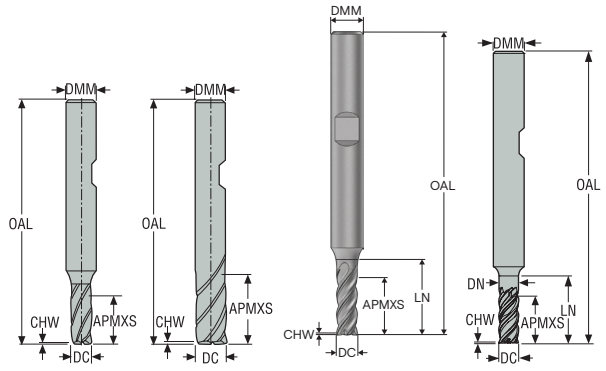
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm			
554030SZ4.0-SIRON-AW	02733844	2	F	3,0	6,0	7,0	50,0	4	Weldon	☐
554040SZ4.0-SIRON-AW	02733846	2	F	4,0	6,0	10,0	55,0	4	Weldon	☐
554050SZ4.0-SIRON-AW	02733847	2	F	5,0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

☐ 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

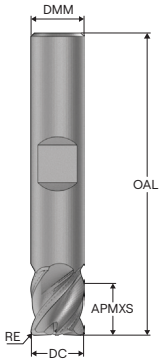
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS554040F1C.3Z4-SIRA	10041460	1	F	4,0	6,0	6,0	40,0	–	–	0,045	4	Weldon	■
JS554060D1C.3Z4-SIRA	10041461	1	D	6,0	6,0	8,0	40,0	–	–	0,075	4	Weldon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

■ **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

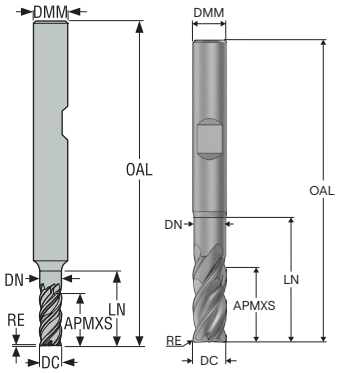
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS554080D1R050.3Z4-SIRA	10194629	1	D	8,0	8,0	11,0	50,0	0,5	4	Weldon	□
JS554100D1R050.3Z4-SIRA	10194630	1	D	10,0	10,0	13,0	57,0	0,5	4	Weldon	□
JS554100D1R100.3Z4-SIRA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

■ **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

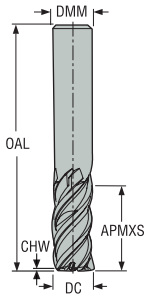
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS554030G2R015.3Z4-SIRA	02881706	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	Weldon	□
JS554040G2R020.3Z4-SIRA	02881946	2	G	4,0	6,0	10,0	57,0	13,0	3,8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

■ **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



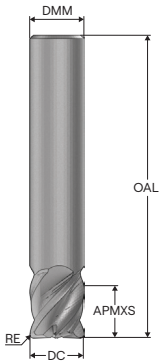
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
				inch	inch	inch	inch	inch			
5540250Z4.0-SIRON-A	02711329	2	D	0.250	0.250	0.500	2.500	0.003	4	Cylindrical	■
5540312Z4.0-SIRON-A	02711340	2	D	0.313	0.313	0.625	2.500	0.004	4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

■ **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



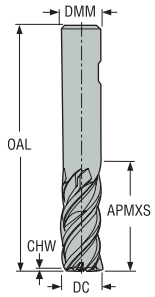
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				inch	inch	inch	inch	inch			
5540250R015Z4.0-SIRON-A	02711335	2	D	0.250	0.250	0.500	2.500	0.015	4	Cylindrical	■
5540312R015Z4.0-SIRON-A	02711341	2	D	0.313	0.313	0.625	2.500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

■ **Prodotto standard.**

JS554

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





D

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



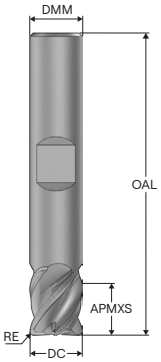
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
				inch	inch	inch	inch	inch			
5540500Z4.3-SIRON-A	02711608	2	D	0.500	0.500	1.000	3.500	0.006	4	Weldon	■
5540750Z4.3-SIRON-A	02711632	2	D	0.750	0.750	1.500	4.000	0.010	4	Weldon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

■ **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	Attacco	Prodotto standard
				inch	inch	inch	inch	inch			
5540500R015Z4.3-SIRON-A	02711613	2	D	0.500	0.500	1.000	3.500	0.015	4	Weldon	■
5540500R030Z4.3-SIRON-A	02711615	2	D	0.500	0.500	1.000	3.500	0.030	4	Weldon	■
5540500R125Z4.3-SIRON-A	02856456	2	D	0.500	0.500	1.000	3.500	0.125	4	Weldon	□
5540625R125Z4.3-SIRON-A	02856457	2	D	0.625	0.625	1.250	3.750	0.125	4	Weldon	□
5541000R060Z4.3-SIRON-A	02711663	2	D	1.000	1.000	2.000	5.000	0.060	4	Weldon	■

■ **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 699 - 707

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 699 - 707

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 *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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	195 (170 — 220) *640 (560 — 720)*
P2	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	165 (140 — 180) *540 (460 — 590)*
P4	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P8	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P11	M/A/D/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*	130 (120 — 140) *425 (400 — 450)*
P12	M/A/D/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 — 87) *260 (230 — 280)*
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 — 100) *310 (280 — 320)*
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 — 87) *260 (230 — 280)*
M3	E	0.60 *0,60*	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*	48 (39 — 57) *155 (130 — 180)*
M4	E	0.60 *0,60*	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*	36 (29 — 43) *120 (96 — 140)*
M5	E	0.60 *0,60*	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 — 36) *100 (83 — 110)*
K1	E	1.0 *1,0*	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*	155 (140 — 170) *510 (460 — 550)*
K2	E	1.0 *1,0*	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*	135 (120 — 150) *445 (400 — 490)*
K3	E	1.0 *1,0*	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*	115 (110 — 120) *375 (370 — 390)*
K4	E	1.0 *1,0*	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*	110 (96 — 120) *360 (320 — 390)*
K5	E	0.70 *0,70*	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*	135 (120 — 150) *445 (400 — 490)*
K6	E	0.70 *0,70*	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*	200 (180 — 220) *660 (600 — 720)*
K7	E	0.70 *0,70*	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*	175 (150 — 190) *570 (500 — 620)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 699 - 707

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 699 - 707

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 699 - 707

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 699 - 707

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)*

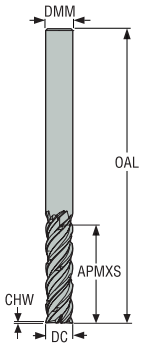
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

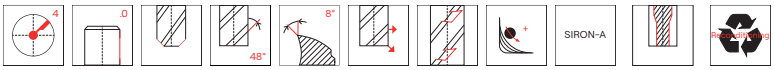
Sgrossatura avanzata – Universale – Spallamento – 4 Eliche – Cilindrico – Smusso





D

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



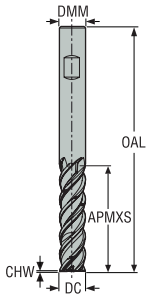
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS554060D3C.0Z4C-SIRA	02810475	3	D	■	6,0	6,0	23,0	65,0	0,075	4	Cylindrical	■
JS554080D3C.0Z4C-SIRA	02810477	3	D	■	8,0	8,0	32,0	75,0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

■ **Prodotto standard.**

JS554-3C

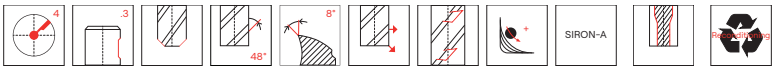
Sgrossatura avanzata – Universale – Spallamento – 4 Eliche – Weldon – Smusso





D

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



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

■ **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 699 - 707

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)*

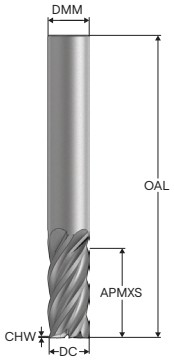
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

ST5551

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





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



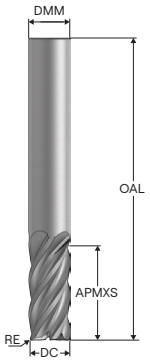
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
ST5551-060D2C.0Z5	SIRA	10303332	2	D	6,0	6,0	14,0	58,0	0,075	5	Cylindrical	■
ST5551-080D2C.0Z5	SIRA	10303333	2	D	8,0	8,0	18,0	64,0	0,1	5	Cylindrical	■
ST5551-100D2C.0Z5	SIRA	10303334	2	D	10,0	10,0	22,0	73,0	0,125	5	Cylindrical	■
ST5551-120D2C.0Z5	SIRA	10303335	2	D	12,0	12,0	26,0	84,0	0,15	5	Cylindrical	■
ST5551-160D2C.0Z5	SIRA	10303336	2	D	16,0	16,0	34,0	95,0	0,2	5	Cylindrical	■
ST5551-200D2C.0Z5	SIRA	10303337	2	D	20,0	20,0	42,0	109,0	0,25	5	Cylindrical	■
ST5551-250D2C.0Z5	SIRA	10303338	2	D	25,0	25,0	52,0	125,0	0,3	5	Cylindrical	■
ST5551-060D3C.0Z5	SIRA	10303339	3	D	6,0	6,0	23,0	64,0	0,075	5	Cylindrical	■
ST5551-080D3C.0Z5	SIRA	10303340	3	D	8,0	8,0	32,0	73,0	0,1	5	Cylindrical	■
ST5551-100D3C.0Z5	SIRA	10303341	3	D	10,0	10,0	40,0	85,0	0,125	5	Cylindrical	■
ST5551-120D3C.0Z5	SIRA	10303342	3	D	12,0	12,0	45,0	100,0	0,15	5	Cylindrical	■
ST5551-160D3C.0Z5	SIRA	10303343	3	D	16,0	16,0	55,0	115,0	0,2	5	Cylindrical	■
ST5551-200D3C.0Z5	SIRA	10303344	3	D	20,0	20,0	65,0	125,0	0,25	5	Cylindrical	■
ST5551-250D3C.0Z5	SIRA	10303345	3	D	25,0	25,0	85,0	155,0	0,3	5	Cylindrical	■

■ **Prodotto standard.**

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Cilindrico – Raggio di punta





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



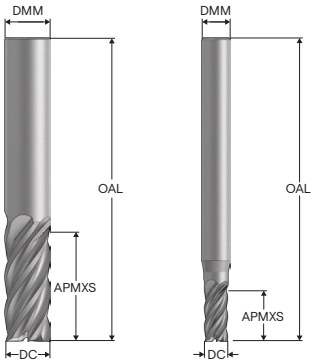
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
ST5551-060D2R050.0Z5	SIRA	10303346	2	D	6,0	6,0	14,0	58,0	0,5	5	Cylindrical	■
ST5551-080D2R050.0Z5	SIRA	10303347	2	D	8,0	8,0	18,0	64,0	0,5	5	Cylindrical	■
ST5551-100D2R050.0Z5	SIRA	10303348	2	D	10,0	10,0	22,0	73,0	0,5	5	Cylindrical	■
ST5551-120D2R050.0Z5	SIRA	10303349	2	D	12,0	12,0	26,0	84,0	0,5	5	Cylindrical	■
ST5551-120D2R100.0Z5	SIRA	10303350	2	D	12,0	12,0	26,0	84,0	1,0	5	Cylindrical	■
ST5551-160D2R050.0Z5	SIRA	10303351	2	D	16,0	16,0	34,0	95,0	0,5	5	Cylindrical	■
ST5551-160D2R100.0Z5	SIRA	10303352	2	D	16,0	16,0	34,0	95,0	1,0	5	Cylindrical	■
ST5551-200D2R050.0Z5	SIRA	10303353	2	D	20,0	20,0	42,0	109,0	0,5	5	Cylindrical	■
ST5551-200D2R100.0Z5	SIRA	10303354	2	D	20,0	20,0	42,0	109,0	1,0	5	Cylindrical	■
ST5551-250D2R050.0Z5	SIRA	10303355	2	D	25,0	25,0	52,0	125,0	0,5	5	Cylindrical	■
ST5551-250D2R100.0Z5	SIRA	10303356	2	D	25,0	25,0	52,0	125,0	1,0	5	Cylindrical	■
ST5551-060D3R050.0Z5	SIRA	10303357	3	D	6,0	6,0	23,0	64,0	0,5	5	Cylindrical	■
ST5551-080D3R050.0Z5	SIRA	10303358	3	D	8,0	8,0	32,0	73,0	0,5	5	Cylindrical	■
ST5551-100D3R050.0Z5	SIRA	10303359	3	D	10,0	10,0	40,0	85,0	0,5	5	Cylindrical	■
ST5551-120D3R050.0Z5	SIRA	10303360	3	D	12,0	12,0	45,0	100,0	0,5	5	Cylindrical	■
ST5551-120D3R100.0Z5	SIRA	10303361	3	D	12,0	12,0	45,0	100,0	1,0	5	Cylindrical	■
ST5551-160D3R050.0Z5	SIRA	10303362	3	D	16,0	16,0	55,0	115,0	0,5	5	Cylindrical	■
ST5551-160D3R100.0Z5	SIRA	10303363	3	D	16,0	16,0	55,0	115,0	1,0	5	Cylindrical	■
ST5551-200D3R050.0Z5	SIRA	10303364	3	D	20,0	20,0	65,0	125,0	0,5	5	Cylindrical	■
ST5551-200D3R100.0Z5	SIRA	10303365	3	D	20,0	20,0	65,0	125,0	1,0	5	Cylindrical	■
ST5551-250D3R050.0Z5	SIRA	10303366	3	D	25,0	25,0	85,0	155,0	0,5	5	Cylindrical	■
ST5551-250D3R100.0Z5	SIRA	10303367	3	D	25,0	25,0	85,0	155,0	1,0	5	Cylindrical	■

■ **Prodotto standard.**

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Cilindrico – Spigolo vivo – Pollici





– Tolleranze:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– Riaffilatura possibile se DC è ≥Ø.250



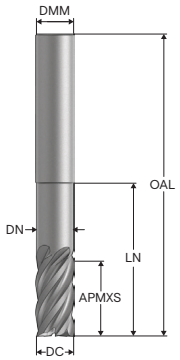
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
ST5551-.250D1S.0Z5	SIRA	10303040	1	D	0.250	0.250	0.375	2.000	5	Cylindrical	■
ST5551-.375D1S.0Z5	SIRA	10303041	1	D	0.375	0.375	0.500	2.500	5	Cylindrical	■
ST5551-.500D1S.0Z5	SIRA	10303042	1	D	0.500	0.500	0.625	3.000	5	Cylindrical	■
ST5551-.625D1S.0Z5	SIRA	10303043	1	D	0.625	0.625	0.750	3.000	5	Cylindrical	■
ST5551-.750D1S.0Z5	SIRA	10303044	1	D	0.750	0.750	0.875	3.000	5	Cylindrical	■
ST5551-.125D2S.0Z5	SIRA	10303045	2	D	0.125	0.125	0.250	1.500	5	Cylindrical	■
ST5551-.156F2S.0Z5	SIRA	10303046	2	F	0.156	0.188	0.313	2.000	5	Cylindrical	■
ST5551-.188D2S.0Z5	SIRA	10303047	2	D	0.188	0.188	0.313	2.000	5	Cylindrical	■
ST5551-.219F2S.0Z5	SIRA	10303048	2	F	0.219	0.250	0.375	2.000	5	Cylindrical	■
ST5551-.313D2S.0Z5	SIRA	10303049	2	D	0.313	0.313	0.750	2.500	5	Cylindrical	■
ST5551-.375D2S.0Z5	SIRA	10303050	2	D	0.375	0.375	0.875	2.500	5	Cylindrical	■
ST5551-.500D2S.0Z5	SIRA	10303051	2	D	0.500	0.500	1.000	3.000	5	Cylindrical	■
ST5551-.625D2S.0Z5	SIRA	10303052	2	D	0.625	0.625	1.250	3.500	5	Cylindrical	■
ST5551-.750D2S.0Z5	SIRA	10303053	2	D	0.750	0.750	1.500	4.000	5	Cylindrical	■
ST5551-.188D3S.0Z5	SIRA	10303054	3	D	0.188	0.188	0.563	2.000	5	Cylindrical	■
ST5551-.219F3S.0Z5	SIRA	10303055	3	F	0.219	0.250	0.750	2.500	5	Cylindrical	■
ST5551-.250D3S.0Z5	SIRA	10303056	3	D	0.250	0.250	0.750	2.500	5	Cylindrical	■
ST5551-.500D3S.0Z5	SIRA	10303057	3	D	0.500	0.500	1.250	3.000	5	Cylindrical	■
ST5551-.125D4S.0Z5	SIRA	10303059	4	D	0.125	0.125	0.500	1.500	5	Cylindrical	■
ST5551-.156F4S.0Z5	SIRA	10303060	4	F	0.156	0.188	0.563	2.000	5	Cylindrical	■
ST5551-.625D4S.0Z5	SIRA	10303065	4	D	0.625	0.625	1.625	3.500	5	Cylindrical	■
ST5551-.625D5S.0Z5	SIRA	10303070	5	D	0.625	0.625	2.125	4.000	5	Cylindrical	■

■ **Prodotto standard.**

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Cilindrico – Spigolo vivo – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Riaffilatura possibile



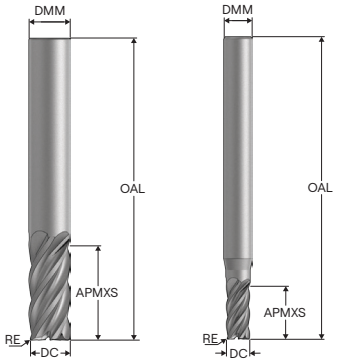
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch	inch			
ST5551-.750E3S.0Z5	SIRA	10303058	3	E	0.750	0.750	1.125	5.000	2.500	0.720	5	Cylindrical	■
ST5551-.250E4S.0Z5	SIRA	10303061	4	E	0.250	0.250	0.500	3.000	1.000	0.240	5	Cylindrical	■
ST5551-.375E4S.0Z5	SIRA	10303062	4	E	0.375	0.375	0.750	3.000	1.500	0.360	5	Cylindrical	■
ST5551-.500E4S.0Z5	SIRA	10303063	4	E	0.500	0.500	1.000	4.000	2.000	0.480	5	Cylindrical	■
ST5551-.625E4S.0Z5	SIRA	10303064	4	E	0.625	0.625	1.250	5.000	2.500	0.600	5	Cylindrical	■
ST5551-.750E4S.0Z5	SIRA	10303066	4	E	0.750	0.750	1.500	5.000	3.000	0.720	5	Cylindrical	■
ST5551-.250E5S.0Z5	SIRA	10303067	5	E	0.250	0.250	0.500	4.000	1.250	0.240	5	Cylindrical	■
ST5551-.375E5S.0Z5	SIRA	10303068	5	E	0.375	0.375	0.500	4.000	2.125	0.360	5	Cylindrical	■
ST5551-.625E5S.0Z5	SIRA	10303069	5	E	0.625	0.625	0.750	6.000	3.375	0.600	5	Cylindrical	■
ST5551-.750E5S.0Z5	SIRA	10303071	5	E	0.750	0.750	1.125	6.000	4.125	0.720	5	Cylindrical	■
ST5551-.500E6S.0Z5	SIRA	10303072	6	E	0.500	0.500	0.625	5.000	3.125	0.480	5	Cylindrical	■
ST5551-.250E8S.0Z5	SIRA	10303073	8	E	0.250	0.250	0.500	4.000	2.125	0.240	5	Cylindrical	■
ST5551-.375E8S.0Z5	SIRA	10303074	8	E	0.375	0.375	0.500	6.000	3.125	0.360	5	Cylindrical	■
ST5551-.500E8S.0Z5	SIRA	10303075	8	E	0.500	0.500	0.625	6.000	4.125	0.480	5	Cylindrical	■

■ **Prodotto standard.**

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Cilindrico – Raggio di punta – Pollici





– Tolleranze:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– RE= ±.0008"
– Riaffilatura possibile se DC è ≥Ø.250



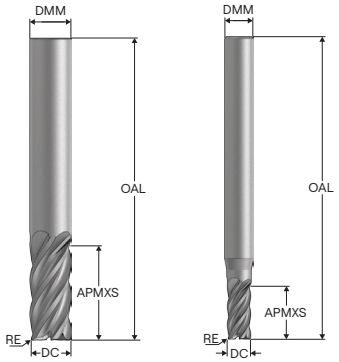
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
ST5551-.250D1R015.0Z5	SIRA	10303076	1	D	0.250	0.250	0.375	2.000	0.015	5	Cylindrical	■
ST5551-.250D1R030.0Z5	SIRA	10303077	1	D	0.250	0.250	0.375	2.000	0.030	5	Cylindrical	■
ST5551-.250D1R045.0Z5	SIRA	10303078	1	D	0.250	0.250	0.375	2.000	0.045	5	Cylindrical	■
ST5551-.375D1R015.0Z5	SIRA	10303079	1	D	0.375	0.375	0.500	2.500	0.015	5	Cylindrical	■
ST5551-.375D1R030.0Z5	SIRA	10303080	1	D	0.375	0.375	0.500	2.500	0.030	5	Cylindrical	■
ST5551-.375D1R045.0Z5	SIRA	10303081	1	D	0.375	0.375	0.500	2.500	0.045	5	Cylindrical	■
ST5551-.500D1R015.0Z5	SIRA	10303082	1	D	0.500	0.500	0.625	3.000	0.015	5	Cylindrical	■
ST5551-.500D1R030.0Z5	SIRA	10303083	1	D	0.500	0.500	0.625	3.000	0.030	5	Cylindrical	■
ST5551-.500D1R045.0Z5	SIRA	10303084	1	D	0.500	0.500	0.625	3.000	0.045	5	Cylindrical	■
ST5551-.500D1R060.0Z5	SIRA	10303085	1	D	0.500	0.500	0.625	3.000	0.060	5	Cylindrical	■
ST5551-.500D1R120.0Z5	SIRA	10303086	1	D	0.500	0.500	0.625	3.000	0.120	5	Cylindrical	■
ST5551-.625D1R015.0Z5	SIRA	10303087	1	D	0.625	0.625	0.750	3.000	0.015	5	Cylindrical	■
ST5551-.625D1R030.0Z5	SIRA	10303088	1	D	0.625	0.625	0.750	3.000	0.030	5	Cylindrical	■
ST5551-.625D1R060.0Z5	SIRA	10303089	1	D	0.625	0.625	0.750	3.000	0.060	5	Cylindrical	■
ST5551-.625D1R120.0Z5	SIRA	10303090	1	D	0.625	0.625	0.750	3.000	0.120	5	Cylindrical	■
ST5551-.750D1R030.0Z5	SIRA	10303091	1	D	0.750	0.750	0.875	3.000	0.030	5	Cylindrical	■
ST5551-.750D1R060.0Z5	SIRA	10303092	1	D	0.750	0.750	0.875	3.000	0.060	5	Cylindrical	■
ST5551-.750D1R120.0Z5	SIRA	10303093	1	D	0.750	0.750	0.875	3.000	0.120	5	Cylindrical	■
ST5551-.125D2R010.0Z5	SIRA	10303094	2	D	0.125	0.125	0.250	1.500	0.010	5	Cylindrical	■
ST5551-.156F2R010.0Z5	SIRA	10303095	2	F	0.156	0.188	0.313	2.000	0.010	5	Cylindrical	■
ST5551-.188D2R010.0Z5	SIRA	10303096	2	D	0.188	0.188	0.313	2.000	0.010	5	Cylindrical	■
ST5551-.219F2R010.0Z5	SIRA	10303097	2	F	0.219	0.250	0.375	2.000	0.010	5	Cylindrical	■
ST5551-.313D2R015.0Z5	SIRA	10303098	2	D	0.313	0.313	0.750	2.500	0.015	5	Cylindrical	■
ST5551-.375D2R015.0Z5	SIRA	10303099	2	D	0.375	0.375	0.875	2.500	0.015	5	Cylindrical	■
ST5551-.375D2R030.0Z5	SIRA	10303100	2	D	0.375	0.375	0.875	2.500	0.030	5	Cylindrical	■
ST5551-.375D2R045.0Z5	SIRA	10303101	2	D	0.375	0.375	0.875	2.500	0.045	5	Cylindrical	■
ST5551-.375D2R060.0Z5	SIRA	10303102	2	D	0.375	0.375	0.875	2.500	0.060	5	Cylindrical	■
ST5551-.500D2R015.0Z5	SIRA	10303103	2	D	0.500	0.500	1.000	3.000	0.015	5	Cylindrical	■
ST5551-.500D2R030.0Z5	SIRA	10303104	2	D	0.500	0.500	1.000	3.000	0.030	5	Cylindrical	■
ST5551-.500D2R060.0Z5	SIRA	10303105	2	D	0.500	0.500	1.000	3.000	0.060	5	Cylindrical	■
ST5551-.625D2R015.0Z5	SIRA	10303106	2	D	0.625	0.625	1.250	3.500	0.015	5	Cylindrical	■
ST5551-.625D2R030.0Z5	SIRA	10303107	2	D	0.625	0.625	1.250	3.500	0.030	5	Cylindrical	■
ST5551-.625D2R045.0Z5	SIRA	10303108	2	D	0.625	0.625	1.250	3.500	0.045	5	Cylindrical	■
ST5551-.625D2R060.0Z5	SIRA	10303109	2	D	0.625	0.625	1.250	3.500	0.060	5	Cylindrical	■
ST5551-.625D2R090.0Z5	SIRA	10303110	2	D	0.625	0.625	1.250	3.500	0.090	5	Cylindrical	■
ST5551-.625D2R125.0Z5	SIRA	10303111	2	D	0.625	0.625	1.250	3.500	0.125	5	Cylindrical	■

■ **Prodotto standard.**

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Cilindrico – Raggio di punta – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Riaffilatura possibile se DC è ≥Ø.250



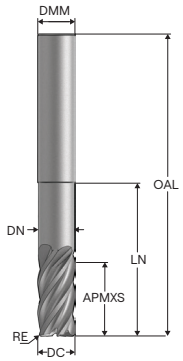
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
ST5551-.750D2R030.0Z5	SIRA	10303112	2	D	0.750	0.750	1.500	4.000	0.030	5	Cylindrical	■
ST5551-.750D2R060.0Z5	SIRA	10303113	2	D	0.750	0.750	1.500	4.000	0.060	5	Cylindrical	■
ST5551-.750D2R090.0Z5	SIRA	10303114	2	D	0.750	0.750	1.500	4.000	0.090	5	Cylindrical	■
ST5551-.750D2R125.0Z5	SIRA	10303115	2	D	0.750	0.750	1.500	4.000	0.125	5	Cylindrical	■
ST5551-1.00D2R015.0Z5	SIRA	10303116	2	D	1.000	1.000	1.750	4.000	0.015	5	Cylindrical	■
ST5551-1.00D2R030.0Z5	SIRA	10303117	2	D	1.000	1.000	1.750	4.000	0.030	5	Cylindrical	■
ST5551-1.00D2R060.0Z5	SIRA	10303118	2	D	1.000	1.000	1.750	4.000	0.060	5	Cylindrical	■
ST5551-.188D3R010.0Z5	SIRA	10303119	3	D	0.188	0.188	0.563	2.000	0.010	5	Cylindrical	■
ST5551-.219F3R010.0Z5	SIRA	10303120	3	F	0.219	0.250	0.750	2.500	0.010	5	Cylindrical	■
ST5551-.250D3R015.0Z5	SIRA	10303121	3	D	0.250	0.250	0.750	2.500	0.015	5	Cylindrical	■
ST5551-.250D3R030.0Z5	SIRA	10303122	3	D	0.250	0.250	0.750	2.500	0.030	5	Cylindrical	■
ST5551-.250D3R045.0Z5	SIRA	10303123	3	D	0.250	0.250	0.750	2.500	0.045	5	Cylindrical	■
ST5551-.375D3R030.0Z5	SIRA	10303124	3	D	0.375	0.375	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.500D3R015.0Z5	SIRA	10303125	3	D	0.500	0.500	1.250	3.000	0.015	5	Cylindrical	■
ST5551-.500D3R030.0Z5	SIRA	10303126	3	D	0.500	0.500	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.500D3R045.0Z5	SIRA	10303127	3	D	0.500	0.500	1.250	3.000	0.045	5	Cylindrical	■
ST5551-.500D3R060.0Z5	SIRA	10303128	3	D	0.500	0.500	1.250	3.000	0.060	5	Cylindrical	■
ST5551-.500D3R090.0Z5	SIRA	10303129	3	D	0.500	0.500	1.250	3.000	0.090	5	Cylindrical	■
ST5551-.500D3R125.0Z5	SIRA	10303130	3	D	0.500	0.500	1.250	3.000	0.125	5	Cylindrical	■
ST5551-.750D3R030.0Z5	SIRA	10303134	3	D	0.750	0.750	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.125D4R010.0Z5	SIRA	10303138	4	D	0.125	0.125	0.500	1.500	0.010	5	Cylindrical	■
ST5551-.156F4R010.0Z5	SIRA	10303139	4	F	0.156	0.188	0.563	2.000	0.010	5	Cylindrical	■
ST5551-.250D4R015.0Z5	SIRA	10303142	4	D	0.250	0.250	1.000	3.000	0.015	5	Cylindrical	■
ST5551-.375D4R030.0Z5	SIRA	10303147	4	D	0.375	0.375	1.500	4.000	0.030	5	Cylindrical	■
ST5551-.500D4R030.0Z5	SIRA	10303152	4	D	0.500	0.500	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.750D4R030.0Z5	SIRA	10303158	4	D	0.750	0.750	2.250	5.000	0.030	5	Cylindrical	■
ST5551-.500D5R030.0Z5	SIRA	10303165	5	D	0.500	0.500	2.000	4.000	0.030	5	Cylindrical	■
ST5551-.750D5R030.0Z5	SIRA	10303171	5	D	0.750	0.750	2.750	5.000	0.030	5	Cylindrical	■

■ **Prodotto standard.**

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Cilindrico – Raggio di punta – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Riaffilatura possibile



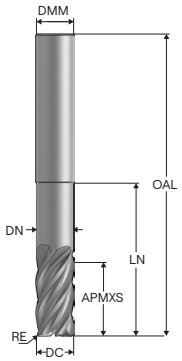
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch	inch	inch			
ST5551-.250E4R015.0Z5	SIRA	10303140	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.015	5	Cylindrical	■
ST5551-.250E4R030.0Z5	SIRA	10303141	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.030	5	Cylindrical	■
ST5551-.375E4R015.0Z5	SIRA	10303143	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.015	5	Cylindrical	■
ST5551-.375E4R030.0Z5	SIRA	10303144	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.030	5	Cylindrical	■
ST5551-.375E4R045.0Z5	SIRA	10303145	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.045	5	Cylindrical	■
ST5551-.375E4R060.0Z5	SIRA	10303146	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.060	5	Cylindrical	■
ST5551-.500E4R015.0Z5	SIRA	10303148	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.015	5	Cylindrical	■
ST5551-.500E4R030.0Z5	SIRA	10303149	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.030	5	Cylindrical	■
ST5551-.500E4R060.0Z5	SIRA	10303150	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.060	5	Cylindrical	■
ST5551-.500E4R120.0Z5	SIRA	10303151	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.120	5	Cylindrical	■
ST5551-.625E4R030.0Z5	SIRA	10303153	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.030	5	Cylindrical	■
ST5551-.625E4R060.0Z5	SIRA	10303154	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.060	5	Cylindrical	■
ST5551-.250E5R015.0Z5	SIRA	10303159	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.015	5	Cylindrical	■
ST5551-.250E5R030.0Z5	SIRA	10303160	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.030	5	Cylindrical	■
ST5551-.375E5R015.0Z5	SIRA	10303161	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.015	5	Cylindrical	■
ST5551-.375E5R030.0Z5	SIRA	10303162	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.030	5	Cylindrical	■
ST5551-.375E5R045.0Z5	SIRA	10303163	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.045	5	Cylindrical	■
ST5551-.375E5R060.0Z5	SIRA	10303164	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.060	5	Cylindrical	■
ST5551-.625E5R030.0Z5	SIRA	10303166	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.030	5	Cylindrical	■
ST5551-.625E5R060.0Z5	SIRA	10303167	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.060	5	Cylindrical	■
ST5551-.500E6R015.0Z5	SIRA	10303172	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.015	5	Cylindrical	■
ST5551-.500E6R030.0Z5	SIRA	10303173	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.030	5	Cylindrical	■
ST5551-.500E6R060.0Z5	SIRA	10303174	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.060	5	Cylindrical	■
ST5551-.500E6R120.0Z5	SIRA	10303175	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.120	5	Cylindrical	■
ST5551-.250E8R015.0Z5	SIRA	10303176	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.015	5	Cylindrical	■
ST5551-.250E8R030.0Z5	SIRA	10303177	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.030	5	Cylindrical	■
ST5551-.375E8R015.0Z5	SIRA	10303178	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.015	5	Cylindrical	■
ST5551-.375E8R030.0Z5	SIRA	10303179	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.030	5	Cylindrical	■
ST5551-.375E8R045.0Z5	SIRA	10303180	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.045	5	Cylindrical	■
ST5551-.375E8R060.0Z5	SIRA	10303181	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.060	5	Cylindrical	■
ST5551-.500E8R015.0Z5	SIRA	10303182	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.015	5	Cylindrical	■
ST5551-.500E8R030.0Z5	SIRA	10303183	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.030	5	Cylindrical	■
ST5551-.500E8R060.0Z5	SIRA	10303184	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.060	5	Cylindrical	■
ST5551-.500E8R120.0Z5	SIRA	10303185	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.120	5	Cylindrical	■

■ **Prodotto standard.**

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Cilindrico – Raggio di punta – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Riaffilatura possibile



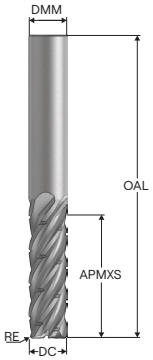
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch	inch	inch			
ST5551-.750E3R030.0Z5	SIRA	10303131	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.030	5	Cylindrical	■
ST5551-.750E3R060.0Z5	SIRA	10303132	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.060	5	Cylindrical	■
ST5551-.750E3R120.0Z5	SIRA	10303133	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.120	5	Cylindrical	■
ST5551-1.00E3R030.0Z5	SIRA	10303135	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.030	5	Cylindrical	■
ST5551-1.00E3R060.0Z5	SIRA	10303136	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.060	5	Cylindrical	■
ST5551-1.00E3R120.0Z5	SIRA	10303137	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.120	5	Cylindrical	■
ST5551-.750E4R030.0Z5	SIRA	10303155	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.030	5	Cylindrical	■
ST5551-.750E4R060.0Z5	SIRA	10303156	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.060	5	Cylindrical	■
ST5551-.750E4R120.0Z5	SIRA	10303157	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.120	5	Cylindrical	■
ST5551-.750E5R030.0Z5	SIRA	10303168	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.030	5	Cylindrical	■
ST5551-.750E5R060.0Z5	SIRA	10303169	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.060	5	Cylindrical	■
ST5551-.750E5R120.0Z5	SIRA	10303170	5	E	0.750	0.750	1.132	6.000	4.125	0.720	0.120	5	Cylindrical	■

■ **Prodotto standard.**

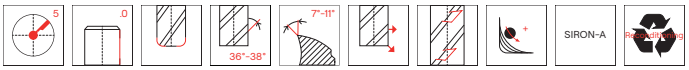
ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Cilindrico – Raggio di punta – Pollici





—Tolleranze:
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—DC= + .000" / - .002"
—RE= ±.0008"
—Riaffilatura possibile



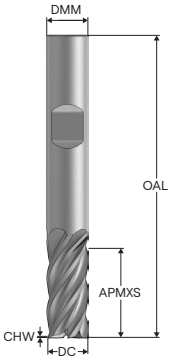
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
						inch	inch	inch	inch	inch			
ST5551-.250D3R015.0Z5C	SIRA	10303186	3	D	■	0.250	0.250	0.750	2.500	0.015	5	Cylindrical	■
ST5551-.375D3R030.0Z5C	SIRA	10303187	3	D	■	0.375	0.375	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.500D3R030.0Z5C	SIRA	10303188	3	D	■	0.500	0.500	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.625D3R030.0Z5C	SIRA	10303189	3	D	■	0.625	0.625	1.375	3.500	0.030	5	Cylindrical	■
ST5551-.750D3R030.0Z5C	SIRA	10303190	3	D	■	0.750	0.750	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.500D4R030.0Z5C	SIRA	10303191	4	D	■	0.500	0.500	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.750D4R030.0Z5C	SIRA	10303192	4	D	■	0.750	0.750	2.250	5.000	0.030	5	Cylindrical	■
ST5551-.625D5R030.0Z5C	SIRA	10303193	5	D	■	0.625	0.625	2.125	4.000	0.030	5	Cylindrical	■

■ **Prodotto standard.**

ST5551

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





—Tolleranze:
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—DC=e7
—Riaffilatura possibile



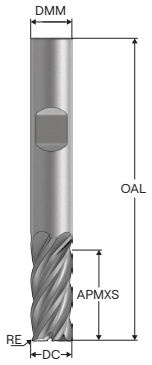
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
ST5551-060D2C.3Z5	SIRA	10303368	2	D	6,0	6,0	14,0	58,0	0,075	5	Weldon	☐
ST5551-080D2C.3Z5	SIRA	10303369	2	D	8,0	8,0	18,0	64,0	0,1	5	Weldon	☐
ST5551-100D2C.3Z5	SIRA	10303370	2	D	10,0	10,0	22,0	73,0	0,125	5	Weldon	☐
ST5551-120D2C.3Z5	SIRA	10303371	2	D	12,0	12,0	26,0	84,0	0,15	5	Weldon	☐
ST5551-160D2C.3Z5	SIRA	10303372	2	D	16,0	16,0	34,0	95,0	0,2	5	Weldon	☐
ST5551-200D2C.3Z5	SIRA	10303373	2	D	20,0	20,0	42,0	109,0	0,25	5	Weldon	☐
ST5551-250D2C.3Z5	SIRA	10303374	2	D	25,0	25,0	52,0	125,0	0,3	5	Weldon	☐
ST5551-060D3C.3Z5	SIRA	10303375	3	D	6,0	6,0	23,0	64,0	0,075	5	Weldon	☐
ST5551-080D3C.3Z5	SIRA	10303376	3	D	8,0	8,0	32,0	73,0	0,1	5	Weldon	☐
ST5551-100D3C.3Z5	SIRA	10303377	3	D	10,0	10,0	40,0	85,0	0,125	5	Weldon	☐
ST5551-120D3C.3Z5	SIRA	10303378	3	D	12,0	12,0	45,0	100,0	0,15	5	Weldon	☐
ST5551-160D3C.3Z5	SIRA	10303379	3	D	16,0	16,0	55,0	115,0	0,2	5	Weldon	☐
ST5551-200D3C.3Z5	SIRA	10303380	3	D	20,0	20,0	65,0	125,0	0,25	5	Weldon	☐
ST5551-250D3C.3Z5	SIRA	10303381	3	D	25,0	25,0	85,0	155,0	0,3	5	Weldon	☐

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

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Weldon – Raggio di punta





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



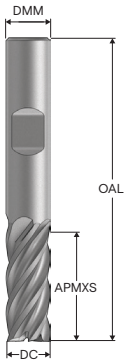
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
ST5551-060D2R050.3Z5	SIRA	10303382	2	D	6,0	6,0	14,0	58,0	0,5	5	Weldon	☐
ST5551-080D2R050.3Z5	SIRA	10303383	2	D	8,0	8,0	18,0	64,0	0,5	5	Weldon	☐
ST5551-100D2R050.3Z5	SIRA	10303384	2	D	10,0	10,0	22,0	73,0	0,5	5	Weldon	☐
ST5551-120D2R050.3Z5	SIRA	10303385	2	D	12,0	12,0	26,0	84,0	0,5	5	Weldon	☐
ST5551-120D2R100.3Z5	SIRA	10303386	2	D	12,0	12,0	26,0	84,0	1,0	5	Weldon	☐
ST5551-160D2R050.3Z5	SIRA	10303387	2	D	16,0	16,0	34,0	95,0	0,5	5	Weldon	☐
ST5551-160D2R100.3Z5	SIRA	10303388	2	D	16,0	16,0	34,0	95,0	1,0	5	Weldon	☐
ST5551-200D2R050.3Z5	SIRA	10303389	2	D	20,0	20,0	42,0	109,0	0,5	5	Weldon	☐
ST5551-200D2R100.3Z5	SIRA	10303390	2	D	20,0	20,0	42,0	109,0	1,0	5	Weldon	☐
ST5551-250D2R050.3Z5	SIRA	10303391	2	D	25,0	25,0	52,0	125,0	0,5	5	Weldon	☐
ST5551-250D2R100.3Z5	SIRA	10303392	2	D	25,0	25,0	52,0	125,0	1,0	5	Weldon	☐
ST5551-060D3R050.3Z5	SIRA	10303393	3	D	6,0	6,0	23,0	64,0	0,5	5	Weldon	☐
ST5551-080D3R050.3Z5	SIRA	10303394	3	D	8,0	8,0	32,0	73,0	0,5	5	Weldon	☐
ST5551-100D3R050.3Z5	SIRA	10303395	3	D	10,0	10,0	40,0	85,0	0,5	5	Weldon	☐
ST5551-120D3R050.3Z5	SIRA	10303396	3	D	12,0	12,0	45,0	100,0	0,5	5	Weldon	☐
ST5551-120D3R100.3Z5	SIRA	10303397	3	D	12,0	12,0	45,0	100,0	1,0	5	Weldon	☐
ST5551-160D3R050.3Z5	SIRA	10303398	3	D	16,0	16,0	55,0	115,0	0,5	5	Weldon	☐
ST5551-160D3R100.3Z5	SIRA	10303399	3	D	16,0	16,0	55,0	115,0	1,0	5	Weldon	☐
ST5551-200D3R050.3Z5	SIRA	10303400	3	D	20,0	20,0	65,0	125,0	0,5	5	Weldon	☐
ST5551-200D3R100.3Z5	SIRA	10303401	3	D	20,0	20,0	65,0	125,0	1,0	5	Weldon	☐
ST5551-250D3R050.3Z5	SIRA	10303402	3	D	25,0	25,0	85,0	155,0	0,5	5	Weldon	☐
ST5551-250D3R100.3Z5	SIRA	10303403	3	D	25,0	25,0	85,0	155,0	1,0	5	Weldon	☐

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

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Weldon – Spigolo vivo – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Riaffilatura possibile



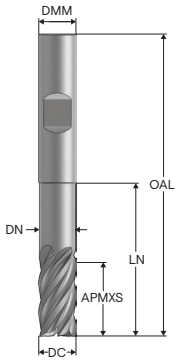
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
ST5551-.250D1S.3Z5	SIRA	10303194	1	D	0.250	0.250	0.375	2.000	5	Weldon	☐
ST5551-.375D1S.3Z5	SIRA	10303195	1	D	0.375	0.375	0.500	2.500	5	Weldon	☐
ST5551-.500D1S.3Z5	SIRA	10303196	1	D	0.500	0.500	0.625	3.000	5	Weldon	☐
ST5551-.625D1S.3Z5	SIRA	10303197	1	D	0.625	0.625	0.750	3.000	5	Weldon	☐
ST5551-.750D1S.3Z5	SIRA	10303198	1	D	0.750	0.750	0.875	3.000	5	Weldon	☐
ST5551-.313D2S.3Z5	SIRA	10303199	2	D	0.313	0.313	0.750	2.500	5	Weldon	☐
ST5551-.375D2S.3Z5	SIRA	10303200	2	D	0.375	0.375	0.875	2.500	5	Weldon	☐
ST5551-.500D2S.3Z5	SIRA	10303201	2	D	0.500	0.500	1.000	3.000	5	Weldon	☐
ST5551-.625D2S.3Z5	SIRA	10303202	2	D	0.625	0.625	1.250	3.500	5	Weldon	☐
ST5551-.750D2S.3Z5	SIRA	10303203	2	D	0.750	0.750	1.500	4.000	5	Weldon	☐
ST5551-.250D3S.3Z5	SIRA	10303204	3	D	0.250	0.250	0.750	2.500	5	Weldon	☐
ST5551-.500D3S.3Z5	SIRA	10303205	3	D	0.500	0.500	1.250	3.000	5	Weldon	☐
ST5551-.625D4S.3Z5	SIRA	10303211	4	D	0.625	0.625	1.625	3.500	5	Weldon	☐
ST5551-.625D5S.3Z5	SIRA	10303216	5	D	0.625	0.625	2.125	4.000	5	Weldon	☐

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

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Weldon – Spigolo vivo – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Riaffilatura possibile



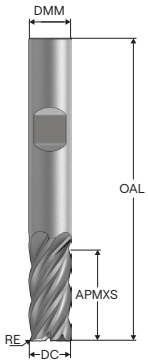
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch	inch			
ST5551-.750E3S.3Z5	SIRA	10303206	3	E	0.750	0.750	1.125	5.000	2.500	0.720	5	Weldon	☐
ST5551-.250E4S.3Z5	SIRA	10303207	4	E	0.250	0.250	0.500	3.000	1.000	0.240	5	Weldon	☐
ST5551-.375E4S.3Z5	SIRA	10303208	4	E	0.375	0.375	0.750	3.000	1.500	0.360	5	Weldon	☐
ST5551-.500E4S.3Z5	SIRA	10303209	4	E	0.500	0.500	1.000	4.000	2.000	0.480	5	Weldon	☐
ST5551-.625E4S.3Z5	SIRA	10303210	4	E	0.625	0.625	1.250	5.000	2.500	0.600	5	Weldon	☐
ST5551-.750E4S.3Z5	SIRA	10303212	4	E	0.750	0.750	1.500	5.000	3.000	0.720	5	Weldon	☐
ST5551-.250E5S.3Z5	SIRA	10303213	5	E	0.250	0.250	0.500	4.000	1.250	0.240	5	Weldon	☐
ST5551-.375E5S.3Z5	SIRA	10303214	5	E	0.375	0.375	0.500	4.000	2.125	0.360	5	Weldon	☐
ST5551-.625E5S.3Z5	SIRA	10303215	5	E	0.625	0.625	0.750	6.000	3.375	0.600	5	Weldon	☐
ST5551-.750E5S.3Z5	SIRA	10303217	5	E	0.750	0.750	1.125	6.000	4.125	0.720	5	Weldon	☐
ST5551-.500E6S.3Z5	SIRA	10303218	6	E	0.500	0.500	0.625	5.000	3.125	0.480	5	Weldon	☐
ST5551-.250E8S.3Z5	SIRA	10303219	8	E	0.250	0.250	0.500	4.000	2.125	0.240	5	Weldon	☐
ST5551-.375E8S.3Z5	SIRA	10303220	8	E	0.375	0.375	0.500	6.000	3.125	0.360	5	Weldon	☐
ST5551-.500E8S.3Z5	SIRA	10303221	8	E	0.500	0.500	0.625	6.000	4.109	0.480	5	Weldon	☐

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

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Weldon – Raggio di punta – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Riaffilatura possibile



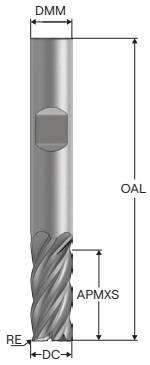
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
ST5551-.250D1R015.3Z5	SIRA	10303222	1	D	0.250	0.250	0.375	2.000	0.015	5	Weldon	☐
ST5551-.250D1R030.3Z5	SIRA	10303223	1	D	0.250	0.250	0.375	2.000	0.030	5	Weldon	☐
ST5551-.250D1R045.3Z5	SIRA	10303224	1	D	0.250	0.250	0.375	2.000	0.045	5	Weldon	☐
ST5551-.375D1R015.3Z5	SIRA	10303225	1	D	0.375	0.375	0.500	2.500	0.015	5	Weldon	☐
ST5551-.375D1R030.3Z5	SIRA	10303226	1	D	0.375	0.375	0.500	2.500	0.030	5	Weldon	☐
ST5551-.375D1R045.3Z5	SIRA	10303227	1	D	0.375	0.375	0.500	2.500	0.045	5	Weldon	☐
ST5551-.500D1R015.3Z5	SIRA	10303228	1	D	0.500	0.500	0.625	3.000	0.015	5	Weldon	☐
ST5551-.500D1R030.3Z5	SIRA	10303231	1	D	0.500	0.500	0.625	3.000	0.030	5	Weldon	☐
ST5551-.500D1R045.3Z5	SIRA	10303229	1	D	0.500	0.500	0.625	3.000	0.045	5	Weldon	☐
ST5551-.500D1R060.3Z5	SIRA	10303232	1	D	0.500	0.500	0.625	3.000	0.060	5	Weldon	☐
ST5551-.500D1R120.3Z5	SIRA	10303230	1	D	0.500	0.500	0.625	3.000	0.120	5	Weldon	☐
ST5551-.625D1R015.3Z5	SIRA	10303233	1	D	0.625	0.625	0.750	3.000	0.015	5	Weldon	☐
ST5551-.625D1R030.3Z5	SIRA	10303235	1	D	0.625	0.625	0.750	3.000	0.030	5	Weldon	☐
ST5551-.625D1R060.3Z5	SIRA	10303236	1	D	0.625	0.625	0.750	3.000	0.060	5	Weldon	☐
ST5551-.625D1R120.3Z5	SIRA	10303234	1	D	0.625	0.625	0.750	3.000	0.120	5	Weldon	☐
ST5551-.750D1R030.3Z5	SIRA	10303237	1	D	0.750	0.750	0.875	3.000	0.030	5	Weldon	☐
ST5551-.750D1R060.3Z5	SIRA	10303238	1	D	0.750	0.750	0.875	3.000	0.060	5	Weldon	☐
ST5551-.750D1R120.3Z5	SIRA	10303239	1	D	0.750	0.750	0.875	3.000	0.120	5	Weldon	☐
ST5551-.313D2R015.3Z5	SIRA	10303240	2	D	0.313	0.313	0.750	2.500	0.015	5	Weldon	☐
ST5551-.375D2R015.3Z5	SIRA	10303241	2	D	0.375	0.375	0.875	2.500	0.015	5	Weldon	☐
ST5551-.375D2R030.3Z5	SIRA	10303242	2	D	0.375	0.375	0.875	2.500	0.030	5	Weldon	☐
ST5551-.375D2R045.3Z5	SIRA	10303243	2	D	0.375	0.375	0.875	2.500	0.045	5	Weldon	☐
ST5551-.375D2R060.3Z5	SIRA	10303244	2	D	0.375	0.375	0.875	2.500	0.060	5	Weldon	☐
ST5551-.500D2R015.3Z5	SIRA	10303245	2	D	0.500	0.500	1.000	3.000	0.015	5	Weldon	☐
ST5551-.500D2R030.3Z5	SIRA	10303246	2	D	0.500	0.500	1.000	3.000	0.030	5	Weldon	☐
ST5551-.500D2R060.3Z5	SIRA	10303247	2	D	0.500	0.500	1.000	3.000	0.060	5	Weldon	☐
ST5551-.625D2R015.3Z5	SIRA	10303248	2	D	0.625	0.625	1.250	3.500	0.015	5	Weldon	☐
ST5551-.625D2R030.3Z5	SIRA	10303249	2	D	0.625	0.625	1.250	3.500	0.030	5	Weldon	☐
ST5551-.625D2R045.3Z5	SIRA	10303250	2	D	0.625	0.625	1.250	3.500	0.045	5	Weldon	☐
ST5551-.625D2R060.3Z5	SIRA	10303251	2	D	0.625	0.625	1.250	3.500	0.060	5	Weldon	☐
ST5551-.625D2R090.3Z5	SIRA	10303252	2	D	0.625	0.625	1.250	3.500	0.090	5	Weldon	☐
ST5551-.625D2R125.3Z5	SIRA	10303253	2	D	0.625	0.625	1.250	3.500	0.125	5	Weldon	☐
ST5551-.750D2R030.3Z5	SIRA	10303254	2	D	0.750	0.750	1.500	4.000	0.030	5	Weldon	☐
ST5551-.750D2R060.3Z5	SIRA	10303255	2	D	0.750	0.750	1.500	4.000	0.060	5	Weldon	☐
ST5551-.750D2R090.3Z5	SIRA	10303256	2	D	0.750	0.750	1.500	4.000	0.090	5	Weldon	☐
ST5551-.750D2R125.3Z5	SIRA	10303257	2	D	0.750	0.750	1.500	4.000	0.125	5	Weldon	☐

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

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Weldon – Raggio di punta – Pollici





– Tolleranze:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– RE= ±.0008"
– Riaffilatura possibile



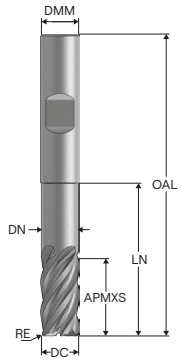
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
ST5551-1.00D2R015.3Z5	SIRA	10303258	2	D	1.000	1.000	1.750	4.000	0.015	5	Weldon	☐
ST5551-1.00D2R030.3Z5	SIRA	10303259	2	D	1.000	1.000	1.750	4.000	0.030	5	Weldon	☐
ST5551-1.00D2R060.3Z5	SIRA	10303260	2	D	1.000	1.000	1.750	4.000	0.060	5	Weldon	☐
ST5551-.250D3R015.3Z5	SIRA	10303261	3	D	0.250	0.250	0.750	2.500	0.015	5	Weldon	☐
ST5551-.250D3R030.3Z5	SIRA	10303262	3	D	0.250	0.250	0.750	2.500	0.030	5	Weldon	☐
ST5551-.250D3R045.3Z5	SIRA	10303263	3	D	0.250	0.250	0.750	2.500	0.045	5	Weldon	☐
ST5551-.375D3R030.3Z5	SIRA	10303264	3	D	0.375	0.375	1.250	3.000	0.030	5	Weldon	☐
ST5551-.500D3R015.3Z5	SIRA	10303265	3	D	0.500	0.500	1.250	3.000	0.015	5	Weldon	☐
ST5551-.500D3R030.3Z5	SIRA	10303266	3	D	0.500	0.500	1.250	3.000	0.030	5	Weldon	☐
ST5551-.500D3R045.3Z5	SIRA	10303267	3	D	0.500	0.500	1.250	3.000	0.045	5	Weldon	☐
ST5551-.500D3R060.3Z5	SIRA	10303268	3	D	0.500	0.500	1.250	3.000	0.060	5	Weldon	☐
ST5551-.500D3R090.3Z5	SIRA	10303269	3	D	0.500	0.500	1.250	3.000	0.090	5	Weldon	☐
ST5551-.500D3R125.3Z5	SIRA	10303270	3	D	0.500	0.500	1.250	3.000	0.125	5	Weldon	☐
ST5551-.750D3R030.3Z5	SIRA	10303274	3	D	0.750	0.750	1.625	4.000	0.030	5	Weldon	☐
ST5551-.250D4R015.3Z5	SIRA	10303280	4	D	0.250	0.250	1.000	3.000	0.015	5	Weldon	☐
ST5551-.375D4R030.3Z5	SIRA	10303285	4	D	0.375	0.375	1.500	4.000	0.030	5	Weldon	☐
ST5551-.500D4R030.3Z5	SIRA	10303290	4	D	0.500	0.500	1.625	4.000	0.030	5	Weldon	☐
ST5551-.750D4R030.3Z5	SIRA	10303296	4	D	0.750	0.750	2.250	5.000	0.030	5	Weldon	☐
ST5551-.500D5R030.3Z5	SIRA	10303303	5	D	0.500	0.500	2.000	4.000	0.030	5	Weldon	☐
ST5551-.750D5R030.3Z5	SIRA	10303309	5	D	0.750	0.750	2.750	5.000	0.030	5	Weldon	☐

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

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Weldon – Raggio di punta – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Riaffilatura possibile



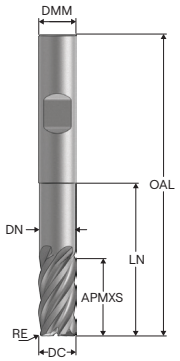
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch	inch	inch			
ST5551-.750E3R030.3Z5	SIRA	10303271	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.030	5	Weldon	□
ST5551-.750E3R060.3Z5	SIRA	10303272	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.060	5	Weldon	□
ST5551-.750E3R120.3Z5	SIRA	10303273	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.120	5	Weldon	□
ST5551-1.00E3R030.3Z5	SIRA	10303275	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.030	5	Weldon	□
ST5551-1.00E3R060.3Z5	SIRA	10303276	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.060	5	Weldon	□
ST5551-1.00E3R120.3Z5	SIRA	10303277	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.120	5	Weldon	□
ST5551-.250E4R015.3Z5	SIRA	10303278	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.015	5	Weldon	□
ST5551-.250E4R030.3Z5	SIRA	10303279	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.030	5	Weldon	□
ST5551-.375E4R015.3Z5	SIRA	10303281	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.015	5	Weldon	□
ST5551-.375E4R030.3Z5	SIRA	10303282	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.030	5	Weldon	□
ST5551-.375E4R045.3Z5	SIRA	10303283	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.045	5	Weldon	□
ST5551-.375E4R060.3Z5	SIRA	10303284	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.060	5	Weldon	□
ST5551-.500E4R015.3Z5	SIRA	10303286	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.015	5	Weldon	□
ST5551-.500E4R030.3Z5	SIRA	10303287	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.030	5	Weldon	□
ST5551-.500E4R060.3Z5	SIRA	10303288	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.060	5	Weldon	□
ST5551-.500E4R120.3Z5	SIRA	10303289	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.120	5	Weldon	□
ST5551-.625E4R030.3Z5	SIRA	10303291	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.030	5	Weldon	□
ST5551-.625E4R060.3Z5	SIRA	10303292	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.060	5	Weldon	□
ST5551-.750E4R030.3Z5	SIRA	10303293	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.030	5	Weldon	□
ST5551-.750E4R060.3Z5	SIRA	10303294	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.060	5	Weldon	□
ST5551-.750E4R120.3Z5	SIRA	10303295	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.120	5	Weldon	□

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

ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Weldon – Raggio di punta – Pollici





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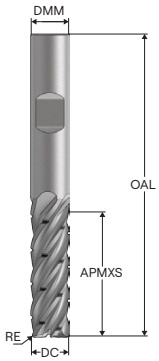
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch	inch	inch			
ST5551-.250E5R015.3Z5	SIRA	10303297	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.015	5	Weldon	☐
ST5551-.250E5R030.3Z5	SIRA	10303298	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.030	5	Weldon	☐
ST5551-.375E5R015.3Z5	SIRA	10303299	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.015	5	Weldon	☐
ST5551-.375E5R030.3Z5	SIRA	10303300	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.030	5	Weldon	☐
ST5551-.375E5R045.3Z5	SIRA	10303301	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.045	5	Weldon	☐
ST5551-.375E5R060.3Z5	SIRA	10303302	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.060	5	Weldon	☐
ST5551-.625E5R030.3Z5	SIRA	10303304	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.030	5	Weldon	☐
ST5551-.625E5R060.3Z5	SIRA	10303305	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.060	5	Weldon	☐
ST5551-.750E5R030.3Z5	SIRA	10303306	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.030	5	Weldon	☐
ST5551-.750E5R060.3Z5	SIRA	10303307	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.060	5	Weldon	☐
ST5551-.750E5R120.3Z5	SIRA	10303308	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.120	5	Weldon	☐
ST5551-.500E6R015.3Z5	SIRA	10303310	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.015	5	Weldon	☐
ST5551-.500E6R030.3Z5	SIRA	10303311	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.030	5	Weldon	☐
ST5551-.500E6R060.3Z5	SIRA	10303312	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.060	5	Weldon	☐
ST5551-.500E6R120.3Z5	SIRA	10303313	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.120	5	Weldon	☐
ST5551-.250E8R015.3Z5	SIRA	10303314	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.015	5	Weldon	☐
ST5551-.250E8R030.3Z5	SIRA	10303315	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.030	5	Weldon	☐
ST5551-.375E8R015.3Z5	SIRA	10303316	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.015	5	Weldon	☐
ST5551-.375E8R030.3Z5	SIRA	10303317	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.030	5	Weldon	☐
ST5551-.375E8R045.3Z5	SIRA	10303318	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.045	5	Weldon	☐
ST5551-.375E8R060.3Z5	SIRA	10303319	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.060	5	Weldon	☐
ST5551-.500E8R015.3Z5	SIRA	10303320	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.015	5	Weldon	☐
ST5551-.500E8R030.3Z5	SIRA	10303321	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.030	5	Weldon	☐
ST5551-.500E8R060.3Z5	SIRA	10303322	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.060	5	Weldon	☐
ST5551-.500E8R120.3Z5	SIRA	10303323	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.120	5	Weldon	☐

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

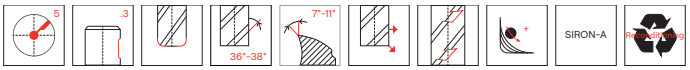
ST5551

Alte prestazioni – Universale – Spallamento – 5 Eliche – Weldon – Raggio di punta – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Riaffilatura possibile



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
						inch	inch	inch	inch	inch			
ST5551-.250D3R015.3Z5C	SIRA	10303324	3	D	■	0.250	0.250	0.750	2.500	0.015	5	Weldon	□
ST5551-.375D3R030.3Z5C	SIRA	10303325	3	D	■	0.375	0.375	1.250	3.000	0.030	5	Weldon	□
ST5551-.500D3R030.3Z5C	SIRA	10303326	3	D	■	0.500	0.500	1.250	3.000	0.030	5	Weldon	□
ST5551-.625D3R030.3Z5C	SIRA	10303327	3	D	■	0.625	0.625	1.375	3.500	0.030	5	Weldon	□
ST5551-.750D3R030.3Z5C	SIRA	10303328	3	D	■	0.750	0.750	1.625	4.000	0.030	5	Weldon	□
ST5551-.500D4R030.3Z5C	SIRA	10303329	4	D	■	0.500	0.500	1.625	4.000	0.030	5	Weldon	□
ST5551-.750D4R030.3Z5C	SIRA	10303330	4	D	■	0.750	0.750	2.250	5.000	0.030	5	Weldon	□
ST5551-.625D5R030.3Z5C	SIRA	10303331	5	D	■	0.625	0.625	2.125	4.000	0.030	5	Weldon	□

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

Parametri di taglio – ST5551 Contornatura

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P1	M/A/D/E	0,30 *0.30*	2,0 *2.0*	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*	175 (140 — 210) *570 (460 — 680)*
P2	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,040 *0.0016*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	170 (140 — 210) *560 (460 — 680)*
P3	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	150 (120 — 180) *490 (400 — 590)*
P4	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,036 *0.0014*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	130 (110 — 160) *425 (370 — 520)*
P5	M/A/D/E	0,30 *0.30*	2,0 *2.0*	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*	125 (97 — 150) *410 (320 — 490)*
P6	M/A/D/E	0,30 *0.30*	2,0 *2.0*	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*	140 (110 — 170) *460 (370 — 550)*
P7	M/A/D/E	0,30 *0.30*	2,0 *2.0*	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*	135 (110 — 160) *445 (370 — 520)*
P8	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	125 (97 — 150) *410 (320 — 490)*
P11	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	120 (110 — 140) *395 (370 — 450)*
P12	M/A/D/E	0,30 *0.30*	2,0 *2.0*	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*	75 (66 — 88) *245 (220 — 280)*
M1	E	0,30 *0.30*	2,0 *2.0*	0,034 *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*	140 (120 — 160) *460 (400 — 520)*
M2	E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	115 (99 — 130) *375 (330 — 420)*
M3	E	0,30 *0.30*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	90 (79 — 100) *295 (260 — 320)*
M4	E	0,30 *0.30*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	70 (60 — 80) *230 (200 — 260)*
M5	E	0,30 *0.30*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	60 (50 — 67) *195 (170 — 210)*
K1	E	0,30 *0.30*	2,0 *2.0*	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*	150 (120 — 180) *490 (400 — 590)*
K2	E	0,30 *0.30*	2,0 *2.0*	0,034 *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*	130 (110 — 160) *425 (370 — 520)*
K3	E	0,30 *0.30*	2,0 *2.0*	0,034 *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)*
K4	E	0,30 *0.30*	2,0 *2.0*	0,034 *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*	105 (81 — 130) *345 (270 — 420)*
K5	E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	65 (50 — 81) *215 (170 — 260)*
K6	E	0,30 *0.30*	2,0 *2.0*	0,034 *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 — 130) *360 (280 — 420)*
K7	E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	95 (75 — 120) *310 (250 — 390)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – ST5551 Contornatura

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	385 (300 — 470) *1275 (990 — 1500)*
N2	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	250 (190 — 300) *820 (630 — 980)*
N3	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	165 (130 — 200) *540 (430 — 650)*
N11	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	220 (170 — 270) *720 (560 — 880)*
S1	E	0,24 *0.24*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	47 (36 — 76) *155 (120 — 240)*
S2	E	0,24 *0.24*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	38 (29 — 61) *125 (96 — 200)*
S3	E	0,24 *0.24*	2,0 *2.0*	0,022 *0.00085*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,070 *0.0028*	33 (25 — 53) *110 (83 — 170)*
S11	E	0,24 *0.24*	2,0 *2.0*	0,028 *0.0011*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	65 (50 — 100) *215 (170 — 320)*
S12	E	0,24 *0.24*	2,0 *2.0*	0,028 *0.0011*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	50 (39 — 82) *165 (130 — 260)*
S13	E	0,24 *0.24*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	40 (31 — 65) *130 (110 — 210)*
H5	M/A/D	0,15 *0.15*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	115 (86 — 140) *375 (290 — 450)*
H8	M/A/D	0,15 *0.15*	2,0 *2.0*	0,016 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*
H11	M/A/D	0,15 *0.15*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	145 (110 — 180) *475 (370 — 590)*
H12	M/A/D	0,15 *0.15*	2,0 *2.0*	0,016 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	140 (110 — 170) *460 (370 — 550)*
H21	M/A/D	0,15 *0.15*	2,0 *2.0*	0,016 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – ST5551 Contornatura sgrossatura avanzata a_e/DC = 0,10

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
P1	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	215 (170 — 260) *710 (560 — 850)*
P2	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	210 (170 — 260) *690 (560 — 850)*
P3	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	180 (140 — 220) *590 (460 — 720)*
P4	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	160 (130 — 190) *520 (430 — 620)*
P5	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	155 (120 — 180) *510 (400 — 590)*
P6	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	170 (140 — 210) *560 (460 — 680)*
P7	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	160 (130 — 200) *520 (430 — 650)*
P8	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	155 (120 — 180) *510 (400 — 590)*
P11	M/A/D/E	2,0 *2.0*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	2,0 *2.0*	0,032 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	90 (78 — 100) *295 (260 — 320)*
M1	E	2,0 *2.0*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	170 (150 — 190) *560 (500 — 620)*
M2	E	2,0 *2.0*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (120 — 150) *460 (400 — 490)*
M3	E	2,0 *2.0*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	110 (93 — 120) *360 (310 — 390)*
M4	E	2,0 *2.0*	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*	80 (71 — 94) *260 (240 — 300)*
M5	E	2,0 *2.0*	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*	70 (59 — 79) *230 (200 — 250)*
K1	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	180 (140 — 220) *590 (460 — 720)*
K2	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	155 (120 — 190) *510 (400 — 620)*
K3	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	135 (110 — 160) *445 (370 — 520)*
K4	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	125 (97 — 160) *410 (320 — 520)*
K5	E	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*	0,15 *0.0060*	75 (58 — 96) *245 (200 — 310)*
K6	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	130 (110 — 160) *425 (370 — 520)*
K7	E	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*	0,15 *0.0060*	115 (88 — 140) *375 (290 — 450)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – ST5551 Contornatura sgrossatura avanzata a_e/DC = 0,10

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
N1	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	495 (380 — 610) *1625 (1300 — 2000)*
N2	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	320 (250 — 390) *1050 (830 — 1200)*
N3	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	215 (170 — 260) *710 (560 — 850)*
N11	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	285 (220 — 350) *940 (730 — 1100)*
S1	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	55 (41 — 86) *180 (140 — 280)*
S2	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	43 (33 — 70) *140 (110 — 220)*
S3	E	2,0 *2.0*	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*	37 (28 — 60) *120 (92 — 190)*
S11	E	2,0 *2.0*	0,032 *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*	75 (58 — 120) *245 (200 — 390)*
S12	E	2,0 *2.0*	0,032 *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*	60 (45 — 96) *195 (150 — 310)*
S13	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	46 (35 — 74) *150 (120 — 240)*
H5	M/A/D	2,0 *2.0*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	120 (91 — 150) *395 (300 — 490)*
H8	M/A/D	2,0 *2.0*	0,019 *0.00075*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*
H11	M/A/D	2,0 *2.0*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	155 (120 — 190) *510 (400 — 620)*
H12	M/A/D	2,0 *2.0*	0,019 *0.00075*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	145 (110 — 180) *475 (370 — 590)*
H21	M/A/D	2,0 *2.0*	0,019 *0.00075*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – ST5551 Contornatura – Inch

SMG		a_e/DC	a_p/DC	f_z											v_c
				1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	175 (140 — 210) *570 (460 — 680)*
P2	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	170 (140 — 210) *560 (460 — 680)*
P3	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	150 (120 — 180) *490 (400 — 590)*
P4	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,030 *0.0012*	0,034 *0.0013*	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*	130 (110 — 160) *425 (370 — 520)*
P5	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	125 (97 — 150) *410 (320 — 490)*
P6	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	140 (110 — 170) *460 (370 — 550)*
P7	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P8	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	125 (97 — 150) *410 (320 — 490)*
P11	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	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*	120 (110 — 140) *395 (370 — 450)*
P12	M/A/D/E	0,30 *0.30*	2,0 *2.0*	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*	0,042 *0.0017*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	75 (66 — 88) *245 (220 — 280)*
M1	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	140 (120 — 160) *460 (400 — 520)*
M2	E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	115 (99 — 130) *375 (330 — 420)*
M3	E	0,30 *0.30*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,080 *0.0032*	90 (79 — 100) *295 (260 — 320)*
M4	E	0,30 *0.30*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	70 (60 — 80) *230 (200 — 260)*
M5	E	0,30 *0.30*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	60 (50 — 67) *195 (170 — 210)*
K1	E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,030 *0.0012*	0,034 *0.0013*	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*	150 (120 — 180) *490 (400 — 590)*
K2	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	130 (110 — 160) *425 (370 — 520)*
K3	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	110 (85 — 140) *360 (280 — 450)*
K4	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	105 (81 — 130) *345 (270 — 420)*
K5	E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	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*	65 (50 — 81) *215 (170 — 260)*
K6	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	110 (85 — 130) *360 (280 — 420)*
K7	E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	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*	95 (75 — 120) *310 (250 — 390)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – ST5551 Contornatura – Inch

SMG		a_e/DC	a_p/DC	f_z											v_c
				1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	385 (300 — 470) *1275 (990 — 1500)*
N2	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	250 (190 — 300) *820 (630 — 980)*
N3	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	165 (130 — 200) *540 (430 — 650)*
N11	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	220 (170 — 270) *720 (560 — 880)*
S1	E	0,24 *0.24*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	47 (36 — 76) *155 (120 — 240)*
S2	E	0,24 *0.24*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	38 (29 — 61) *125 (96 — 200)*
S3	E	0,24 *0.24*	2,0 *2.0*	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*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	0,070 *0.0028*	33 (25 — 53) *110 (83 — 170)*
S11	E	0,24 *0.24*	2,0 *2.0*	0,015 *0.00060*	0,018 *0.00070*	0,022 *0.00085*	0,025 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	65 (50 — 100) *215 (170 — 320)*
S12	E	0,24 *0.24*	2,0 *2.0*	0,015 *0.00060*	0,018 *0.00070*	0,022 *0.00085*	0,025 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	50 (39 — 82) *165 (130 — 260)*
S13	E	0,24 *0.24*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	40 (31 — 65) *130 (110 — 210)*
H5	M/A/D	0,15 *0.15*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	115 (86 — 140) *375 (290 — 450)*
H8	M/A/D	0,15 *0.15*	2,0 *2.0*	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*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*
H11	M/A/D	0,15 *0.15*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	145 (110 — 180) *475 (370 — 590)*
H12	M/A/D	0,15 *0.15*	2,0 *2.0*	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*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	140 (110 — 170) *460 (370 — 550)*
H21	M/A/D	0,15 *0.15*	2,0 *2.0*	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*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – ST5551 Contornatura sgrossatura avanzata a_e/DC = 0,10 –

SMG		a_p/DC	f_z											v_c
			1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	215 (170 — 260) *710 (560 — 850)*
P2	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	210 (170 — 260) *690 (560 — 850)*
P3	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	180 (140 — 220) *590 (460 — 720)*
P4	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	160 (130 — 190) *520 (430 — 620)*
P5	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	155 (120 — 180) *510 (400 — 590)*
P6	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	170 (140 — 210) *560 (460 — 680)*
P7	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	160 (130 — 200) *520 (430 — 650)*
P8	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	155 (120 — 180) *510 (400 — 590)*
P11	M/A/D/E	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	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*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	2,0 *2.0*	0,017 *0.00065*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	0,10 *0.0040*	90 (78 — 100) *295 (260 — 320)*
M1	E	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	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*	170 (150 — 190) *560 (500 — 620)*
M2	E	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	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*	140 (120 — 150) *460 (400 — 490)*
M3	E	2,0 *2.0*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*	0,034 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	110 (93 — 120) *360 (310 — 390)*
M4	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	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*	80 (71 — 94) *260 (240 — 300)*
M5	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	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*	70 (59 — 79) *230 (200 — 250)*
K1	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	180 (140 — 220) *590 (460 — 720)*
K2	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*	155 (120 — 190) *510 (400 — 620)*
K3	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*	135 (110 — 160) *445 (370 — 520)*
K4	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*	125 (97 — 160) *410 (320 — 520)*
K5	E	2,0 *2.0*	0,024 *0.00095*	0,030 *0.0012*	0,036 *0.0014*	0,042 *0.0017*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	75 (58 — 96) *245 (200 — 310)*
K6	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*	130 (110 — 160) *425 (370 — 520)*
K7	E	2,0 *2.0*	0,024 *0.00095*	0,030 *0.0012*	0,036 *0.0014*	0,042 *0.0017*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	115 (88 — 140) *375 (290 — 450)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – ST5551 Contornatura sgrossatura avanzata a_e/DC = 0,10 –

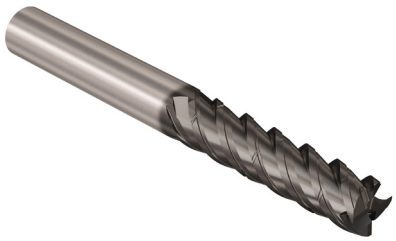
SMG		a_p/DC	f_z											v_c
			1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	495 (380 — 610) *1625 (1300 — 2000)*
N2	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	320 (250 — 390) *1050 (830 — 1200)*
N3	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	215 (170 — 260) *710 (560 — 850)*
N11	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	285 (220 — 350) *940 (730 — 1100)*
S1	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	55 (41 — 86) *180 (140 — 280)*
S2	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	43 (33 — 70) *140 (110 — 220)*
S3	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,025 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,085 *0.0034*	0,10 *0.0040*	37 (28 — 60) *120 (92 — 190)*
S11	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	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*	75 (58 — 120) *245 (200 — 390)*
S12	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	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*	60 (45 — 96) *195 (150 — 310)*
S13	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	46 (35 — 74) *150 (120 — 240)*
H5	M/A/D	2,0 *2.0*	0,013 *0.00050*	0,017 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	120 (91 — 150) *395 (300 — 490)*
H8	M/A/D	2,0 *2.0*	0,010 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,046 *0.0018*	0,050 *0.0020*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*
H11	M/A/D	2,0 *2.0*	0,013 *0.00050*	0,017 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	155 (120 — 190) *510 (400 — 620)*
H12	M/A/D	2,0 *2.0*	0,010 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,046 *0.0018*	0,050 *0.0020*	0,060 *0.0024*	145 (110 — 180) *475 (370 — 590)*
H21	M/A/D	2,0 *2.0*	0,010 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,046 *0.0018*	0,050 *0.0020*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*

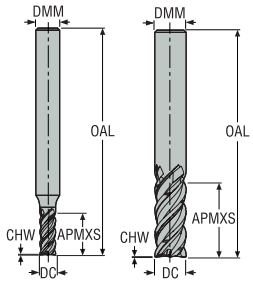
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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





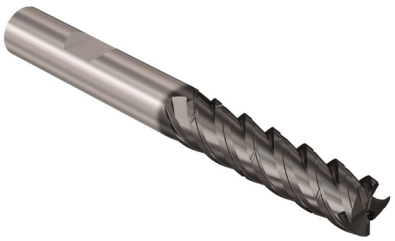
—Tolleranze:
—DMM= h5
—DC= e7
—Riaffilatura possibile se DC è ≥Ø8

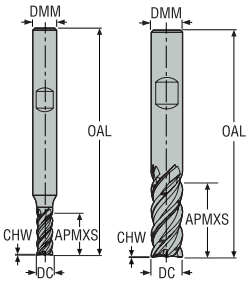
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS564030F2C.0Z4C-NXT	03067338	2	F	■	3,0	6,0	7,0	57,0	0,04	4	Cylindrical	■
JS564040F2C.0Z4C-NXT	03067339	2	F	■	4,0	6,0	10,0	57,0	0,05	4	Cylindrical	■
JS564050F2C.0Z4C-NXT	03067340	2	F	■	5,0	6,0	12,5	57,0	0,06	4	Cylindrical	■
JS564060D2C.0Z4C-NXT	03067341	2	D	■	6,0	6,0	15,0	57,0	0,075	4	Cylindrical	■
JS564080D2C.0Z4C-NXT	03067342	2	D	■	8,0	8,0	20,0	63,0	0,1	4	Cylindrical	■
JS564100D2C.0Z4C-NXT	03067343	2	D	■	10,0	10,0	25,0	72,0	0,125	4	Cylindrical	■
JS564120D2C.0Z4C-NXT	03067344	2	D	■	12,0	12,0	30,0	83,0	0,15	4	Cylindrical	■
JS564160D2C.0Z4C-NXT	03067345	2	D	■	16,0	16,0	40,0	99,0	0,2	4	Cylindrical	■
JS564200D2C.0Z4C-NXT	03067346	2	D	■	20,0	20,0	50,0	114,0	0,25	4	Cylindrical	■
JS564060D3C.0Z4C-NXT	03067347	3	D	■	6,0	6,0	23,0	64,0	0,075	4	Cylindrical	■
JS564080D3C.0Z4C-NXT	03067348	3	D	■	8,0	8,0	32,0	74,0	0,1	4	Cylindrical	■
JS564100D3C.0Z4C-NXT	03067349	3	D	■	10,0	10,0	40,0	88,0	0,125	4	Cylindrical	■
JS564120D3C.0Z4C-NXT	03067350	3	D	■	12,0	12,0	45,0	99,0	0,15	4	Cylindrical	■
JS564160D3C.0Z4C-NXT	03067351	3	D	■	16,0	16,0	55,0	114,0	0,2	4	Cylindrical	■
JS564200D3C.0Z4C-NXT	03067352	3	D	■	20,0	20,0	65,0	126,0	0,25	4	Cylindrical	■
JS564060D4C.0Z4C-NXT	10273179	4	D	■	6,0	6,0	30,0	80,0	0,075	4	Cylindrical	■
JS564080D4C.0Z4C-NXT	10273180	4	D	■	8,0	8,0	40,0	85,0	0,1	4	Cylindrical	■
JS564100D4C.0Z4C-NXT	10273181	4	D	■	10,0	10,0	50,0	100,0	0,125	4	Cylindrical	■
JS564120D4C.0Z4C-NXT	10273182	4	D	■	12,0	12,0	60,0	115,0	0,15	4	Cylindrical	■
JS564160D4C.0Z4C-NXT	10273183	4	D	■	16,0	16,0	80,0	150,0	0,2	4	Cylindrical	■
JS564200D4C.0Z4C-NXT	10273184	4	D	■	20,0	20,0	100,0	175,0	0,25	4	Cylindrical	■
JS564250D4C.0Z4C-NXT	10273185	4	D	■	25,0	25,0	125,0	205,0	0,3	4	Cylindrical	■

■ **Prodotto standard.**

JS564

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





F D

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

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS564030F2C.3Z4C-NXT	03067353	2	F	■	3,0	6,0	7,0	57,0	0,04	4	Weldon	■
JS564040F2C.3Z4C-NXT	03067354	2	F	■	4,0	6,0	10,0	57,0	0,05	4	Weldon	■
JS564050F2C.3Z4C-NXT	03067355	2	F	■	5,0	6,0	12,5	57,0	0,06	4	Weldon	■
JS564060D2C.3Z4C-NXT	03067356	2	D	■	6,0	6,0	15,0	57,0	0,075	4	Weldon	■
JS564080D2C.3Z4C-NXT	03067357	2	D	■	8,0	8,0	20,0	63,0	0,1	4	Weldon	■
JS564100D2C.3Z4C-NXT	03067358	2	D	■	10,0	10,0	25,0	72,0	0,125	4	Weldon	■
JS564120D2C.3Z4C-NXT	03067359	2	D	■	12,0	12,0	30,0	83,0	0,15	4	Weldon	■
JS564160D2C.3Z4C-NXT	03067360	2	D	■	16,0	16,0	40,0	99,0	0,2	4	Weldon	■
JS564200D2C.3Z4C-NXT	03067361	2	D	■	20,0	20,0	50,0	114,0	0,25	4	Weldon	■
JS564060D3C.3Z4C-NXT	03067362	3	D	■	6,0	6,0	23,0	64,0	0,075	4	Weldon	■
JS564080D3C.3Z4C-NXT	03067363	3	D	■	8,0	8,0	32,0	74,0	0,1	4	Weldon	■
JS564100D3C.3Z4C-NXT	03067364	3	D	■	10,0	10,0	40,0	88,0	0,125	4	Weldon	■
JS564120D3C.3Z4C-NXT	03067365	3	D	■	12,0	12,0	45,0	99,0	0,15	4	Weldon	■
JS564160D3C.3Z4C-NXT	03067366	3	D	■	16,0	16,0	55,0	114,0	0,2	4	Weldon	■
JS564200D3C.3Z4C-NXT	03067367	3	D	■	20,0	20,0	65,0	126,0	0,25	4	Weldon	■
JS564060D4C.3Z4C-NXT	10273186	4	D	■	6,0	6,0	30,0	80,0	0,075	4	Weldon	□
JS564080D4C.3Z4C-NXT	10273187	4	D	■	8,0	8,0	40,0	85,0	0,1	4	Weldon	□
JS564100D4C.3Z4C-NXT	10273188	4	D	■	10,0	10,0	50,0	100,0	0,125	4	Weldon	□
JS564120D4C.3Z4C-NXT	10273189	4	D	■	12,0	12,0	60,0	115,0	0,15	4	Weldon	□
JS564160D4C.3Z4C-NXT	10273190	4	D	■	16,0	16,0	80,0	150,0	0,2	4	Weldon	□
JS564200D4C.3Z4C-NXT	10273191	4	D	■	20,0	20,0	100,0	175,0	0,25	4	Weldon	□
JS564250D4C.3Z4C-NXT	10273192	4	D	■	25,0	25,0	125,0	205,0	0,3	4	Weldon	■

■ **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 699 - 707

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

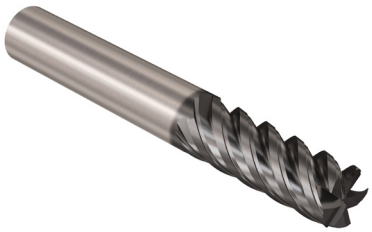
SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	700 (600 — 790) *2300 (2000 — 2500)*
N2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *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)*

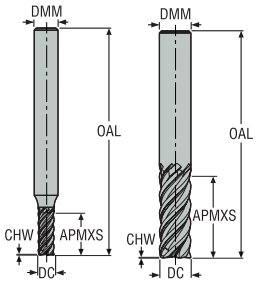
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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
– Riaffilatura possibile se DC è ≥Ø8

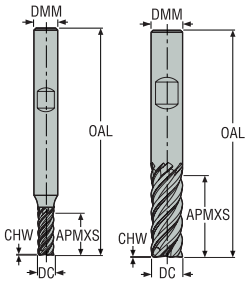
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS565040F2C.0Z5-NXT	03067369	2	F	–	4,0	6,0	10,0	57,0	0,05	5	Cylindrical	■
JS565040F2C.0Z5C-NXT	03067378	2	F	■	4,0	6,0	10,0	57,0	0,05	5	Cylindrical	■
JS565050F2C.0Z5-NXT	03067370	2	F	–	5,0	6,0	12,5	57,0	0,06	5	Cylindrical	■
JS565050F2C.0Z5C-NXT	03067379	2	F	■	5,0	6,0	12,5	57,0	0,06	5	Cylindrical	■
JS565060D2C.0Z5-NXT	03067371	2	D	–	6,0	6,0	15,0	57,0	0,075	5	Cylindrical	■
JS565060D2C.0Z5C-NXT	03067380	2	D	■	6,0	6,0	15,0	57,0	0,075	5	Cylindrical	■
JS565080D2C.0Z5-NXT	03067372	2	D	–	8,0	8,0	20,0	63,0	0,1	5	Cylindrical	■
JS565080D2C.0Z5C-NXT	03067381	2	D	■	8,0	8,0	20,0	63,0	0,1	5	Cylindrical	■
JS565100D2C.0Z5-NXT	03067373	2	D	–	10,0	10,0	25,0	72,0	0,125	5	Cylindrical	■
JS565100D2C.0Z5C-NXT	03067382	2	D	■	10,0	10,0	25,0	72,0	0,125	5	Cylindrical	■
JS565120D2C.0Z5-NXT	03067374	2	D	–	12,0	12,0	30,0	83,0	0,15	5	Cylindrical	■
JS565120D2C.0Z5C-NXT	03067383	2	D	■	12,0	12,0	30,0	83,0	0,15	5	Cylindrical	■
JS565160D2C.0Z5-NXT	03067375	2	D	–	16,0	16,0	40,0	99,0	0,2	5	Cylindrical	■
JS565160D2C.0Z5C-NXT	03067384	2	D	■	16,0	16,0	40,0	99,0	0,2	5	Cylindrical	■
JS565200D2C.0Z5-NXT	03067376	2	D	–	20,0	20,0	50,0	114,0	0,25	5	Cylindrical	■
JS565200D2C.0Z5C-NXT	03067385	2	D	■	20,0	20,0	50,0	114,0	0,25	5	Cylindrical	■
JS565060D3C.0Z5C-NXT	03067386	3	D	■	6,0	6,0	23,0	64,0	0,075	5	Cylindrical	■
JS565080D3C.0Z5C-NXT	03067387	3	D	■	8,0	8,0	32,0	74,0	0,1	5	Cylindrical	■
JS565100D3C.0Z5C-NXT	03067388	3	D	■	10,0	10,0	40,0	88,0	0,125	5	Cylindrical	■
JS565120D3C.0Z5C-NXT	03067389	3	D	■	12,0	12,0	45,0	99,0	0,15	5	Cylindrical	■
JS565160D3C.0Z5C-NXT	03067390	3	D	■	16,0	16,0	55,0	114,0	0,2	5	Cylindrical	■
JS565200D3C.0Z5C-NXT	03067391	3	D	■	20,0	20,0	65,0	126,0	0,25	5	Cylindrical	■
JS565060D4C.0Z5C-NXT	10273193	4	D	■	6,0	6,0	30,0	80,0	0,075	5	Cylindrical	■
JS565080D4C.0Z5C-NXT	10273194	4	D	■	8,0	8,0	40,0	85,0	0,1	5	Cylindrical	■
JS565100D4C.0Z5C-NXT	10273195	4	D	■	10,0	10,0	50,0	100,0	0,125	5	Cylindrical	■
JS565120D4C.0Z5C-NXT	10273196	4	D	■	12,0	12,0	60,0	115,0	0,15	5	Cylindrical	■
JS565160D4C.0Z5C-NXT	10273197	4	D	■	16,0	16,0	80,0	150,0	0,2	5	Cylindrical	■
JS565200D4C.0Z5C-NXT	10273198	4	D	■	20,0	20,0	100,0	175,0	0,25	5	Cylindrical	■
JS565250D4C.0Z5C-NXT	10273199	4	D	■	25,0	25,0	125,0	205,0	0,3	5	Cylindrical	■

■ **Prodotto standard.**

JS565

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





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

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS565040F2C.3Z5-NXT	03067393	2	F	–	4,0	6,0	10,0	57,0	0,05	5	Weldon	■
JS565040F2C.3Z5C-NXT	03067402	2	F	■	4,0	6,0	10,0	57,0	0,05	5	Weldon	■
JS565050F2C.3Z5-NXT	03067394	2	F	–	5,0	6,0	12,5	57,0	0,06	5	Weldon	■
JS565050F2C.3Z5C-NXT	03067403	2	F	■	5,0	6,0	12,5	57,0	0,06	5	Weldon	■
JS565060D2C.3Z5-NXT	03067395	2	D	–	6,0	6,0	15,0	57,0	0,075	5	Weldon	■
JS565060D2C.3Z5C-NXT	03067404	2	D	■	6,0	6,0	15,0	57,0	0,075	5	Weldon	■
JS565080D2C.3Z5-NXT	03067396	2	D	–	8,0	8,0	20,0	63,0	0,1	5	Weldon	■
JS565080D2C.3Z5C-NXT	03067405	2	D	■	8,0	8,0	20,0	63,0	0,1	5	Weldon	■
JS565100D2C.3Z5-NXT	03067397	2	D	–	10,0	10,0	25,0	72,0	0,125	5	Weldon	■
JS565100D2C.3Z5C-NXT	03067406	2	D	■	10,0	10,0	25,0	72,0	0,125	5	Weldon	■
JS565120D2C.3Z5-NXT	03067398	2	D	–	12,0	12,0	30,0	83,0	0,15	5	Weldon	■
JS565120D2C.3Z5C-NXT	03067407	2	D	■	12,0	12,0	30,0	83,0	0,15	5	Weldon	■
JS565160D2C.3Z5-NXT	03067399	2	D	–	16,0	16,0	40,0	99,0	0,2	5	Weldon	■
JS565160D2C.3Z5C-NXT	03067408	2	D	■	16,0	16,0	40,0	99,0	0,2	5	Weldon	■
JS565200D2C.3Z5-NXT	03067400	2	D	–	20,0	20,0	50,0	114,0	0,25	5	Weldon	■
JS565200D2C.3Z5C-NXT	03067409	2	D	■	20,0	20,0	50,0	114,0	0,25	5	Weldon	■
JS565060D3C.3Z5C-NXT	03067410	3	D	■	6,0	6,0	23,0	64,0	0,075	5	Weldon	■
JS565080D3C.3Z5C-NXT	03067411	3	D	■	8,0	8,0	32,0	74,0	0,1	5	Weldon	■
JS565100D3C.3Z5C-NXT	03067412	3	D	■	10,0	10,0	40,0	88,0	0,125	5	Weldon	■
JS565120D3C.3Z5C-NXT	03067413	3	D	■	12,0	12,0	45,0	99,0	0,15	5	Weldon	■
JS565160D3C.3Z5C-NXT	03067414	3	D	■	16,0	16,0	55,0	114,0	0,2	5	Weldon	■
JS565200D3C.3Z5C-NXT	03067415	3	D	■	20,0	20,0	65,0	126,0	0,25	5	Weldon	■
JS565060D4C.3Z5C-NXT	10273200	4	D	■	6,0	6,0	30,0	80,0	0,075	5	Weldon	□
JS565080D4C.3Z5C-NXT	10273201	4	D	■	8,0	8,0	40,0	85,0	0,1	5	Weldon	□
JS565100D4C.3Z5C-NXT	10273202	4	D	■	10,0	10,0	50,0	100,0	0,125	5	Weldon	□
JS565120D4C.3Z5C-NXT	10273203	4	D	■	12,0	12,0	60,0	115,0	0,15	5	Weldon	□
JS565160D4C.3Z5C-NXT	10273204	4	D	■	16,0	16,0	80,0	150,0	0,2	5	Weldon	□
JS565200D4C.3Z5C-NXT	10273205	4	D	■	20,0	20,0	100,0	175,0	0,25	5	Weldon	□
JS565250D4C.3Z5C-NXT	10273206	4	D	■	25,0	25,0	125,0	205,0	0,3	5	Weldon	■

■ **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 699 - 707

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)*

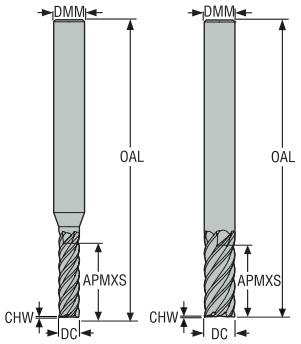
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

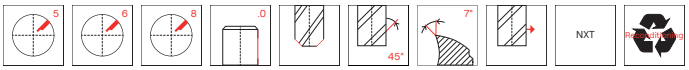
JS520

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





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



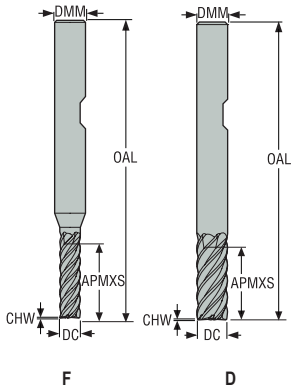
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS520040F2C.0Z5-NXT	02927474	2	F	4,0	6,0	10,0	57,0	0,04	5	Cylindrical	■
JS520050F2C.0Z5-NXT	02927476	2	F	5,0	6,0	12,0	57,0	0,05	5	Cylindrical	■
JS520060D2C.0Z5-NXT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

■ **Prodotto standard.**

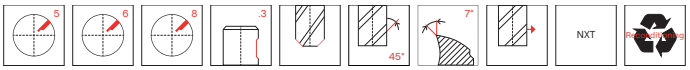
JS520

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

■ **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 699 - 707

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)*

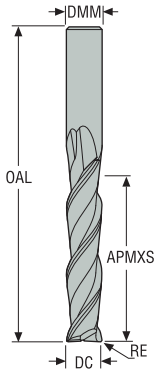
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

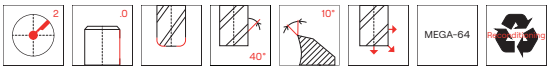
JS522

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
- Riaffilatura possibile se DC è ≥Ø6

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

■ **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 699 - 707

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)*

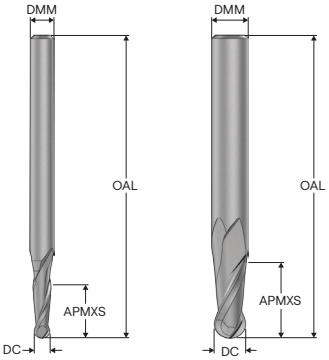
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

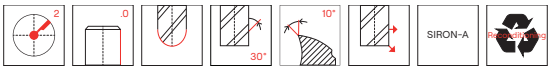
C5321

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





– Tolleranze:
– DMM=h5
– DC= h10
– RE= ±0,01 mm
– Riaffilatura possibile se DC è ≥Ø10



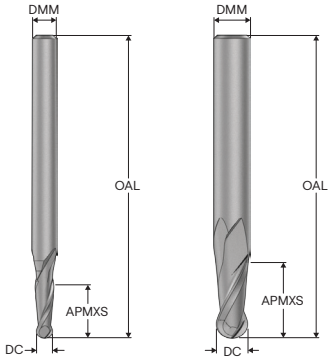
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
C5321-060D1B.0Z2	SIRA	10268679	1	D	6,0	6,0	9,0	57,0	3,0	2	Cylindrical	■
C5321-020F2B.0Z2	SIRA	10268669	2	F	2,0	3,0	4,0	38,0	1,0	2	Cylindrical	■
C5321-030D2B.0Z2	SIRA	10268672	2	D	3,0	3,0	6,0	38,0	1,5	2	Cylindrical	■
C5321-040D2B.0Z2	SIRA	10268675	2	D	4,0	4,0	8,0	50,0	2,0	2	Cylindrical	■
C5321-050F2B.0Z2	SIRA	10268677	2	F	5,0	6,0	10,0	57,0	2,5	2	Cylindrical	■
C5321-060D2B.0Z2	SIRA	10268680	2	D	6,0	6,0	12,0	57,0	3,0	2	Cylindrical	■
C5321-080D2B.0Z2	SIRA	10268682	2	D	8,0	8,0	16,0	63,0	4,0	2	Cylindrical	■
C5321-090F2B.0Z2	SIRA	10268684	2	F	9,0	10,0	22,0	72,0	4,5	2	Cylindrical	■
C5321-100D2B.0Z2	SIRA	10268685	2	D	10,0	10,0	22,0	72,0	5,0	2	Cylindrical	■
C5321-120D2B.0Z2	SIRA	10268687	2	D	12,0	12,0	25,0	83,0	6,0	2	Cylindrical	■
C5321-015F3B.0Z2	SIRA	10268668	3	F	1,5	3,0	4,5	38,0	0,75	2	Cylindrical	■
C5321-020F3B.0Z2	SIRA	10268670	3	F	2,0	3,0	6,3	38,0	1,0	2	Cylindrical	■
C5321-035F3B.0Z2	SIRA	10268674	3	F	3,5	4,0	12,0	50,0	1,75	2	Cylindrical	■
C5321-050F3B.0Z2	SIRA	10268678	3	F	5,0	6,0	16,0	57,0	2,5	2	Cylindrical	■
C5321-060D3B.0Z2	SIRA	10268681	3	D	6,0	6,0	19,0	63,0	3,0	2	Cylindrical	■
C5321-080D3B.0Z2	SIRA	10268683	3	D	8,0	8,0	20,0	63,0	4,0	2	Cylindrical	■
C5321-010F4B.0Z2	SIRA	10268667	4	F	1,0	3,0	4,0	38,0	0,5	2	Cylindrical	■
C5321-030D4B.0Z2	SIRA	10268673	4	D	3,0	3,0	12,0	38,0	1,5	2	Cylindrical	■
C5321-040D4B.0Z2	SIRA	10268676	4	D	4,0	4,0	14,0	50,0	2,0	2	Cylindrical	■
C5321-100D4B.0Z2	SIRA	10268686	4	D	10,0	10,0	35,0	89,0	5,0	2	Cylindrical	■
C5321-120D4B.0Z2	SIRA	10268688	4	D	12,0	12,0	50,0	100,0	6,0	2	Cylindrical	■

■ **Prodotto standard.**

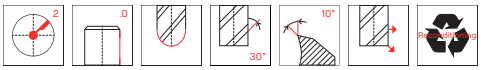
C5321

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





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
—Riaffilatura possibile se DC è ≥Ø.375

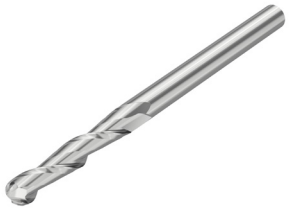


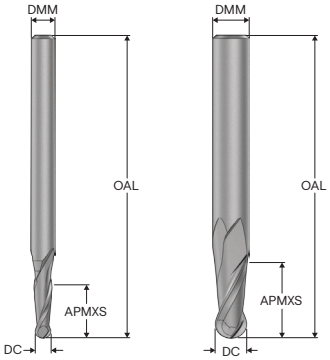
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				inch	inch	inch	inch	inch			
C5321-.500D1B.0Z2	10268913	1	D	0.500	0.500	0.625	2.500	0.250	2	Cylindrical	■
C5321-1.000D1B.0Z2	10268923	1	D	1.000	1.000	1.500	4.000	0.500	2	Cylindrical	■
C5321-.016F2B.0Z2	10268878	2	F	0.016	0.125	0.031	1.500	0.008	2	Cylindrical	■
C5321-.047F2B.0Z2	10268881	2	F	0.047	0.125	0.109	1.500	0.023	2	Cylindrical	■
C5321-.063F2B.0Z2	10268883	2	F	0.063	0.125	0.125	1.500	0.031	2	Cylindrical	■
C5321-.078F2B.0Z2	10268886	2	F	0.078	0.125	0.188	1.500	0.039	2	Cylindrical	■
C5321-.094F2B.0Z2	10268888	2	F	0.094	0.125	0.188	1.500	0.047	2	Cylindrical	■
C5321-.125D2B.0Z2	10268891	2	D	0.125	0.125	0.250	1.500	0.063	2	Cylindrical	■
C5321-.188D2B.0Z2	10268896	2	D	0.188	0.188	0.375	2.000	0.094	2	Cylindrical	■
C5321-.250D2B.0Z2	10268899	2	D	0.250	0.250	0.500	2.000	0.125	2	Cylindrical	■
C5321-.375D2B.0Z2	10268908	2	D	0.375	0.375	0.625	2.000	0.188	2	Cylindrical	■
C5321-.500D2B.0Z2	10268914	2	D	0.500	0.500	1.000	3.000	0.250	2	Cylindrical	■
C5321-.625D2B.0Z2	10268919	2	D	0.625	0.625	1.250	3.500	0.313	2	Cylindrical	■
C5321-.750D2B.0Z2	10268921	2	D	0.750	0.750	1.500	4.000	0.375	2	Cylindrical	■
C5321-.031F3B.0Z2	10268879	3	F	0.031	0.125	0.078	1.500	0.016	2	Cylindrical	■
C5321-.047F3B.0Z2	10268882	3	F	0.047	0.125	0.125	1.500	0.023	2	Cylindrical	■
C5321-.063F3B.0Z2	10268884	3	F	0.063	0.125	0.188	1.500	0.031	2	Cylindrical	■
C5321-.078F3B.0Z2	10268887	3	F	0.078	0.125	0.250	1.500	0.039	2	Cylindrical	■
C5321-.094F3B.0Z2	10268889	3	F	0.094	0.125	0.281	1.500	0.047	2	Cylindrical	■
C5321-.156F3B.0Z2	10268895	3	F	0.156	0.188	0.500	2.000	0.078	2	Cylindrical	■
C5321-.188D3B.0Z2	10268897	3	D	0.188	0.188	0.625	2.000	0.094	2	Cylindrical	■
C5321-.250D3B.0Z2	10268900	3	D	0.250	0.250	0.750	2.500	0.125	2	Cylindrical	■
C5321-.313D3B.0Z2	10268905	3	D	0.313	0.313	0.813	2.500	0.156	2	Cylindrical	■
C5321-.375D3B.0Z2	10268909	3	D	0.375	0.375	1.000	2.500	0.188	2	Cylindrical	■
C5321-.500D3B.0Z2	10268915	3	D	0.500	0.500	1.000	4.000	0.250	2	Cylindrical	■
C5321-.750D3B.0Z2	10268922	3	D	0.750	0.750	2.000	6.000	0.375	2	Cylindrical	■

■ **Prodotto standard.**

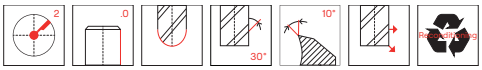
C5321

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





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
—Riaffilatura possibile se DC è ≥Ø.375



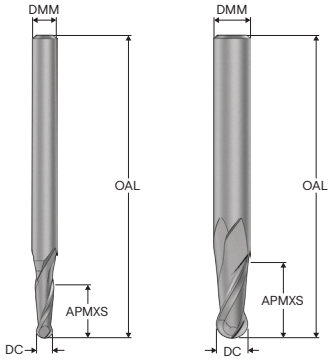
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				inch	inch	inch	inch	inch			
C5321-.031F4B.0Z2	10268880	4	F	0.031	0.125	0.094	1.500	0.016	2	Cylindrical	■
C5321-.063F4B.0Z2	10268885	4	F	0.063	0.125	0.250	1.500	0.031	2	Cylindrical	■
C5321-.094F4B.0Z2	10268890	4	F	0.094	0.125	0.375	1.500	0.047	2	Cylindrical	■
C5321-.125D4B.0Z2	10268892	4	D	0.125	0.125	0.500	1.500	0.063	2	Cylindrical	■
C5321-.188D4B.0Z2	10268898	4	D	0.188	0.188	1.000	3.000	0.094	2	Cylindrical	■
C5321-.250D4B.0Z2	10268901	4	D	0.250	0.250	1.000	3.000	0.125	2	Cylindrical	■
C5321-.375D4B.0Z2	10268910	4	D	0.375	0.375	1.000	3.000	0.188	2	Cylindrical	■
C5321-.500D4B.0Z2	10268916	4	D	0.500	0.500	1.500	6.000	0.250	2	Cylindrical	■
C5321-.125D5B.0Z2	10268893	5	D	0.125	0.125	0.625	2.000	0.063	2	Cylindrical	■
C5321-.250D5B.0Z2	10268902	5	D	0.250	0.250	1.000	4.000	0.125	2	Cylindrical	■
C5321-.313D5B.0Z2	10268906	5	D	0.313	0.313	1.000	4.000	0.156	2	Cylindrical	■
C5321-.500D5B.0Z2	10268917	5	D	0.500	0.500	2.000	4.000	0.250	2	Cylindrical	■
C5321-.125D6B.0Z2	10268894	6	D	0.125	0.125	0.750	3.000	0.063	2	Cylindrical	■
C5321-.250D6B.0Z2	10268903	6	D	0.250	0.250	1.500	4.000	0.125	2	Cylindrical	■
C5321-.375D6B.0Z2	10268911	6	D	0.375	0.375	1.500	6.000	0.188	2	Cylindrical	■
C5321-.500D6B.0Z2	10268918	6	D	0.500	0.500	3.000	6.000	0.250	2	Cylindrical	■
C5321-.375D7B.0Z2	10268912	7	D	0.375	0.375	2.000	4.000	0.188	2	Cylindrical	■

■ **Prodotto standard.**

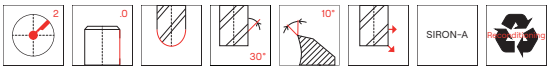
C5321

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





—Tolleranze:
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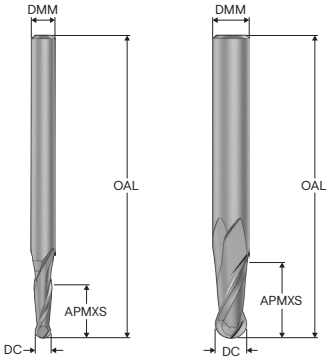
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
C5321-.500D1B.0Z2	SIRA	10268630	1	D	0.500	0.500	0.625	2.500	0.250	2	Cylindrical	■
C5321-.750D1B.0Z2	SIRA	10268637	1	D	0.750	0.750	1.000	3.000	0.375	2	Cylindrical	■
C5321-.016F2B.0Z2	SIRA	10268595	2	F	0.016	0.125	0.031	1.500	0.008	2	Cylindrical	■
C5321-.047F2B.0Z2	SIRA	10268598	2	F	0.047	0.125	0.109	1.500	0.023	2	Cylindrical	■
C5321-.063F2B.0Z2	SIRA	10268600	2	F	0.063	0.125	0.125	1.500	0.031	2	Cylindrical	■
C5321-.078F2B.0Z2	SIRA	10268603	2	F	0.078	0.125	0.188	1.500	0.039	2	Cylindrical	■
C5321-.094F2B.0Z2	SIRA	10268605	2	F	0.094	0.125	0.188	1.500	0.047	2	Cylindrical	■
C5321-.125D2B.0Z2	SIRA	10268608	2	D	0.125	0.125	0.250	1.500	0.063	2	Cylindrical	■
C5321-.188D2B.0Z2	SIRA	10268613	2	D	0.188	0.188	0.375	2.000	0.094	2	Cylindrical	■
C5321-.250D2B.0Z2	SIRA	10268616	2	D	0.250	0.250	0.500	2.000	0.125	2	Cylindrical	■
C5321-.375D2B.0Z2	SIRA	10268625	2	D	0.375	0.375	0.625	2.000	0.188	2	Cylindrical	■
C5321-.500D2B.0Z2	SIRA	10268631	2	D	0.500	0.500	1.000	3.000	0.250	2	Cylindrical	■
C5321-.625D2B.0Z2	SIRA	10268636	2	D	0.625	0.625	1.250	3.500	0.313	2	Cylindrical	■
C5321-.750D2B.0Z2	SIRA	10268638	2	D	0.750	0.750	1.500	4.000	0.375	2	Cylindrical	■
C5321-.031F3B.0Z2	SIRA	10268596	3	F	0.031	0.125	0.078	1.500	0.016	2	Cylindrical	■
C5321-.047F3B.0Z2	SIRA	10268599	3	F	0.047	0.125	0.125	1.500	0.023	2	Cylindrical	■
C5321-.063F3B.0Z2	SIRA	10268601	3	F	0.063	0.125	0.188	1.500	0.031	2	Cylindrical	■
C5321-.078F3B.0Z2	SIRA	10268604	3	F	0.078	0.125	0.250	1.500	0.039	2	Cylindrical	■
C5321-.094F3B.0Z2	SIRA	10268606	3	F	0.094	0.125	0.281	1.500	0.047	2	Cylindrical	■
C5321-.156F3B.0Z2	SIRA	10268612	3	F	0.156	0.188	0.500	2.000	0.078	2	Cylindrical	■
C5321-.188D3B.0Z2	SIRA	10268614	3	D	0.188	0.188	0.625	2.000	0.094	2	Cylindrical	■
C5321-.250D3B.0Z2	SIRA	10268617	3	D	0.250	0.250	0.750	2.500	0.125	2	Cylindrical	■
C5321-.313D3B.0Z2	SIRA	10268622	3	D	0.313	0.313	0.813	2.500	0.156	2	Cylindrical	■
C5321-.375D3B.0Z2	SIRA	10268626	3	D	0.375	0.375	1.000	2.500	0.188	2	Cylindrical	■
C5321-.500D3B.0Z2	SIRA	10268632	3	D	0.500	0.500	1.000	4.000	0.250	2	Cylindrical	■
C5321-.750D3B.0Z2	SIRA	10268639	3	D	0.750	0.750	2.000	6.000	0.375	2	Cylindrical	■

■ **Prodotto standard.**

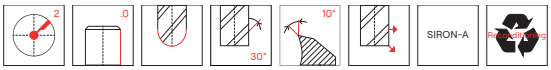
C5321

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





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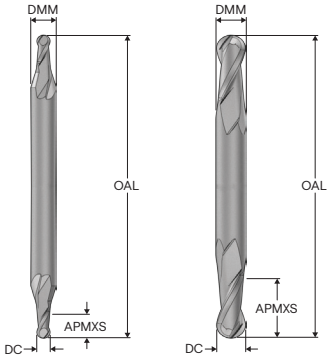
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
C5321-.031F4B.0Z2	SIRA	10268597	4	F	0.031	0.125	0.094	1.500	0.016	2	Cylindrical	■
C5321-.063F4B.0Z2	SIRA	10268602	4	F	0.063	0.125	0.250	1.500	0.031	2	Cylindrical	■
C5321-.094F4B.0Z2	SIRA	10268607	4	F	0.094	0.125	0.375	1.500	0.047	2	Cylindrical	■
C5321-.125D4B.0Z2	SIRA	10268609	4	D	0.125	0.125	0.500	1.500	0.063	2	Cylindrical	■
C5321-.188D4B.0Z2	SIRA	10268615	4	D	0.188	0.188	1.000	3.000	0.094	2	Cylindrical	■
C5321-.250D4B.0Z2	SIRA	10268618	4	D	0.250	0.250	1.000	3.000	0.125	2	Cylindrical	■
C5321-.375D4B.0Z2	SIRA	10268627	4	D	0.375	0.375	1.000	3.000	0.188	2	Cylindrical	■
C5321-.500D4B.0Z2	SIRA	10268633	4	D	0.500	0.500	1.500	6.000	0.250	2	Cylindrical	■
C5321-.125D5B.0Z2	SIRA	10268610	5	D	0.125	0.125	0.625	2.000	0.063	2	Cylindrical	■
C5321-.250D5B.0Z2	SIRA	10268619	5	D	0.250	0.250	1.000	4.000	0.125	2	Cylindrical	■
C5321-.313D5B.0Z2	SIRA	10268623	5	D	0.313	0.313	1.000	4.000	0.156	2	Cylindrical	■
C5321-.500D5B.0Z2	SIRA	10268634	5	D	0.500	0.500	2.000	4.000	0.250	2	Cylindrical	■
C5321-.125D6B.0Z2	SIRA	10268611	6	D	0.125	0.125	0.750	3.000	0.063	2	Cylindrical	■
C5321-.250D6B.0Z2	SIRA	10268620	6	D	0.250	0.250	1.500	4.000	0.125	2	Cylindrical	■
C5321-.375D6B.0Z2	SIRA	10268628	6	D	0.375	0.375	1.500	6.000	0.188	2	Cylindrical	■
C5321-.500D6B.0Z2	SIRA	10268635	6	D	0.500	0.500	3.000	6.000	0.250	2	Cylindrical	■
C5321-.313D7B.0Z2	SIRA	10268624	7	D	0.313	0.313	1.625	4.000	0.156	2	Cylindrical	■
C5321-.375D7B.0Z2	SIRA	10268629	7	D	0.375	0.375	2.000	4.000	0.188	2	Cylindrical	■

■ **Prodotto standard.**

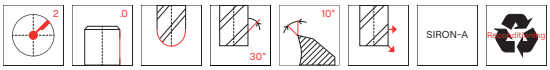
C5321

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





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—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
—Fresa integrale bilaterale
—Riaffilatura possibile se DC è ≥Ø.375



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
C5321-.031F2B.0Z2D	SIRA	10268656	2	F	0.031	0.125	0.063	1.500	0.016	2	Cylindrical	■
C5321-.047F2B.0Z2D	SIRA	10268657	2	F	0.047	0.125	0.094	1.500	0.023	2	Cylindrical	■
C5321-.063F2B.0Z2D	SIRA	10268658	2	F	0.063	0.125	0.125	1.500	0.031	2	Cylindrical	■
C5321-.078F2B.0Z2D	SIRA	10268659	2	F	0.078	0.125	0.125	1.500	0.039	2	Cylindrical	■
C5321-.094F2B.0Z2D	SIRA	10268660	2	F	0.094	0.125	0.188	1.500	0.047	2	Cylindrical	■
C5321-.125D2B.0Z2D	SIRA	10268661	2	D	0.125	0.125	0.250	1.500	0.063	2	Cylindrical	■
C5321-.188D2B.0Z2D	SIRA	10268662	2	D	0.188	0.188	0.375	2.000	0.094	2	Cylindrical	■
C5321-.250D2B.0Z2D	SIRA	10268663	2	D	0.250	0.250	0.500	2.500	0.125	2	Cylindrical	■
C5321-.313D2B.0Z2D	SIRA	10268664	2	D	0.313	0.313	0.500	2.500	0.156	2	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – C5321 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	0,10 *0.10*	1,0 *1.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,048 *0.0019*	150 (135 — 165) *490 (440— 540)*
P2	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	58 (45— 70) *190 (147 — 230)*
P3	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,0038 *0.00015*	0,005 *0.00020*	0,0075 *0.00030*	0,009 *0.00036*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,02 *0.00080*	0,022 *0.00085*	0,025 *0.0010*	0,03 *0.0012*	55 (45— 65) *180 (147 — 213)*
M1	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	55 (45 —65) *180 (147 — 213)*
M4	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,10 *0.10*	1,0 *1.0*	0,0034 *0.00013*	0,005 *0.00020*	0,0065 *0.00026*	0,01 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	0,017 *0.00065*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,10 *0.10*	1,0 *1.0*	0,0044 *0.00017*	0,0065 *0.00026*	0,0085 *0.00034*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,034 *0.0013*	0,04 *0.0016*	0,044 *0.0017*	0,05 *0.0020*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,10 *0.10*	1,0 *1.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,048 *0.0019*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,10 *0.10*	1,0 *1.0*	0,0028 *0.00011*	0,004 *0.00016*	0,0055 *0.00022*	0,008 *0.00032*	0,0095 *0.00038*	0,011 *0.00044*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,025 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,10 *0.10*	1,0 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	110 (95— 120) *360 (311 — 390)*
S12	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,0038 *0.00015*	0,005 *0.00020*	0,0075 *0.00030*	0,009 *0.00036*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,02 *0.00080*	0,022 *0.00085*	0,025 *0.0010*	0,03 *0.0012*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,0038 *0.00015*	0,005 *0.00020*	0,0075 *0.00030*	0,009 *0.00036*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,02 *0.00080*	0,022 *0.00085*	0,025 *0.0010*	0,03 *0.0012*	30 (20 — 40) *100 (65 — 130)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – C5321 Contornatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z												v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,10	1,0	0,0032	0,0065	0,013	0,016	0,019	0,022	0,026	0,032	0,038	0,05	0,06	0,065	0,08	150 (135 — 165)
		0.10	*1.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*490 (440— 540)*
P2	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	58 (45— 70)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*190 (147 — 230)*
P3	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	85 (70 — 95)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*279 (246 — 312)*
P4	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	100 (90 — 110)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*330 (295 — 360)*
P5	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	68 (50 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*223 (165 — 245)*
P6	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	87 (77 — 100)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*285 (250 — 330)*
P7	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (55 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (180 — 245)*
P8	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (50 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (165 — 245)*
P11	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	85 (70 — 95)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*280 (230 — 310)*
P12	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	55 (45— 65)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*180 (147 — 213)*
M1	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	93 (83 — 100)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*305 (270 — 360)*
M2	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	60 (50 — 70)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*200 (165 — 230)*
M3	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	55 (45 —65)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*180 (147 — 213)*
M4	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	45 (35 — 55)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*147 (115 — 180)*
M5	E	0,10	1,0	0,0026	0,0055	0,011	0,013	0,016	0,019	0,022	0,026	0,032	0,042	0,048	0,055	0,065	35 (20 — 45)
		0.10	*1.0*	*0.00010*	*0.00022*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0019*	*0.0022*	*0.0026*	*114 (65 — 147)*
K1	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	80 (70 — 90)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*260 (230 — 290)*
K2	E	0,10	1,0	0,0034	0,007	0,014	0,017	0,02	0,024	0,028	0,034	0,042	0,055	0,065	0,07	0,085	87 (75 — 100)
		0.10	*1.0*	*0.00013*	*0.00028*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0011*	*0.0013*	*0.0017*	*0.0022*	*0.0026*	*0.0028*	*0.0034*	*285 (245 — 330)*
K3	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (55 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (180 — 245)*
K4	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	50 (35 — 65)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*165 (115 — 213)*
K5	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	45 (30 — 55)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*147 (100 — 180)*
K6	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	77 (65 — 85)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*250 (210 — 280)*
K7	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	77 (60 — 90)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*250 (200 — 290)*
S1	E	0,10	1,0	0,0032	0,0065	0,013	0,016	0,019	0,022	0,026	0,032	0,038	0,05	0,06	0,065	0,08	50 (35 — 60)
		0.10	*1.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*165 (115 — 200)*
S2	E	0,10	1,0	0,0022	0,0044	0,009	0,011	0,013	0,015	0,018	0,022	0,026	0,034	0,04	0,044	0,055	25 (15 — 35)
		0.10	*1.0*	*0.000085*	*0.00017*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0017*	*0.0022*	*82 (50 — 115)*
S3	E	0,10	1,0	0,0014	0,0028	0,0055	0,007	0,008	0,0095	0,011	0,014	0,016	0,022	0,025	0,028	0,034	11 (7,5 — 16)
		0.10	*1.0*	*0.000055*	*0.00011*	*0.00022*	*0.00028*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0011*	*0.0013*	*35 (25 — 52)*
S11	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	110 (95— 120)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*360 (311 — 390)*
S12	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	77 (60 — 90)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*250 (190 — 290)*
S13	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	30 (20 — 40)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*100 (65 — 130)*

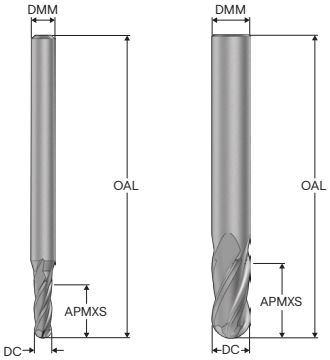
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

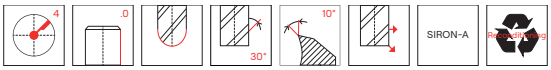
C5341

Uso generico – Universale – A testa sferica – 4 Eliche – Cilindrico





- Tolleranze:
- DMM=h5
- DC= h10
- RE= ±0,01 mm
- Riaffilatura possibile se DC è ≥Ø10



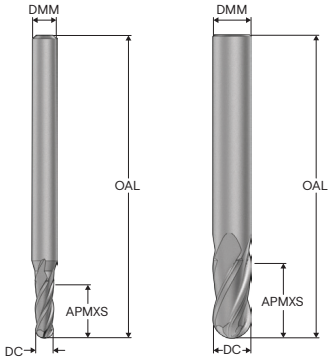
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
C5341-020F2B.0Z4	SIRA	10268568	2	F	2,0	3,0	4,0	39,0	1,0	4	Cylindrical	■
C5341-030D2B.0Z4	SIRA	10268570	2	D	3,0	3,0	6,0	39,0	1,5	4	Cylindrical	■
C5341-040D2B.0Z4	SIRA	10268573	2	D	4,0	4,0	8,0	50,0	2,0	4	Cylindrical	■
C5341-050F2B.0Z4	SIRA	10268575	2	D	5,0	6,0	10,0	57,0	2,5	4	Cylindrical	■
C5341-060D1B.0Z4	SIRA	10268577	2	D	6,0	6,0	9,0	51,0	3,0	4	Cylindrical	■
C5341-060D2B.0Z4	SIRA	10268578	2	D	6,0	6,0	12,0	57,0	3,0	4	Cylindrical	■
C5341-080D2B.0Z4	SIRA	10268580	2	D	8,0	8,0	16,0	63,0	4,0	4	Cylindrical	■
C5341-090F2B.0Z4	SIRA	10268581	2	F	9,0	10,0	22,0	72,0	4,5	4	Cylindrical	■
C5341-100D2B.0Z4	SIRA	10268582	2	D	10,0	10,0	22,0	73,0	5,0	4	Cylindrical	■
C5341-120D2B.0Z4	SIRA	10268584	2	D	12,0	12,0	25,0	74,0	6,0	4	Cylindrical	■
C5341-160D2B.0Z4	SIRA	10268586	2	D	16,0	16,0	32,0	92,0	8,0	4	Cylindrical	■
C5341-200D2B.0Z4	SIRA	10268588	2	D	20,0	20,0	35,0	104,0	10,0	4	Cylindrical	■
C5341-015F3B.0Z4	SIRA	10268567	3	F	1,5	3,0	4,5	38,0	0,75	4	Cylindrical	■
C5341-020F3B.0Z4	SIRA	10268569	3	F	2,0	3,0	6,3	38,0	1,0	4	Cylindrical	■
C5341-035F3B.0Z4	SIRA	10268572	3	F	3,5	4,0	12,0	50,0	1,5	4	Cylindrical	■
C5341-050F3B.0Z4	SIRA	10268576	3	F	5,0	6,0	16,0	51,0	2,5	4	Cylindrical	■
C5341-060D3B.0Z4	SIRA	10268579	3	D	6,0	6,0	19,0	51,0	3,0	4	Cylindrical	■
C5341-160D3B.0Z4	SIRA	10268587	3	D	16,0	16,0	50,0	115,0	8,0	4	Cylindrical	■
C5341-200D3B.0Z4	SIRA	10268589	3	D	20,0	20,0	60,0	125,0	10,0	4	Cylindrical	■
C5341-010F4B.0Z4	SIRA	10268566	4	F	1,0	3,0	4,0	39,0	0,5	4	Cylindrical	■
C5341-030D4B.0Z4	SIRA	10268571	4	D	3,0	3,0	12,0	39,0	1,5	4	Cylindrical	■
C5341-040D4B.0Z4	SIRA	10268574	4	D	4,0	4,0	14,0	51,0	2,0	4	Cylindrical	■
C5341-100D4B.0Z4	SIRA	10268583	4	D	10,0	10,0	35,0	89,0	5,0	4	Cylindrical	■
C5341-120D4B.0Z4	SIRA	10268585	4	D	12,0	12,0	50,0	100,0	6,0	4	Cylindrical	■

■ **Prodotto standard.**

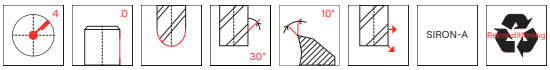
C5341

Uso generico – Universale – A testa sferica – 4 Eliche – Cilindrico – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
—Riaffilatura possibile se DC è ≥Ø.375



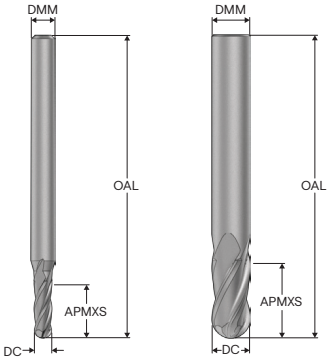
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
C5341-.500D1B.0Z4	SIRA	10268532	1	D	0.500	0.500	0.625	2.500	0.250	4	Cylindrical	■
C5341-.625D1B.0Z4	SIRA	10268539	1	D	0.625	0.625	0.750	3.000	0.313	4	Cylindrical	■
C5341-.750D1B.0Z4	SIRA	10268543	1	D	0.750	0.750	1.000	3.000	0.375	4	Cylindrical	■
C5341-.016F2B.0Z4	SIRA	10268474	2	F	0.016	0.125	0.031	1.500	0.008	4	Cylindrical	■
C5341-.047F2B.0Z4	SIRA	10268477	2	F	0.047	0.125	0.109	1.500	0.023	4	Cylindrical	■
C5341-.063F2B.0Z4	SIRA	10268479	2	F	0.063	0.125	0.125	1.500	0.031	4	Cylindrical	■
C5341-.078F2B.0Z4	SIRA	10268483	2	F	0.078	0.125	0.188	1.500	0.039	4	Cylindrical	■
C5341-.094F2B.0Z4	SIRA	10268485	2	F	0.094	0.125	0.188	1.500	0.047	4	Cylindrical	■
C5341-.125D2B.0Z4	SIRA	10268490	2	D	0.125	0.125	0.250	1.500	0.063	4	Cylindrical	■
C5341-.156F2B.0Z4	SIRA	10268497	2	F	0.156	0.188	0.313	2.000	0.078	4	Cylindrical	■
C5341-.188D2B.0Z4	SIRA	10268500	2	D	0.188	0.188	0.375	2.000	0.094	4	Cylindrical	■
C5341-.250D2B.0Z4	SIRA	10268508	2	D	0.250	0.250	0.500	2.000	0.125	4	Cylindrical	■
C5341-.313D2B.0Z4	SIRA	10268515	2	D	0.313	0.313	0.500	2.000	0.156	4	Cylindrical	■
C5341-.375D2B.0Z4	SIRA	10268521	2	D	0.375	0.375	0.625	2.000	0.188	4	Cylindrical	■
C5341-.406F2B.0Z4	SIRA	10268528	2	F	0.406	0.438	1.000	2.750	0.203	4	Cylindrical	■
C5341-.438D2B.0Z4	SIRA	10268529	2	D	0.438	0.438	1.000	2.750	0.219	4	Cylindrical	■
C5341-.500D2B.0Z4	SIRA	10268533	2	D	0.500	0.500	1.000	3.000	0.250	4	Cylindrical	■
C5341-.563D2B.0Z4	SIRA	10268538	2	D	0.563	0.563	1.125	3.500	0.281	4	Cylindrical	■
C5341-.625D2B.0Z4	SIRA	10268540	2	D	0.625	0.625	1.250	3.500	0.313	4	Cylindrical	■
C5341-.750D2B.0Z4	SIRA	10268544	2	D	0.750	0.750	1.500	4.000	0.375	4	Cylindrical	■
C5341-.875D2B.0Z4	SIRA	10268548	2	D	0.875	0.875	1.500	4.000	0.438	4	Cylindrical	■
C5341-1.000D2B.0Z4	SIRA	10268549	2	D	1.000	1.000	1.500	4.000	0.500	4	Cylindrical	■

■ **Prodotto standard.**

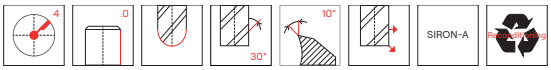
C5341

Uso generico – Universale – A testa sferica – 4 Eliche – Cilindrico – Pollici





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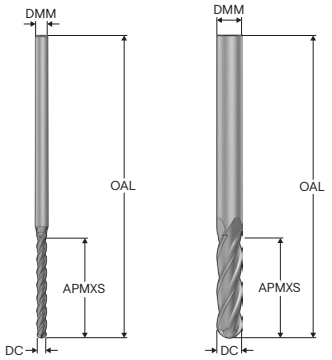
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
C5341-.031F3B.0Z4	SIRA	10268475	3	F	0.031	0.125	0.078	1.500	0.016	4	Cylindrical	■
C5341-.047F3B.0Z4	SIRA	10268478	3	F	0.047	0.125	0.125	1.500	0.023	4	Cylindrical	■
C5341-.063F3B.0Z4	SIRA	10268480	3	F	0.063	0.125	0.188	1.500	0.031	4	Cylindrical	■
C5341-.078F3B.0Z4	SIRA	10268484	3	F	0.078	0.125	0.250	1.500	0.039	4	Cylindrical	■
C5341-.094F3B.0Z4	SIRA	10268486	3	F	0.094	0.125	0.281	1.500	0.047	4	Cylindrical	■
C5341-.109F3B.0Z4	SIRA	10268489	3	F	0.109	0.125	0.375	1.500	0.055	4	Cylindrical	■
C5341-.156F3B.0Z4	SIRA	10268498	3	F	0.156	0.188	0.500	2.000	0.078	4	Cylindrical	■
C5341-.188D3B.0Z4	SIRA	10268501	3	D	0.188	0.188	0.625	2.000	0.094	4	Cylindrical	■
C5341-.203F3B.0Z4	SIRA	10268505	3	F	0.203	0.250	0.625	2.500	0.102	4	Cylindrical	■
C5341-.219F3B.0Z4	SIRA	10268506	3	F	0.219	0.250	0.625	2.500	0.109	4	Cylindrical	■
C5341-.234F3B.0Z4	SIRA	10268507	3	F	0.234	0.250	0.750	2.500	0.117	4	Cylindrical	■
C5341-.250D3B.0Z4	SIRA	10268509	3	D	0.250	0.250	0.750	2.500	0.125	4	Cylindrical	■
C5341-.281F3B.0Z4	SIRA	10268514	3	F	0.281	0.313	0.750	2.500	0.141	4	Cylindrical	■
C5341-.313D3B.0Z4	SIRA	10268516	3	D	0.313	0.313	0.813	2.500	0.156	4	Cylindrical	■
C5341-.328F3B.0Z4	SIRA	10268519	3	F	0.328	0.375	1.000	2.500	0.164	4	Cylindrical	■
C5341-.344F3B.0Z4	SIRA	10268520	3	F	0.344	0.375	1.000	2.500	0.172	4	Cylindrical	■
C5341-.375D3B.0Z4	SIRA	10268522	3	D	0.375	0.375	1.000	2.500	0.188	4	Cylindrical	■
C5341-.438D3B.0Z4	SIRA	10268530	3	D	0.438	0.438	1.000	4.000	0.219	4	Cylindrical	■
C5341-.500D3B.0Z4	SIRA	10268534	3	D	0.500	0.500	1.000	4.000	0.250	4	Cylindrical	■
C5341-.625D3B.0Z4	SIRA	10268541	3	D	0.625	0.625	2.000	6.000	0.313	4	Cylindrical	■
C5341-.750D3B.0Z4	SIRA	10268545	3	D	0.750	0.750	2.000	6.000	0.375	4	Cylindrical	■
C5341-1.000D3B.0Z4	SIRA	10268550	3	D	1.000	1.000	2.000	6.000	0.500	4	Cylindrical	■
C5341-.031F4B.0Z4	SIRA	10268476	4	F	0.031	0.125	0.094	1.500	0.016	4	Cylindrical	■
C5341-.063F4B.0Z4	SIRA	10268481	4	F	0.063	0.125	0.250	1.500	0.031	4	Cylindrical	■
C5341-.094F4B.0Z4	SIRA	10268487	4	F	0.094	0.125	0.375	1.500	0.047	4	Cylindrical	■
C5341-.125D4B.0Z4	SIRA	10268491	4	D	0.125	0.125	0.500	1.500	0.063	4	Cylindrical	■
C5341-.141F4B.0Z4	SIRA	10268496	4	F	0.141	0.188	0.500	2.000	0.070	4	Cylindrical	■
C5341-.172F4B.0Z4	SIRA	10268499	4	F	0.172	0.188	0.625	2.000	0.086	4	Cylindrical	■
C5341-.188D4B.0Z4	SIRA	10268502	4	D	0.188	0.188	1.000	3.000	0.094	4	Cylindrical	■
C5341-.250D4B.0Z4	SIRA	10268510	4	D	0.250	0.250	1.000	3.000	0.125	4	Cylindrical	■
C5341-.313D4B.0Z4	SIRA	10268517	4	D	0.313	0.313	1.000	3.000	0.156	4	Cylindrical	■
C5341-.375D4B.0Z4	SIRA	10268523	4	D	0.375	0.375	1.000	3.000	0.188	4	Cylindrical	■
C5341-.500D4B.0Z4	SIRA	10268535	4	D	0.500	0.500	1.500	6.000	0.250	4	Cylindrical	■
C5341-.750D4B.0Z4	SIRA	10268546	4	D	0.750	0.750	3.000	6.000	0.375	4	Cylindrical	■
C5341-1.000D4B.0Z4	SIRA	10268551	4	D	1.000	1.000	3.000	6.000	0.500	4	Cylindrical	■

■ **Prodotto standard.**

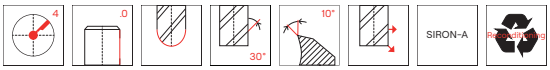
C5341

Uso generico – Universale – A testa sferica – 4 Eliche – Cilindrico – Pollici





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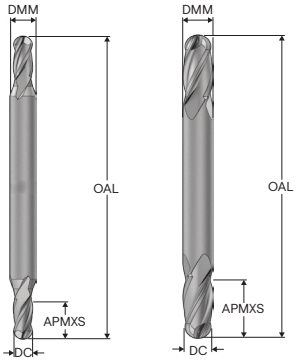
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
C5341-.125D5B.0Z4	SIRA	10268492	5	D	0.125	0.125	0.625	2.000	0.063	4	Cylindrical	■
C5341-.188D5B.0Z4	SIRA	10268503	5	D	0.188	0.188	1.000	4.000	0.094	4	Cylindrical	■
C5341-.250D5B.0Z4	SIRA	10268511	5	D	0.250	0.250	1.000	4.000	0.125	4	Cylindrical	■
C5341-.375D5B.0Z4	SIRA	10268524	5	D	0.375	0.375	1.000	4.000	0.188	4	Cylindrical	■
C5341-.500D5B.0Z4	SIRA	10268536	5	D	0.500	0.500	2.000	4.000	0.250	4	Cylindrical	■
C5341-.625D5B.0Z4	SIRA	10268542	5	D	0.625	0.625	3.000	6.000	0.313	4	Cylindrical	■
C5341-.750D5B.0Z4	SIRA	10268547	5	D	0.750	0.750	4.000	6.000	0.375	4	Cylindrical	■
C5341-1.000D5B.0Z4	SIRA	10268552	5	D	1.000	1.000	4.000	7.000	0.500	4	Cylindrical	■
C5341-.125D6B.0Z4	SIRA	10268493	6	D	0.125	0.125	0.750	3.000	0.063	4	Cylindrical	■
C5341-.188D6B.0Z4	SIRA	10268504	6	D	0.188	0.188	1.125	3.000	0.094	4	Cylindrical	■
C5341-.250D6B.0Z4	SIRA	10268512	6	D	0.250	0.250	1.500	4.000	0.125	4	Cylindrical	■
C5341-.313D6B.0Z4	SIRA	10268518	6	D	0.313	0.313	1.500	6.000	0.156	4	Cylindrical	■
C5341-.375D6B.0Z4	SIRA	10268525	6	D	0.375	0.375	1.500	6.000	0.188	4	Cylindrical	■
C5341-.500D6B.0Z4	SIRA	10268537	6	D	0.500	0.500	3.000	6.000	0.250	4	Cylindrical	■
C5341-.125D7B.0Z4	SIRA	10268494	7	D	0.125	0.125	1.000	3.000	0.063	4	Cylindrical	■
C5341-.250D7B.0Z4	SIRA	10268513	7	D	0.250	0.250	1.500	6.000	0.125	4	Cylindrical	■
C5341-.375D7B.0Z4	SIRA	10268526	7	D	0.375	0.375	2.000	4.000	0.188	4	Cylindrical	■
C5341-.063F8B.0Z4	SIRA	10268482	8	F	0.063	0.125	1.000	3.000	0.031	4	Cylindrical	■
C5341-.094F8B.0Z4	SIRA	10268488	8	F	0.094	0.125	1.000	3.000	0.047	4	Cylindrical	■
C5341-.125D8B.0Z4	SIRA	10268495	8	D	0.125	0.125	1.000	4.000	0.063	4	Cylindrical	■
C5341-.375D8B.0Z4	SIRA	10268527	8	D	0.375	0.375	3.000	6.000	0.188	4	Cylindrical	■

■ **Prodotto standard.**

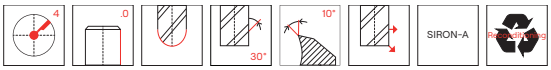
C5341

Uso generico – Universale – A testa sferica – 4 Eliche – Cilindrico – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
—Fresa integrale bilaterale
—Riaffilatura possibile se DC è ≥Ø.375



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
C5341-.500D1B.0Z4D	SIRA	10268565	1	D	0.500	0.500	0.625	3.000	0.250	4	Cylindrical	■
C5341-.031F2B.0Z4D	SIRA	10268553	2	F	0.031	0.125	0.063	1.500	0.016	4	Cylindrical	■
C5341-.047F2B.0Z4D	SIRA	10268554	2	F	0.047	0.125	0.094	1.500	0.023	4	Cylindrical	■
C5341-.063F2B.0Z4D	SIRA	10268555	2	F	0.063	0.125	0.125	1.500	0.031	4	Cylindrical	■
C5341-.078F2B.0Z4D	SIRA	10268556	2	F	0.078	0.125	0.125	1.500	0.039	4	Cylindrical	■
C5341-.094F2B.0Z4D	SIRA	10268557	2	F	0.094	0.125	0.188	1.500	0.047	4	Cylindrical	■
C5341-.125D2B.0Z4D	SIRA	10268558	2	D	0.125	0.125	0.250	1.500	0.063	4	Cylindrical	■
C5341-.156F2B.0Z4D	SIRA	10268559	2	F	0.156	0.188	0.313	2.000	0.078	4	Cylindrical	■
C5341-.172F2B.0Z4D	SIRA	10268560	2	F	0.172	0.188	0.313	2.000	0.086	4	Cylindrical	■
C5341-.188D2B.0Z4D	SIRA	10268561	2	D	0.188	0.188	0.375	2.000	0.094	4	Cylindrical	■
C5341-.250D2B.0Z4D	SIRA	10268562	2	D	0.250	0.250	0.500	2.500	0.125	4	Cylindrical	■
C5341-.313D2B.0Z4D	SIRA	10268563	2	D	0.313	0.313	0.500	2.500	0.156	4	Cylindrical	■
C5341-.375D2B.0Z4D	SIRA	10268564	2	D	0.375	0.375	0.563	2.500	0.188	4	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – C5341 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z														v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	16	20	
P1	E	0,10	1,0	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,024	0,032	0,036	0,04	0,048	0,06	0,07	150 (135 — 165)
		0.10	*1.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0014*	*0.0016*	*0.0019*	*0.0024*	*0.0028*	*490 (440— 540)*
P2	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	58 (45— 70)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*190 (147 — 230)*
P3	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	85 (70 — 95)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*279 (246 — 312)*
P4	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	100 (90 — 110)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*330 (295 — 360)*
P5	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	68 (50 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*223 (165 — 245)*
P6	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	87 (77 — 100)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*285 (250 — 330)*
P7	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	65 (55 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*213 (180 — 245)*
P8	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	65 (50 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*213 (165 — 245)*
P11	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	85 (70 — 95)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*280 (230 — 310)*
P12	E	0,10	1,0	0,0025	0,0038	0,005	0,0075	0,009	0,01	0,013	0,015	0,02	0,022	0,025	0,03	0,038	0,044	55 (45— 65)
		0.10	*1.0*	*0.00010*	*0.00015*	*0.00020*	*0.00030*	*0.00036*	*0.00040*	*0.00050*	*0.00060*	*0.00080*	*0.00085*	*0.0010*	*0.0012*	*0.0015*	*0.0017*	*180 (147 — 213)*
M1	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	93 (83 — 100)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*305 (270 — 360)*
M2	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	60 (50 — 70)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*200 (165 — 230)*
M3	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	55 (45 —65)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*180 (147 — 213)*
M4	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	45 (35 — 55)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*147 (115 — 180)*
M5	E	0,10	1,0	0,0034	0,005	0,0065	0,01	0,012	0,013	0,017	0,02	0,026	0,03	0,034	0,04	0,05	0,055	35 (20 — 45)
		0.10	*1.0*	*0.00013*	*0.00020*	*0.00026*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0013*	*0.0016*	*0.0020*	*0.0022*	*114 (65 — 147)*
K1	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	80 (70 — 90)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*260 (230 — 290)*
K2	E	0,10	1,0	0,0044	0,0065	0,0085	0,013	0,015	0,017	0,022	0,026	0,034	0,04	0,044	0,05	0,065	0,075	87 (75 — 100)
		0.10	*1.0*	*0.00017*	*0.00026*	*0.00034*	*0.00050*	*0.00060*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*285 (245 — 330)*
K3	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	65 (55 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*213 (180 — 245)*
K4	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	50 (35 — 65)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*165 (115 — 213)*
K5	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	45 (30 — 55)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*147 (100 — 180)*
K6	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	77 (65 — 85)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*250 (210 — 280)*
K7	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	77 (60 — 90)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*250 (200 — 290)*
S1	E	0,10	1,0	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,024	0,032	0,036	0,04	0,048	0,06	0,07	50 (35 — 60)
		0.10	*1.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0014*	*0.0016*	*0.0019*	*0.0024*	*0.0028*	*165 (115 — 200)*
S2	E	0,10	1,0	0,0028	0,004	0,0055	0,008	0,0095	0,011	0,014	0,016	0,022	0,025	0,028	0,032	0,04	0,046	25 (15 — 35)
		0.10	*1.0*	*0.00011*	*0.00016*	*0.00022*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0011*	*0.0013*	*0.0016*	*0.0018*	*82 (50 — 115)*
S3	E	0,10	1,0	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,025	0,03	11 (7,5 — 16)
		0.10	*1.0*	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*35 (25 — 52)*
S11	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	110 (95— 120)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*360 (311 — 390)*
S12	E	0,10	1,0	0,0025	0,0038	0,005	0,0075	0,009	0,01	0,013	0,015	0,02	0,022	0,025	0,03	0,038	0,044	77 (60 — 90)
		0.10	*1.0*	*0.00010*	*0.00015*	*0.00020*	*0.00030*	*0.00036*	*0.00040*	*0.00050*	*0.00060*	*0.00080*	*0.00085*	*0.0010*	*0.0012*	*0.0015*	*0.0017*	*250 (190 — 290)*
S13	E	0,10	1,0	0,0025	0,0038	0,005	0,0075	0,009	0,01	0,013	0,015	0,02	0,022	0,025	0,03	0,038	0,044	30 (20 — 40)
		0.10	*1.0*	*0.00010*	*0.00015*	*0.00020*	*0.00030*	*0.00036*	*0.00040*	*0.00050*	*0.00060*	*0.00080*	*0.00085*	*0.0010*	*0.0012*	*0.0015*	*0.0017*	*100 (65 — 130)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – C5341 Contornatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,10	1,0	0,0032	0,0065	0,013	0,016	0,019	0,022	0,026	0,032	0,038	0,05	0,06	0,065	0,08	150 (135 — 165)
		0.10	*1.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*490 (440— 540)*
P2	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	58 (45— 70)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*190 (147 — 230)*
P3	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	85 (70 — 95)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*279 (246 — 312)*
P4	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	100 (90 — 110)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*330 (295 — 360)*
P5	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	68 (50 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*223 (165 — 245)*
P6	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	87 (77 — 100)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*285 (250 — 330)*
P7	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (55 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (180 — 245)*
P8	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (50 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (165 — 245)*
P11	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	85 (70 — 95)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*280 (230 — 310)*
P12	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	55 (45— 65)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*180 (147 — 213)*
M1	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	93 (83 — 100)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*305 (270 — 360)*
M2	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	60 (50 — 70)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*200 (165 — 230)*
M3	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	55 (45 —65)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*180 (147 — 213)*
M4	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	45 (35 — 55)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*147 (115 — 180)*
M5	E	0,10	1,0	0,0026	0,0055	0,011	0,013	0,016	0,019	0,022	0,026	0,032	0,042	0,048	0,055	0,065	35 (20 — 45)
		0.10	*1.0*	*0.00010*	*0.00022*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0019*	*0.0022*	*0.0026*	*114 (65 — 147)*
K1	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	80 (70 — 90)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*260 (230 — 290)*
K2	E	0,10	1,0	0,0034	0,007	0,014	0,017	0,02	0,024	0,028	0,034	0,042	0,055	0,065	0,07	0,085	87 (75 — 100)
		0.10	*1.0*	*0.00013*	*0.00028*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0011*	*0.0013*	*0.0017*	*0.0022*	*0.0026*	*0.0028*	*0.0034*	*285 (245 — 330)*
K3	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (55 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (180 — 245)*
K4	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	50 (35 — 65)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*165 (115 — 213)*
K5	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	45 (30 — 55)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*147 (100 — 180)*
K6	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	77 (65 — 85)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*250 (210 — 280)*
K7	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	77 (60 — 90)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*250 (200 — 290)*
S1	E	0,10	1,0	0,0032	0,0065	0,013	0,016	0,019	0,022	0,026	0,032	0,038	0,05	0,06	0,065	0,08	50 (35 — 60)
		0.10	*1.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*165 (115 — 200)*
S2	E	0,10	1,0	0,0022	0,0044	0,009	0,011	0,013	0,015	0,018	0,022	0,026	0,034	0,04	0,044	0,055	25 (15 — 35)
		0.10	*1.0*	*0.000085*	*0.00017*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0017*	*0.0022*	*82 (50 — 115)*
S3	E	0,10	1,0	0,0014	0,0028	0,0055	0,007	0,008	0,0095	0,011	0,014	0,016	0,022	0,025	0,028	0,034	11 (7,5 — 16)
		0.10	*1.0*	*0.000055*	*0.00011*	*0.00022*	*0.00028*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0011*	*0.0013*	*35 (25 — 52)*
S11	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	110 (95— 120)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*360 (311 — 390)*
S12	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	77 (60 — 90)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*250 (190 — 290)*
S13	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	30 (20 — 40)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*100 (65 — 130)*

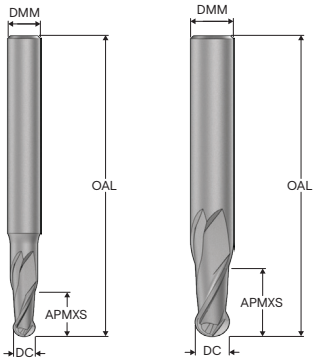
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

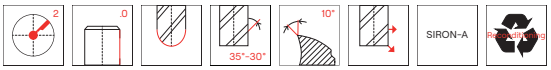
JSB512

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





F D



- 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	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JSB512020F2B.0Z2	SIRA	10053561	2	F	2,0	3,0	3,0	40,0	1,0	2	Cylindrical	■
JSB512030D2B.0Z2	SIRA	10053562	2	D	3,0	3,0	5,0	40,0	1,5	2	Cylindrical	■
JSB512040D2B.0Z2	SIRA	10053563	2	D	4,0	4,0	6,0	50,0	2,0	2	Cylindrical	■
JSB512050F2B.0Z2	SIRA	10053564	2	F	5,0	6,0	8,0	57,0	2,5	2	Cylindrical	■
JSB512060D2B.0Z2	SIRA	10053565	2	D	6,0	6,0	9,0	57,0	3,0	2	Cylindrical	■
JSB512080D2B.0Z2	SIRA	10053566	2	D	8,0	8,0	12,0	63,0	4,0	2	Cylindrical	■
JSB512100D2B.0Z2	SIRA	10053567	2	D	10,0	10,0	15,0	72,0	5,0	2	Cylindrical	■
JSB512120D2B.0Z2	SIRA	10053568	2	D	12,0	12,0	18,0	83,0	6,0	2	Cylindrical	■

■ **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)*

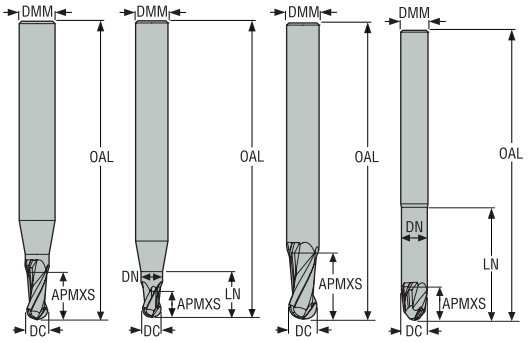
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

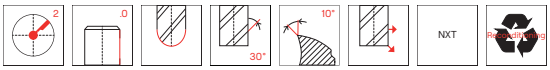
JS532

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





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



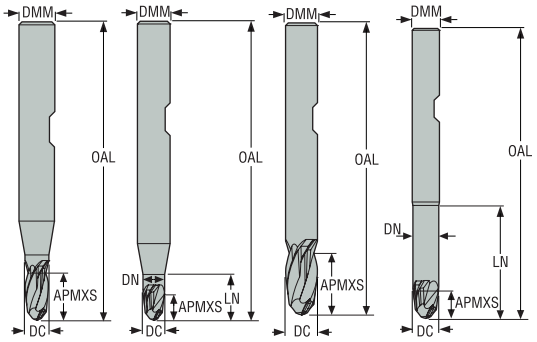
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS532010F1B.0Z2-NXT	02928193	1	F	1,0	3,0	2,0	38,0	–	–	0,5	2	Cylindrical	■
JS532015F1B.0Z2-NXT	02928194	1	F	1,5	3,0	3,0	38,0	–	–	0,75	2	Cylindrical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

■ **Prodotto standard.**

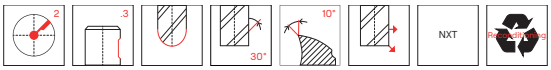
JS532

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

□ 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 699 - 707

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)*

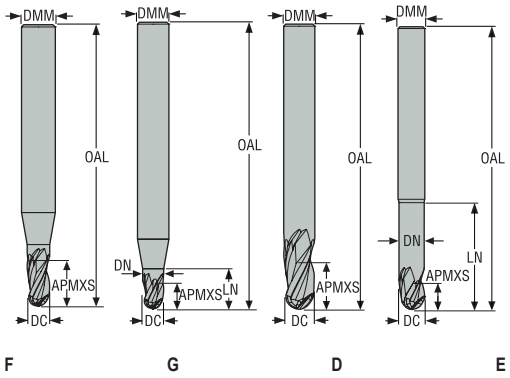
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

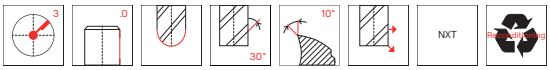
JS533

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





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



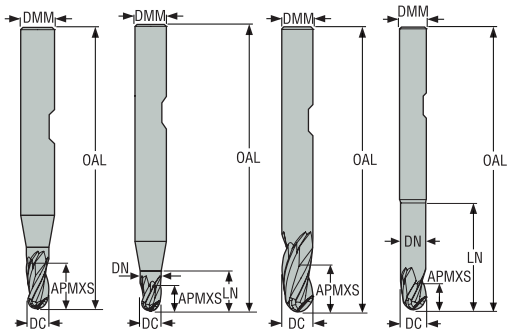
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS533010F1B.0Z3-NXT	02928284	1	F	1,0	3,0	2,0	38,0	–	–	0,5	3	Cylindrical	■
JS533015F1B.0Z3-NXT	02928286	1	F	1,5	3,0	3,0	38,0	–	–	0,75	3	Cylindrical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

■ **Prodotto standard.**

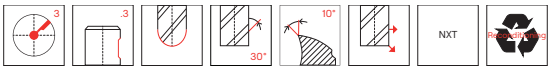
JS533

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	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS533040F1B.3Z3-NXT	02928323	1	F	4,0	6,0	8,0	57,0	–	–	2,0	3	Weldon	☐
JS533050F1B.3Z3-NXT	02928325	1	F	5,0	6,0	10,0	57,0	–	–	2,5	3	Weldon	☐
JS533060D1B.3Z3-NXT	02928326	1	D	6,0	6,0	12,0	57,0	–	–	3,0	3	Weldon	☐
JS533080D1B.3Z3-NXT	02928328	1	D	8,0	8,0	16,0	63,0	–	–	4,0	3	Weldon	☐
JS533100D1B.3Z3-NXT	02928330	1	D	10,0	10,0	20,0	72,0	–	–	5,0	3	Weldon	☐
JS533120D1B.3Z3-NXT	02928332	1	D	12,0	12,0	24,0	83,0	–	–	6,0	3	Weldon	☐
JS533160D1B.3Z3-NXT	02928334	1	D	16,0	16,0	32,0	109,0	–	–	8,0	3	Weldon	☐
JS533200D1B.3Z3-NXT	02928336	1	D	20,0	20,0	40,0	125,0	–	–	10,0	3	Weldon	☐
JS533040G2B.3Z3-NXT	02928324	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	3	Weldon	☐
JS533050G2B.3Z3-NXT	02928341	2	G	5,0	6,0	5,0	57,0	15,0	4,8	2,5	3	Weldon	☐
JS533060E2B.3Z3-NXT	02928327	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	3	Weldon	☐
JS533080E2B.3Z3-NXT	02928329	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	3	Weldon	☐
JS533100E2B.3Z3-NXT	02928331	2	E	10,0	10,0	10,0	89,0	40,0	9,5	5,0	3	Weldon	☐
JS533120E2B.3Z3-NXT	02928333	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	3	Weldon	☐
JS533160E2B.3Z3-NXT	02928335	2	E	16,0	16,0	16,0	122,0	70,0	15,2	8,0	3	Weldon	☐

☐ 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 699 - 707

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)*

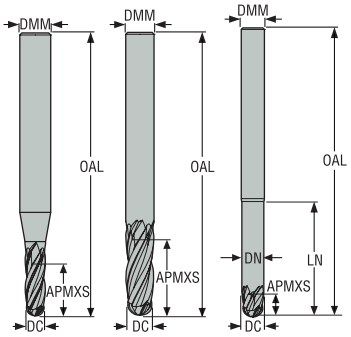
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

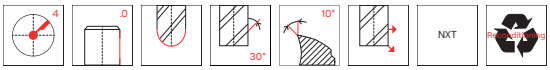
JS534

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





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



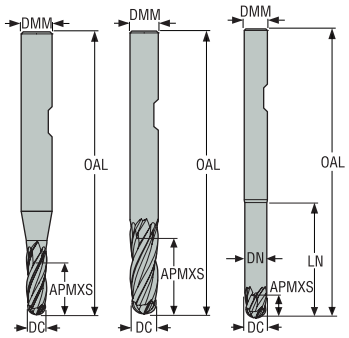
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS534020F1B.0Z4-NXT	02928366	1	F	2,0	3,0	6,0	38,0	–	–	1,0	4	Cylindrical	■
JS534030D1B.0Z4-NXT	02928367	1	D	3,0	3,0	9,0	38,0	–	–	1,5	4	Cylindrical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

■ **Prodotto standard.**

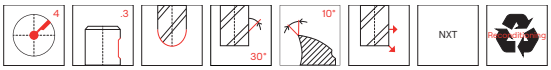
JS534

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	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS534040F1B.3Z4-NXT	02928390	1	F	4,0	6,0	12,0	57,0	–	–	2,0	4	Weldon	□
JS534050F1B.3Z4-NXT	02928392	1	F	5,0	6,0	15,0	57,0	–	–	2,5	4	Weldon	□
JS534060D1B.3Z4-NXT	02928394	1	D	6,0	6,0	18,0	57,0	–	–	3,0	4	Weldon	□
JS534080D1B.3Z4-NXT	02928397	1	D	8,0	8,0	24,0	69,0	–	–	4,0	4	Weldon	□
JS534100D1B.3Z4-NXT	02928400	1	D	10,0	10,0	30,0	82,0	–	–	5,0	4	Weldon	□
JS534120D1B.3Z4-NXT	02928403	1	D	12,0	12,0	36,0	100,0	–	–	6,0	4	Weldon	□
JS534160D1B.3Z4-NXT	02928406	1	D	16,0	16,0	48,0	110,0	–	–	8,0	4	Weldon	□
JS534200D1B.3Z4-NXT	02928409	1	D	20,0	20,0	60,0	125,0	–	–	10,0	4	Weldon	□
JS534040F2B.3Z4-NXT	02928391	2	F	4,0	6,0	20,0	63,0	–	–	2,0	4	Weldon	□
JS534050F2B.3Z4-NXT	02928393	2	F	5,0	6,0	25,0	75,0	–	–	2,5	4	Weldon	□
JS534060D2B.3Z4-NXT	02928395	2	D	6,0	6,0	30,0	75,0	–	–	3,0	4	Weldon	□
JS534080D2B.3Z4-NXT	02928398	2	D	8,0	8,0	40,0	80,0	–	–	4,0	4	Weldon	□
JS534100D2B.3Z4-NXT	02928401	2	D	10,0	10,0	50,0	100,0	–	–	5,0	4	Weldon	□
JS534120D2B.3Z4-NXT	02928404	2	D	12,0	12,0	60,0	125,0	–	–	6,0	4	Weldon	□
JS534160D2B.3Z4-NXT	02928407	2	D	16,0	16,0	80,0	130,0	–	–	8,0	4	Weldon	□
JS534060E3B.3Z4-NXT	02928396	3	E	6,0	6,0	6,0	75,0	30,0	5,7	3,0	4	Weldon	□
JS534080E3B.3Z4-NXT	02928399	3	E	8,0	8,0	8,0	80,0	40,0	7,6	4,0	4	Weldon	□
JS534100E3B.3Z4-NXT	02928402	3	E	10,0	10,0	10,0	100,0	50,0	9,7	5,0	4	Weldon	□
JS534120E3B.3Z4-NXT	02928405	3	E	12,0	12,0	12,0	125,0	60,0	11,4	6,0	4	Weldon	□
JS534160E3B.3Z4-NXT	02928408	3	E	16,0	16,0	16,0	130,0	80,0	15,2	8,0	4	Weldon	□
JS534200E3B.3Z4-NXT	02928410	3	E	20,0	20,0	20,0	150,0	100,0	19,0	10,0	4	Weldon	□

□ 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 699 - 707

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

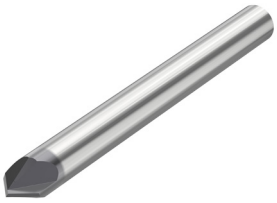
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	1025 (910 — 1100) *3375 (3000 — 3600)*
N2	E	0.0300 *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)*

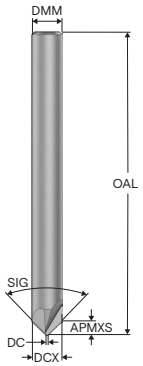
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

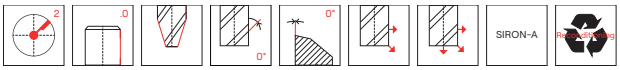
C5021

Uso generico – Universale – Smusso – 2-4 Eliche – Cilindrico – Pollici





– Tolleranze:
– DMM=-.0001"/-.0004"
– SIG= ±1°
– Riaffilatura possibile se DC è ≥Ø.375



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch				
C5021-.250N1S.0Z2T30	SIRA	10268641	1	N	0.250	0.035	0.250	0.186	2.500	30,0	2	Cylindrical	■
C5021-.250N1S.0Z2T45	SIRA	10268644	1	N	0.250	0.035	0.250	0.108	2.500	45,0	2	Cylindrical	■
C5021-.375N1S.0Z2T30	SIRA	10268642	1	N	0.375	0.040	0.375	0.290	2.500	30,0	2	Cylindrical	■
C5021-.375N1S.0Z2T45	SIRA	10268645	1	N	0.375	0.040	0.375	0.168	2.500	45,0	2	Cylindrical	■
C5021-.500N1S.0Z2T30	SIRA	10268643	1	N	0.500	0.045	0.500	0.186	3.000	30,0	2	Cylindrical	■
C5021-.500N1S.0Z2T45	SIRA	10268646	1	N	0.500	0.045	0.500	0.228	3.000	45,0	2	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – C5021 Smussatura – Pollici

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				1/4	3/8	1/2	
P1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	205 (160 — 230) *670 (530 — 750)*
P2	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	195 (160 — 230) *640 (530 — 750)*
P3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	165 (130 — 180) *540 (430 — 590)*
P4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	140 (120 — 160) *460 (400 — 520)*
P5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	135 (120 — 170) *445 (400 — 550)*
P6	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	160 (120 — 170) *520 (400 — 550)*
P7	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	145 (120 — 180) *475 (400 — 590)*
P8	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
P11	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	85 (69 — 110) *280 (230 — 360)*
P12	E	0,02 *0.02*	0,3 *0.3*	0,032 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	60 (49 — 91) *195 (170 — 290)*
M1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,06 *0.0024*	0,065 *0.0026*	120 (110 — 150) *395 (370 — 490)*
M2	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	80 (65 — 100) *260 (220 — 320)*
M3	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	75 (59 — 100) *245 (200 — 320)*
M4	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	43 (30 — 59) *140 (99 — 190)*
M5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,06 *0.0024*	36 (19 — 55) *120 (63 — 180)*
K1	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	195 (160 — 240) *640 (530 — 780)*
K2	E	0,02 *0.02*	0,3 *0.3*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	170 (150 — 200) *560 (500 — 650)*
K3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	145 (130 — 160) *475 (430 — 520)*
K4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	130 (110 — 150) *425 (370 — 490)*
K5	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,048 *0.0019*	0,055 *0.0022*	85 (65 — 110) *280 (220 — 360)*
K6	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	130 (120 — 160) *425 (400 — 520)*
K7	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	110 (94 — 140) *360 (310 — 450)*

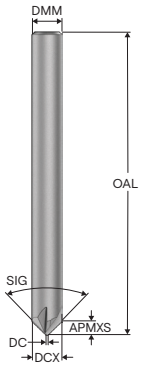
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

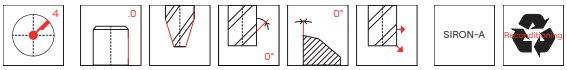
C5041

Uso generico – Universale – Smusso – 2-4 Eliche – Cilindrico – Pollici





– Tolleranze:
– DMM=-.0001"/-.0004"
– SIG= ±1°
– Riaffilatura possibile se DMM è ≥Ø.375"



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch				
C5041-.250N1S.0Z4T30	SIRA	10268647	1	N	0.250	0.035	0.250	0.186	2.500	30,0	4	Cylindrical	■
C5041-.250N1S.0Z4T45	SIRA	10268652	1	N	0.250	0.035	0.250	0.108	2.500	45,0	4	Cylindrical	■
C5041-.375N1S.0Z4T30	SIRA	10268648	1	N	0.375	0.040	0.375	0.290	2.500	30,0	4	Cylindrical	■
C5041-.375N1S.0Z4T45	SIRA	10268653	1	N	0.375	0.040	0.375	0.168	2.500	45,0	4	Cylindrical	■
C5041-.500N1S.0Z4T30	SIRA	10268649	1	N	0.500	0.045	0.500	0.394	3.000	30,0	4	Cylindrical	■
C5041-.500N1S.0Z4T45	SIRA	10268654	1	N	0.500	0.045	0.500	0.228	3.000	45,0	4	Cylindrical	■
C5041-.750N1S.0Z4T30	SIRA	10268651	1	N	0.750	0.055	0.750	0.602	3.000	30,0	4	Cylindrical	■
C5041-.750N1S.0Z4T45	SIRA	10268655	1	N	0.750	0.055	0.750	0.348	3.000	45,0	4	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – C5041 Smussatura – Pollici

SMG		a_e/DCX	a_p/DCX	f_z				v_c
				1/4	3/8	1/2	3/4	
P1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,08 *0.0032*	205 (160 — 230) *670 (530 — 750)*
P2	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	195 (160 — 230) *640 (530 — 750)*
P3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	165 (130 — 180) *540 (430 — 590)*
P4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	135 (120 — 170) *445 (400 — 550)*
P6	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	160 (120 — 170) *520 (400 — 550)*
P7	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	145 (120 — 180) *475 (400 — 590)*
P8	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	135 (120 — 150) *445 (400 — 490)*
P11	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	85 (69 — 110) *280 (230 — 360)*
P12	E	0,02 *0.02*	0,3 *0.3*	0,032 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	0,05 *0.0020*	60 (49 — 91) *195 (170 — 290)*
M1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,06 *0.0024*	0,065 *0.0026*	0,08 *0.0032*	120 (110 — 150) *395 (370 — 490)*
M2	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	80 (65 — 100) *260 (220 — 320)*
M3	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,08 *0.0032*	75 (59 — 100) *245 (200 — 320)*
M4	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,08 *0.0032*	43 (30 — 59) *140 (99 — 190)*
M5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,06 *0.0024*	0,07 *0.0028*	36 (19 — 55) *120 (63 — 180)*
K1	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	195 (160 — 240) *640 (530 — 780)*
K2	E	0,02 *0.02*	0,3 *0.3*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	170 (150 — 200) *560 (500 — 650)*
K3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	145 (130 — 160) *475 (430 — 520)*
K4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	130 (110 — 150) *425 (370 — 490)*
K5	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,048 *0.0019*	0,055 *0.0022*	0,065 *0.0026*	85 (65 — 110) *280 (220 — 360)*
K6	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	130 (120 — 160) *425 (400 — 520)*
K7	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	110 (94 — 140) *360 (310 — 450)*

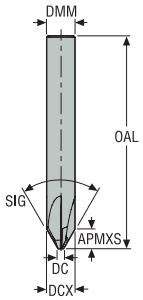
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

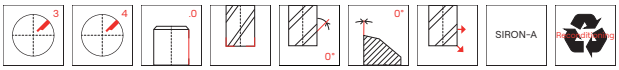
Uso generico – Universale – Smusso – 3-4 Eliche – Cilindrico





N

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



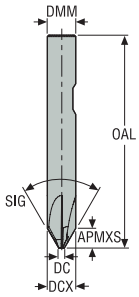
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
JS506030N2CZ3.0-SIRA	02881622	2	N	3,0	0,6	3,0	2,0	50,0	30,0	3	Cylindrical	■
JS506040N2CZ3.0-SIRA	02881623	2	N	4,0	0,8	4,0	2,7	50,0	30,0	3	Cylindrical	■
JS506060N2CZ4.0-SIRA	02881624	2	N	6,0	1,2	6,0	4,1	57,0	30,0	4	Cylindrical	■
JS506080N2CZ4.0-SIRA	02881626	2	N	8,0	1,6	8,0	5,5	63,0	30,0	4	Cylindrical	■
JS506100N2CZ4.0-SIRA	02881628	2	N	10,0	2,0	10,0	6,9	72,0	30,0	4	Cylindrical	■
JS506120N2CZ4.0-SIRA	02881630	2	N	12,0	2,4	12,0	8,3	83,0	30,0	4	Cylindrical	■

■ **Prodotto standard.**

JS506

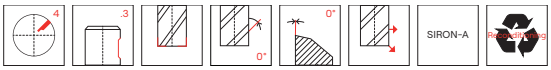
Uso generico – Universale – Smusso – 3-4 Eliche – Weldon





N

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



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
JS506060N2CZ4.3-SIRA	02881625	2	N	6,0	1,2	6,0	4,1	57,0	30,0	4	Weldon	■
JS506080N2CZ4.3-SIRA	02881627	2	N	8,0	1,6	8,0	5,5	63,0	30,0	4	Weldon	■
JS506100N2CZ4.3-SIRA	02881629	2	N	10,0	2,0	10,0	6,9	72,0	30,0	4	Weldon	■
JS506120N2CZ4.3-SIRA	02881631	2	N	12,0	2,4	12,0	8,3	83,0	30,0	4	Weldon	■

■ **Prodotto standard.**

Parametri di taglio – JS506 Smussatura

SMG		a_e/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	190 (170 — 210) *620 (560 — 680)*
P2	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	180 (160 — 200) *590 (530 — 650)*
P3	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	155 (140 — 170) *510 (460 — 550)*
P4	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,032 *0.0013*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	140 (130 — 150) *460 (430 — 490)*
P5	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	150 (130 — 160) *490 (430 — 520)*
P7	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	140 (130 — 160) *460 (430 — 520)*
P8	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	130 (120 — 140) *425 (400 — 450)*
P11	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	95 (76 — 110) *310 (250 — 360)*
P12	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,016 *0.00065*	0,022 *0.00085*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	60 (47 — 69) *195 (160 — 220)*
M1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	110 (87 — 120) *360 (290 — 390)*
M2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	90 (72 — 100) *295 (240 — 320)*
M3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	60 (41 — 75) *195 (140 — 240)*
M4	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	44 (31 — 57) *145 (110 — 180)*
M5	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	37 (26 — 48) *120 (86 — 150)*
K1	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	185 (160 — 200) *610 (530 — 650)*
K2	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	160 (140 — 180) *520 (460 — 590)*
K3	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
K4	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	130 (120 — 140) *425 (400 — 450)*
K5	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	80 (69 — 89) *260 (230 — 290)*
K6	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	115 (100 — 130) *375 (330 — 420)*
K7	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	100 (88 — 110) *330 (290 — 360)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	445 (410 — 480) *1450 (1400 — 1500)*
N2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	285 (260 — 310) *940 (860 — 1000)*
N3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	190 (180 — 200) *620 (600 — 650)*
N11	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	255 (230 — 270) *840 (760 — 880)*
S1	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,034 *0.0013*	0,044 *0.0017*	0,05 *0.0020*	42 (14 — 69) *140 (46 — 220)*
S2	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,034 *0.0013*	0,044 *0.0017*	0,05 *0.0020*	34 (12 — 56) *110 (40 — 180)*
S3	E	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	29 (9,8 — 48) *95 (33 — 150)*
S11	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	85 (64 — 100) *280 (210 — 320)*
S12	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	65 (49 — 84) *215 (170 — 270)*
S13	E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	55 (39 — 66) *180 (130 — 210)*
H5	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	65 (47 — 87) *215 (160 — 280)*
H8	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,03 *0.0012*	0,036 *0.0014*	70 (47 — 88) *230 (160 — 280)*
H11	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	85 (60 — 110) *280 (200 — 360)*
H12	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,03 *0.0012*	0,036 *0.0014*	80 (55 — 100) *260 (190 — 320)*
H21	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,03 *0.0012*	0,036 *0.0014*	70 (47 — 88) *230 (160 — 280)*
TS1	A/D	0,02 *0.02*	0,3 *0.3*	0,03 *0.0012*	0,04 *0.0016*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0040*	0,12 *0.0048*	550 (500 — 600) *1800 (1700 — 1900)*
TP1	A/D	0,02 *0.02*	0,3 *0.3*	0,03 *0.0012*	0,04 *0.0016*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0040*	0,12 *0.0048*	550 (500 — 600) *1800 (1700 — 1900)*
GR1	A/D	0,02 *0.02*	0,3 *0.3*	0,03 *0.0012*	0,04 *0.0016*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0040*	0,12 *0.0048*	550 (500 — 600) *1800 (1700 — 1900)*

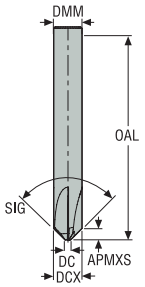
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

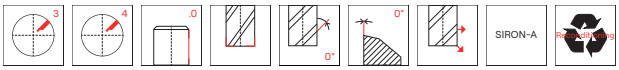
Uso generico – Universale – Smusso – 3-4 Eliche – Cilindrico





N

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



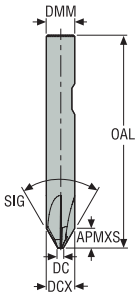
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
JS509030N2CZ3.0-SIRA	02881634	2	N	3,0	0,6	3,0	1,2	50,0	45,0	3	Cylindrical	■
JS509040N2CZ3.0-SIRA	02881635	2	N	4,0	0,8	4,0	1,6	50,0	45,0	3	Cylindrical	■
JS509060N2CZ4.0-SIRA	02881636	2	N	6,0	1,2	6,0	2,4	57,0	45,0	4	Cylindrical	■
JS509080N2CZ4.0-SIRA	02881638	2	N	8,0	1,6	8,0	3,2	63,0	45,0	4	Cylindrical	■
JS509100N2CZ4.0-SIRA	02881640	2	N	10,0	2,0	10,0	4,0	72,0	45,0	4	Cylindrical	■
JS509120N2CZ4.0-SIRA	02881642	2	N	12,0	2,4	12,0	4,8	83,0	45,0	4	Cylindrical	■

■ **Prodotto standard.**

JS509

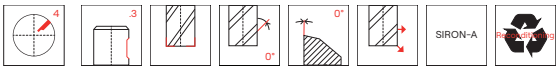
Uso generico – Universale – Smusso – 3-4 Eliche – Weldon





N

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



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
JS509060N2CZ4.3-SIRA	02881637	2	N	6,0	1,2	6,0	2,4	57,0	45,0	4	Weldon	■
JS509080N2CZ4.3-SIRA	02881639	2	N	8,0	1,6	8,0	3,2	63,0	45,0	4	Weldon	■
JS509100N2CZ4.3-SIRA	02881641	2	N	10,0	2,0	10,0	4,0	72,0	45,0	4	Weldon	■
JS509120N2CZ4.3-SIRA	02881643	2	N	12,0	2,4	12,0	4,8	83,0	45,0	4	Weldon	■

■ **Prodotto standard.**

Parametri di taglio – JS509 Smussatura

SMG		a_e/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	200 (180 — 220) *660 (600 — 720)*
P2	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	165 (150 — 180) *540 (500 — 590)*
P4	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,032 *0.0013*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	140 (130 — 150) *460 (430 — 490)*
P6	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	160 (140 — 170) *520 (460 — 550)*
P7	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	150 (130 — 160) *490 (430 — 520)*
P8	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	140 (130 — 150) *460 (430 — 490)*
P11	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	100 (79 — 110) *330 (260 — 360)*
P12	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,016 *0.00065*	0,022 *0.00085*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	60 (49 — 72) *195 (170 — 230)*
M1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	115 (92 — 130) *375 (310 — 420)*
M2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	95 (75 — 110) *310 (250 — 360)*
M3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	60 (43 — 79) *195 (150 — 250)*
M4	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,03 *0.0012*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	46 (32 — 60) *150 (110 — 190)*
M5	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,03 *0.0012*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	39 (27 — 50) *130 (89 — 160)*
K1	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	195 (170 — 210) *640 (560 — 680)*
K2	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	170 (150 — 190) *560 (500 — 620)*
K3	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	145 (130 — 160) *475 (430 — 520)*
K4	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
K5	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	85 (72 — 93) *280 (240 — 300)*
K6	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	120 (110 — 130) *395 (370 — 420)*
K7	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	105 (92 — 120) *345 (310 — 390)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	470 (430 — 510) *1550 (1500 — 1600)*
N2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	300 (280 — 330) *980 (920 — 1000)*
N3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	200 (190 — 220) *660 (630 — 720)*
N11	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	265 (250 — 290) *870 (830 — 950)*
S1	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,036 *0.0014*	0,044 *0.0017*	0,05 *0.0020*	45 (15 — 74) *150 (50 — 240)*
S2	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,036 *0.0014*	0,044 *0.0017*	0,05 *0.0020*	36 (12 — 59) *120 (40 — 190)*
S3	E	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	31 (11 — 51) *100 (37 — 160)*
S11	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	90 (67 — 110) *295 (220 — 360)*
S12	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	70 (52 — 88) *230 (180 — 280)*
S13	E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	55 (41 — 69) *180 (140 — 220)*
H5	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,048 *0.0019*	70 (49 — 92) *230 (170 — 300)*
H8	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	70 (49 — 92) *230 (170 — 300)*
H11	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,048 *0.0019*	90 (63 — 110) *295 (210 — 360)*
H12	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	80 (57 — 100) *260 (190 — 320)*
H21	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	70 (49 — 92) *230 (170 — 300)*
TS1	A/D	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	470 (430 — 510) *1550 (1500 — 1600)*
TP1	A/D	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	470 (430 — 510) *1550 (1500 — 1600)*
GR1	A/D	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	470 (430 — 510) *1550 (1500 — 1600)*

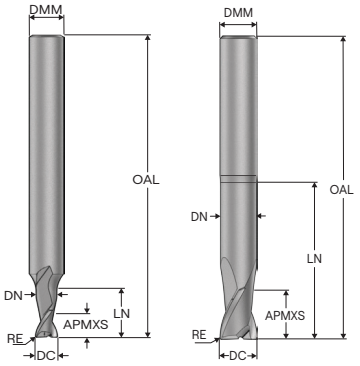
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

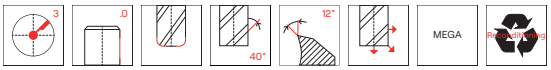
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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

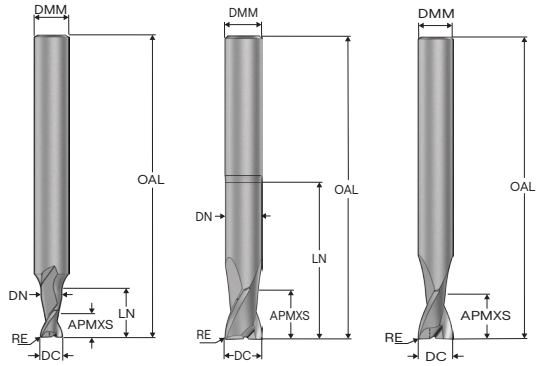
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
910020R020-MEGA	00020058	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,2	3,5	3	Cylindrical	■
910025R020-MEGA	00020065	2	G	2,5	3,0	4,0	40,0	6,0	2,4	0,2	2,0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

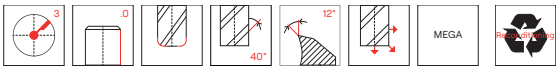
■ **Prodotto standard.**

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°	PCEDC	Attacco	Prodotto standard
				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	3	Cylindrical	■
910L030-MEGA	00022003	3	E	3,0	3,0	4,0	60,0	14,0	2,8	0,2	–	3	Cylindrical	■
910L040-MEGA	00022004	3	G	4,0	6,0	5,0	65,0	18,0	3,7	0,2	3,0	3	Cylindrical	■
910L050-MEGA	00022005	3	G	5,0	6,0	6,0	65,0	22,0	4,6	0,2	1,5	3	Cylindrical	■
910L060-MEGA	00022006	3	E	6,0	6,0	7,0	80,0	26,0	5,6	0,3	–	3	Cylindrical	■
910L080-MEGA	00022007	3	E	8,0	8,0	9,0	85,0	36,0	7,4	0,5	–	3	Cylindrical	■
910L100-MEGA	00022009	3	E	10,0	10,0	12,0	100,0	45,0	9,4	0,5	–	3	Cylindrical	■
910L120-MEGA	00022011	3	E	12,0	12,0	15,0	125,0	54,0	11,4	0,5	–	3	Cylindrical	■
910L160-MEGA	00022013	3	E	16,0	16,0	18,0	125,0	65,0	15,4	1,0	–	3	Cylindrical	■
910RS070-MEGA	00021772	4	P	7,0	6,0	8,0	100,0	–	–	0,3	–	3	Cylindrical	■
910RS090-MEGA	00021781	4	P	9,0	8,0	11,0	100,0	–	–	0,5	–	3	Cylindrical	■
910RS110-MEGA	00021782	4	P	11,0	10,0	13,0	125,0	–	–	0,5	–	3	Cylindrical	■
910RS130-MEGA	00021784	4	P	13,0	12,0	16,0	150,0	–	–	0,6	–	3	Cylindrical	■
910RS170-MEGA	00021800	4	P	17,0	16,0	20,0	150,0	–	–	0,6	–	3	Cylindrical	■

■ **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 699 - 707

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

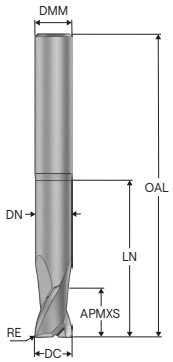
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

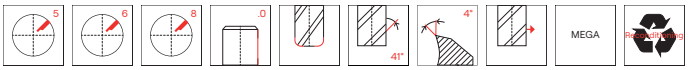
Alta velocità – Universale – Spallamento – 5-8 Eliche – Cilindrico – Raggio di punta





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	Attacco	Prodotto standard
				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	Cylindrical	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	Cylindrical	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	Cylindrical	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	Cylindrical	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	Cylindrical	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	Cylindrical	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	Cylindrical	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	Cylindrical	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	Cylindrical	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	Cylindrical	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	Cylindrical	■

■ **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)*

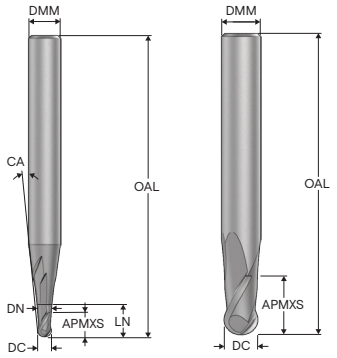
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

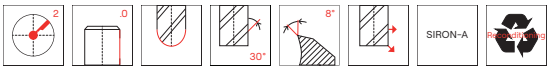
JHB970

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





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	RE	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm				
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	1,5	–	2	Cylindrical	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	2,0	–	2	Cylindrical	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	2,5	–	2	Cylindrical	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	3,0	–	2	Cylindrical	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	1,25	7,5	2	Cylindrical	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	1,75	4,5	2	Cylindrical	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	6,0	–	2	Cylindrical	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	8,0	–	2	Cylindrical	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	6,0	–	2	Cylindrical	■

■ **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)*

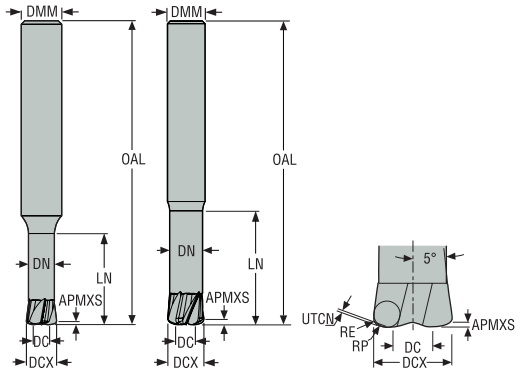
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

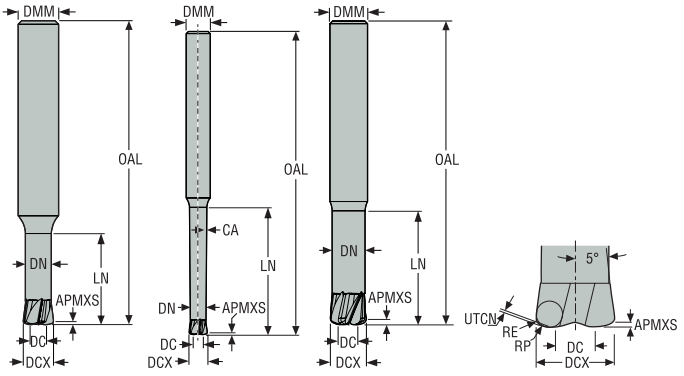
Codice di ordinazione	Codice prodotto	Indice di lung-hezza	Forma uten-sile	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	RP	UTCN	CA°	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm					
980K080Z3-MEGA	02587115	1	E	8,0	4,0	8,0	0,4	70,0	12,0	3,0	0,6	0,935	0,198	–	-5,0	3	Cylindrical	■
JHF980080E1H.0Z5-MEGA	03003384	1	E	8,0	4,0	8,0	0,4	70,0	12,0	7,0	0,6	0,935	0,198	–	-5,0	5	Cylindrical	■
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	–	-5,0	3	Cylindrical	■
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	–	-5,0	5	Cylindrical	■
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	–	-5,0	3	Cylindrical	■
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	–	-5,0	5	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	4	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	4	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	4	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	4	Cylindrical	■
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	–	-5,0	2	Cylindrical	■
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	–	-5,0	5	Cylindrical	■
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	–	-5,0	2	Cylindrical	■
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	–	-5,0	3	Cylindrical	■
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	–	-5,0	5	Cylindrical	■
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	–	-5,0	2	Cylindrical	■
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	–	-5,0	3	Cylindrical	■
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	–	-5,0	5	Cylindrical	■

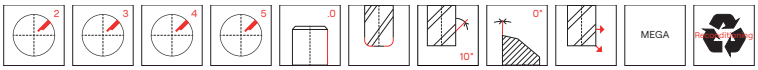
■ **Prodotto standard.**
*UTCN=spessore non asportato

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 lung-hezza	Forma uten-sile	DCX	DC	DMM	AP-MXS	OAL	LN	DN	RE	RP	UTCN	CA°	NA°	PSIR°	PCEDC	Attacco	Prodotto standard
				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	–	-5,0	2	Cylindrical	■
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	–	-5,0	2	Cylindrical	■
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	–	-5,0	2	Cylindrical	■
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	–	-5,0	4	Cylindrical	■
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	–	-5,0	2	Cylindrical	■
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	–	-5,0	4	Cylindrical	■
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	–	-5,0	2	Cylindrical	■
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	–	-5,0	4	Cylindrical	■
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	–	-5,0	2	Cylindrical	■
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	–	-5,0	4	Cylindrical	■
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	–	-5,0	2	Cylindrical	■
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	–	-5,0	4	Cylindrical	■
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	–	–	-5,0	2	Cylindrical	■
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	–	–	-5,0	5	Cylindrical	■
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	–	–	-5,0	2	Cylindrical	■
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	–	–	-5,0	5	Cylindrical	■
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	–	–	-5,0	2	Cylindrical	■
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	–	–	-5,0	5	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	4	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	4	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	4	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	-5,0	4	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	–	–	-5,0	5	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	–	–	-5,0	5	Cylindrical	■
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	-5,0	2	Cylindrical	■
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	–	–	-5,0	5	Cylindrical	■

■ **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 699 - 707

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)*

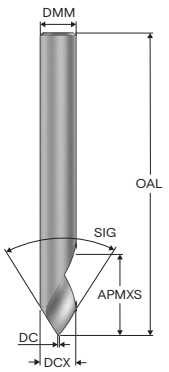
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

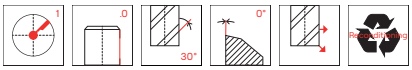
Uso generico – Universale – Incisione – 1 Elica – Cilindrico





D

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



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
29030	00029373	2	D	3,0	0,2	3,0	2,6	40,0	30,0	1	Cylindrical	■
29040	00029381	2	D	4,0	0,2	4,0	3,5	50,0	30,0	1	Cylindrical	■
29060	00029396	2	D	6,0	0,2	6,0	5,2	50,0	30,0	1	Cylindrical	■

■ **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 699 - 707

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)*

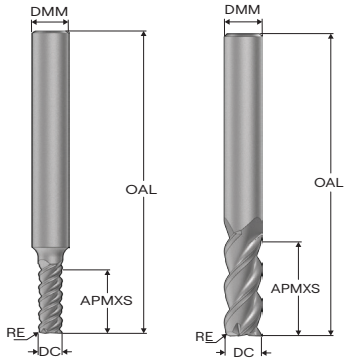
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

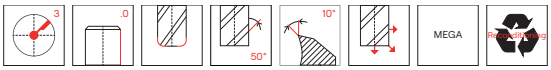
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm/dente (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
36020-MEGA	00025621	2	F	2,0	3,0	9,0	40,0	0,1	2,5	3	Cylindrical	■
36030-MEGA	00025626	2	D	3,0	3,0	12,0	40,0	0,1	–	3	Cylindrical	■
36040-MEGA	00025628	2	D	4,0	4,0	14,0	50,0	0,1	–	3	Cylindrical	■
36050-MEGA	00025651	2	D	5,0	5,0	20,0	50,0	0,1	–	3	Cylindrical	■
36060-MEGA	00025663	2	D	6,0	6,0	20,0	65,0	0,1	–	3	Cylindrical	■
36080-MEGA	00025674	2	D	8,0	8,0	20,0	65,0	0,2	–	3	Cylindrical	■
36100-MEGA	00025680	2	D	10,0	10,0	25,0	75,0	0,2	–	3	Cylindrical	■
36120-MEGA	00025681	2	D	12,0	12,0	25,0	75,0	0,2	–	3	Cylindrical	■
36160-MEGA	00025689	2	D	16,0	16,0	30,0	90,0	0,5	–	3	Cylindrical	■
36200-MEGA	00025692	2	D	20,0	20,0	40,0	100,0	0,5	–	3	Cylindrical	■

■ **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 699 - 707

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)*

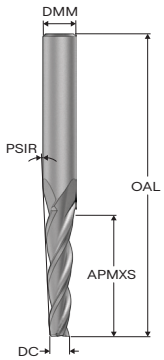
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

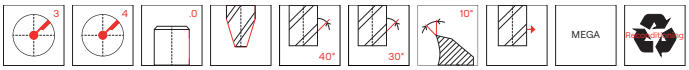
Uso generico – Universale – Conica – 3-4 Eliche – Cilindrico – Spigolo vivo conico





N

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



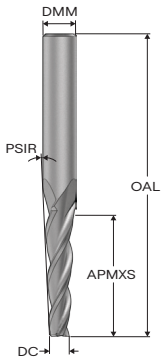
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
HK020-040-MEGA	00028666	2	N	6,0	4,0	6,0	20,0	65,0	2,0	3	Cylindrical	■
HK020-050-MEGA	00028669	2	N	8,0	5,0	8,0	30,0	75,0	2,0	3	Cylindrical	■
HK020-100-MEGA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

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

HKM-HK

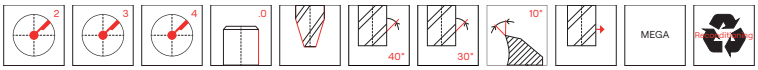
Uso generico – Universale – Conica – 2-4 Eliche – Cilindrico – Spigolo vivo conico





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



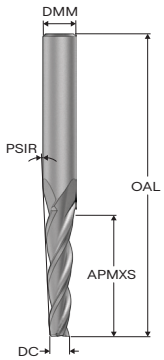
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
HKM030-015-MEGA	00028738	2	N	3,0	1,5	3,0	6,0	40,0	3,0	2	Cylindrical	■
HK030-025-MEGA	00028741	2	N	6,0	2,5	6,0	20,0	65,0	3,0	3	Cylindrical	■
HK030-033-MEGA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

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

HKM-HK

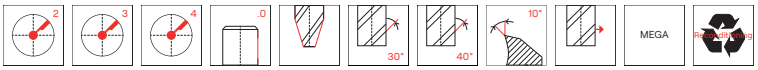
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N

—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



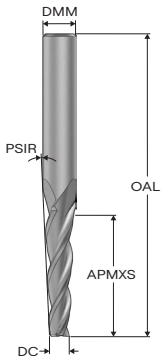
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
HKM050-010-MEGA	00028947	2	N	3,0	1,0	3,0	4,0	40,0	5,0	2	Cylindrical	■
HKM050-015-MEGA	00028952	2	N	3,0	1,5	3,0	6,0	40,0	5,0	2	Cylindrical	■
HKM050-020-MEGA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

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

HK

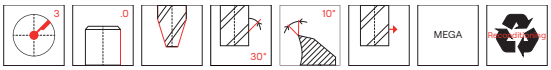
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N

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



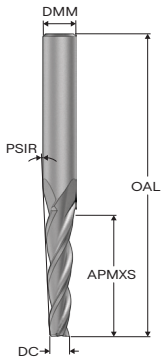
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
HK070-025-MEGA	00029030	2	N	8,0	2,5	8,0	22,0	65,0	7,0	3	Cylindrical	■
HK070-050-MEGA	00029034	2	N	12,0	5,0	12,0	28,0	80,0	7,0	3	Cylindrical	■

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

HK

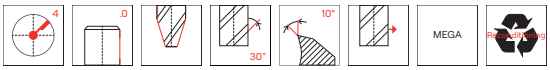
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N

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



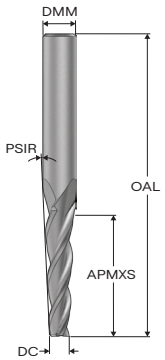
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
HK080-083-MEGA	00029041	2	N	18,0	8,0	18,0	35,0	90,0	8,0	4	Cylindrical	■

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

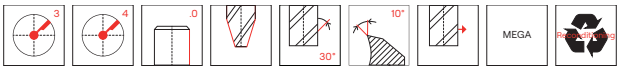
HK

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N



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

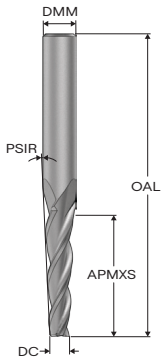
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
HK100-025-MEGA	00029052	2	N	10,0	2,5	10,0	20,0	75,0	10,0	3	Cylindrical	■
HK100-030-MEGA	00029066	2	N	14,0	3,0	14,0	30,0	90,0	10,0	3	Cylindrical	■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

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

HK

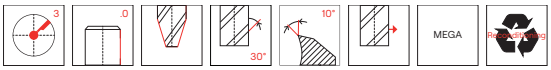
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N

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



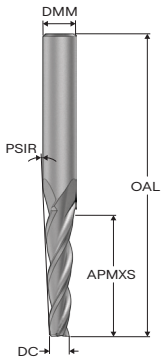
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
HK110-020-MEGA	00029110	2	N	10,0	2,0	10,0	20,0	75,0	11,0	3	Cylindrical	■
HK110-050-MEGA	00029117	2	N	14,0	5,0	14,0	20,0	80,0	11,0	3	Cylindrical	■

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

HK

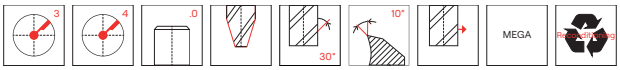
Uso generico – Universale – Conica – 3-4 Eliche – Cilindrico – Spigolo vivo conico





N

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



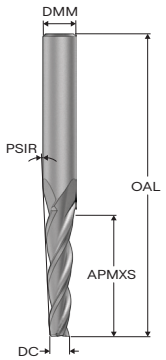
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
HK150-025	00029119	2	N	14,0	2,5	14,0	20,0	80,0	15,0	3	Cylindrical	■
HK150-025-MEGA	00029151	2	N	14,0	2,5	14,0	20,0	80,0	15,0	3	Cylindrical	■
HK150-040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

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

HK

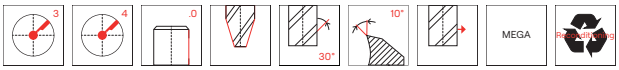
Uso generico – Universale – Conica – 3-4 Eliche – Cilindrico – Spigolo vivo conico





N

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



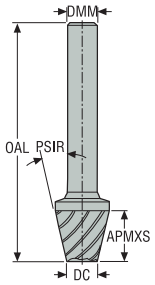
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
HK200-025	00029165	2	N	10,0	2,5	10,0	10,0	75,0	20,0	3	Cylindrical	■
HK200-025-MEGA	00029168	2	N	10,0	2,5	10,0	10,0	75,0	20,0	3	Cylindrical	■
HK200-045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

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

HK

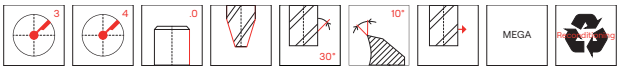
Uso generico – Universale – Conica – 3-4 Eliche – Cilindrico – Spigolo vivo conico





N

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



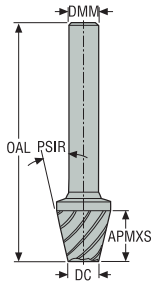
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
HK300-025	00029208	2	N	14,5	2,5	10,0	10,0	75,0	30,0	3	Cylindrical	■
HK300-025-MEGA	00029211	2	N	14,5	2,5	10,0	10,0	75,0	30,0	3	Cylindrical	■
HK300-045	00029210	2	N	23,5	4,5	16,0	16,0	90,0	30,0	4	Cylindrical	■
HK300-045-MEGA	00029212	2	N	23,5	4,5	16,0	16,0	90,0	30,0	4	Cylindrical	■

■ **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

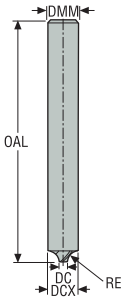
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm				
HK450-025	00029215	2	N	23,0	2,5	12,0	10,0	75,0	45,0	3	Cylindrical	■
HK450-025-MEGA	00029229	2	N	23,0	2,5	12,0	10,0	75,0	45,0	3	Cylindrical	■
HK450-045	00029217	2	N	37,0	4,5	16,0	16,0	90,0	45,0	4	Cylindrical	■
HK450-045-MEGA	00029232	2	N	37,0	4,5	16,0	16,0	90,0	45,0	4	Cylindrical	■

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

V31

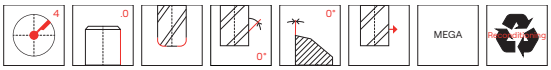
Uso generico – Universale – Concava – 4 Eliche – Cilindrico





D

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



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

■ **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 699 - 707

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)*

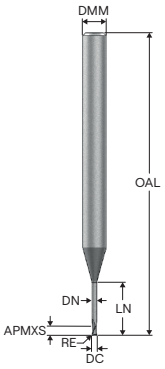
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

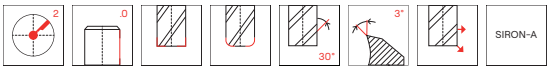
JME542

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

■ **Prodotto standard.**
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, 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 *0,0500*	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*	415 (370 — 460) *1350 (1300 — 1500)*
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*	405 (360 — 440) *1325 (1200 — 1400)*
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*	350 (310 — 380) *1150 (1100 — 1200)*
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*	305 (280 — 340) *1000 (920 — 1100)*
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*	290 (260 — 320) *950 (860 — 1000)*
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*	330 (300 — 360) *1075 (990 — 1100)*
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*	310 (280 — 340) *1025 (920 — 1100)*
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*	290 (260 — 320) *950 (860 — 1000)*
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*	300 (270 — 330) *980 (890 — 1000)*
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*	175 (160 — 190) *570 (530 — 620)*
M1	E/M/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*	220 (190 — 260) *720 (630 — 850)*
M2	E/M/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*	180 (150 — 210) *590 (500 — 680)*
M3	E/M/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*	180 (150 — 210) *590 (500 — 680)*
M4	E/M/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*	135 (110 — 150) *445 (370 — 490)*
M5	E/M/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*	110 (92 — 130) *360 (310 — 420)*
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*	570 (500 — 640) *1875 (1700 — 2000)*
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*	570 (500 — 640) *1875 (1700 — 2000)*
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*	380 (340 — 420) *1250 (1200 — 1300)*
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*	510 (440 — 580) *1675 (1500 — 1900)*
S11	E/M/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*	295 (260 — 330) *970 (860 — 1000)*
S12	E/M/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*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/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*	175 (160 — 200) *570 (530 — 650)*
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*	255 (230 — 280) *840 (760 — 910)*
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*	255 (230 — 280) *840 (760 — 910)*
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*	325 (290 — 360) *1075 (960 — 1100)*
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*	295 (270 — 330) *970 (890 — 1000)*
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*	255 (230 — 280) *840 (760 — 910)*
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*	195 (170 — 210) *640 (560 — 680)*
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*	0.024 *0,00095*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	405 (350 — 460) *1325 (1200 — 1500)*

Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 699 - 707

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)*

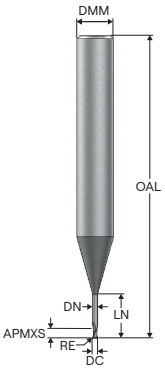
Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 699 - 707

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

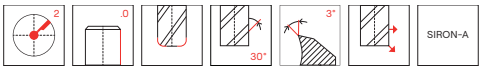
Miniaturizzato – Universale – Spallamento – 2 Eliche – DMM 6 – Cilindrico – Raggio di punta





G

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



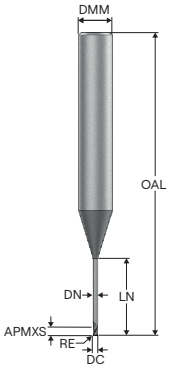
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
JME562005G2R005.0Z2-SIRA	03171145	2	G	0,5	6,0	0,8	50,0	1,5	0,46	0,05	13,48	2	Cylindrical	■
JME562006G2R005.0Z2-SIRA	03171146	2	G	0,6	6,0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

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

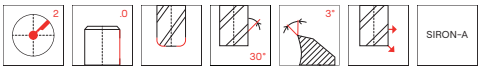
JME562

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	Attacco	Prodotto standard
				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	Cylindrical	■
JME562012G6R010.0Z2-SIRA	03171176	6	G	1,2	6,0	1,8	60,0	18,0	1,15	0,1	5,14	2	Cylindrical	■
JME562015G6R015.0Z2-SIRA	03171177	6	G	1,5	6,0	2,3	70,0	22,5	1,45	0,15	4,2	2	Cylindrical	■
JME562020G6R015.0Z2-SIRA	03171178	6	G	2,0	6,0	3,0	80,0	30,0	1,94	0,15	3,07	2	Cylindrical	■
JME562030G6R015.0Z2-SIRA	03171180	6	G	3,0	6,0	4,5	90,0	45,0	2,85	0,15	1,7	2	Cylindrical	■
JME562010G7R010.0Z2-SIRA	03171181	7	G	1,0	6,0	1,5	60,0	20,0	0,95	0,1	4,93	2	Cylindrical	■
JME562012G7R010.0Z2-SIRA	03171182	7	G	1,2	6,0	1,8	80,0	24,0	1,15	0,1	4,2	2	Cylindrical	■
JME562015G7R015.0Z2-SIRA	03171183	7	G	1,5	6,0	2,3	80,0	30,0	1,45	0,15	3,38	2	Cylindrical	■
JME562020G7R015.0Z2-SIRA	03171184	7	G	2,0	6,0	3,0	80,0	40,0	1,94	0,15	2,42	2	Cylindrical	■
JME562030G7R015.0Z2-SIRA	03171186	7	G	3,0	6,0	4,5	100,0	60,0	2,85	0,15	1,31	2	Cylindrical	■

■ **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 *0,0500*	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*	415 (370 — 460) *1350 (1300 — 1500)*
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*	405 (360 — 440) *1325 (1200 — 1400)*
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*	350 (310 — 380) *1150 (1100 — 1200)*
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*	305 (280 — 340) *1000 (920 — 1100)*
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*	290 (260 — 320) *950 (860 — 1000)*
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*	330 (300 — 360) *1075 (990 — 1100)*
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*	310 (280 — 340) *1025 (920 — 1100)*
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*	290 (260 — 320) *950 (860 — 1000)*
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*	300 (270 — 330) *980 (890 — 1000)*
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*	175 (160 — 190) *570 (530 — 620)*
M1	E/M/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*	220 (190 — 260) *720 (630 — 850)*
M2	E/M/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*	180 (150 — 210) *590 (500 — 680)*
M3	E/M/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*	180 (150 — 210) *590 (500 — 680)*
M4	E/M/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*	135 (110 — 150) *445 (370 — 490)*
M5	E/M/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*	110 (92 — 130) *360 (310 — 420)*
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*	570 (500 — 640) *1875 (1700 — 2000)*
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*	570 (500 — 640) *1875 (1700 — 2000)*
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*	380 (340 — 420) *1250 (1200 — 1300)*
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*	510 (440 — 580) *1675 (1500 — 1900)*
S11	E/M/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*	295 (260 — 330) *970 (860 — 1000)*
S12	E/M/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*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/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*	175 (160 — 200) *570 (530 — 650)*
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*	255 (230 — 280) *840 (760 — 910)*
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*	255 (230 — 280) *840 (760 — 910)*
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*	325 (290 — 360) *1075 (960 — 1100)*
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*	295 (270 — 330) *970 (890 — 1000)*
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*	255 (230 — 280) *840 (760 — 910)*
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*	195 (170 — 210) *640 (560 — 680)*
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*	0.024 *0,00095*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	405 (350 — 460) *1325 (1200 — 1500)*

Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 699 - 707

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)*

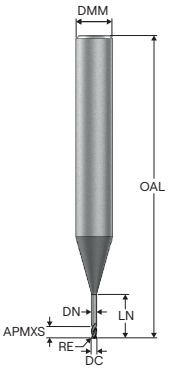
Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 699 - 707

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

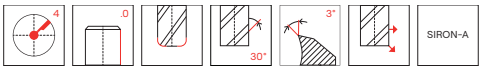
Miniaturizzato – Universale – Spallamento – 4 Eliche – DMM 6 – Cilindrico – Raggio di punta





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	Attacco	Prodotto standard
				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	Cylindrical	■
JME564006G2R005.0Z4-SIRA	03227271	2	G	0,6	6,0	1,2	50,0	2,0	0,56	0,05	12,9	4	Cylindrical	■
JME564008G2R005.0Z4-SIRA	03171194	2	G	0,8	6,0	1,6	50,0	2,5	0,76	0,05	12,28	4	Cylindrical	■
JME564010G2R010.0Z4-SIRA	03171195	2	G	1,0	6,0	2,0	50,0	4,0	0,95	0,1	10,85	4	Cylindrical	■
JME564012G2R010.0Z4-SIRA	03171196	2	G	1,2	6,0	2,4	50,0	4,5	1,15	0,1	10,31	4	Cylindrical	■
JME564015G2R015.0Z4-SIRA	03171197	2	G	1,5	6,0	3,0	50,0	5,0	1,45	0,15	9,67	4	Cylindrical	■
JME564020G2R015.0Z4-SIRA	03171198	2	G	2,0	6,0	4,0	50,0	6,0	1,94	0,15	8,53	4	Cylindrical	■
JME564025G2R015.0Z4-SIRA	03171199	2	G	2,5	6,0	5,0	60,0	7,5	2,4	0,15	7,15	4	Cylindrical	■
JME564030G2R015.0Z4-SIRA	03171200	2	G	3,0	6,0	6,0	60,0	9,0	2,85	0,15	5,81	4	Cylindrical	■
JME564005G4R005.0Z4-SIRA	03171201	4	G	0,5	6,0	1,0	50,0	3,5	0,46	0,05	11,54	4	Cylindrical	■
JME564006G4R005.0Z4-SIRA	03171202	4	G	0,6	6,0	1,2	50,0	4,2	0,56	0,05	10,93	4	Cylindrical	■
JME564008G4R005.0Z4-SIRA	03171203	4	G	0,8	6,0	1,6	50,0	5,6	0,76	0,05	9,81	4	Cylindrical	■
JME564010G4R010.0Z4-SIRA	03171204	4	G	1,0	6,0	2,0	50,0	7,0	0,95	0,1	8,86	4	Cylindrical	■
JME564012G4R010.0Z4-SIRA	03171205	4	G	1,2	6,0	2,4	50,0	8,4	1,15	0,1	8,0	4	Cylindrical	■
JME564015G4R015.0Z4-SIRA	03171206	4	G	1,5	6,0	3,0	50,0	10,5	1,45	0,15	6,86	4	Cylindrical	■
JME564020G4R015.0Z4-SIRA	03171207	4	G	2,0	6,0	4,0	60,0	14,0	1,94	0,15	5,36	4	Cylindrical	■
JME564030G4R015.0Z4-SIRA	03171209	4	G	3,0	6,0	6,0	70,0	21,0	2,85	0,15	3,22	4	Cylindrical	■

■ **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 699 - 707

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)*

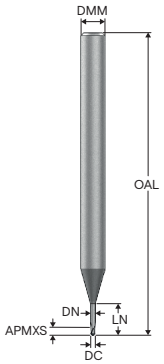
Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 699 - 707

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

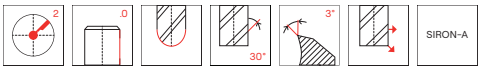
JMB542

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

■ **Prodotto standard.**
Per i valori WDX: Profondità di taglio max relativa a αη (lαη, 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 699 - 707

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)*

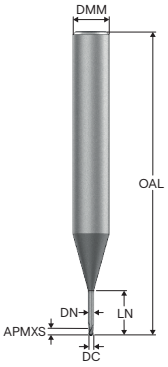
Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 699 - 707

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

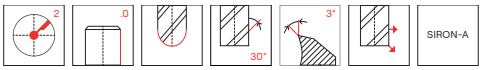
Miniaturizzato – Universale – A testa sferica – 2 Eliche – DMM 6 – Cilindrico





G

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



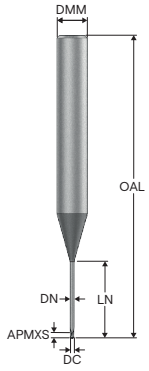
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
JMB562005G2B.0Z2-SIRA	03171261	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	13,69	2	Cylindrical	■
JMB562006G2B.0Z2-SIRA	03171262	2	G	0,6	6,0	0,6	50,0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

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

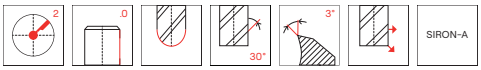
JMB562

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	Attacco	Prodotto standard
				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	Cylindrical	■
JMB562012G6B.0Z2-SIRA	03171291	6	G	1,2	6,0	1,2	60,0	18,0	1,15	0,6	5,24	2	Cylindrical	■
JMB562015G6B.0Z2-SIRA	03171292	6	G	1,5	6,0	1,5	70,0	22,5	1,45	0,75	4,28	2	Cylindrical	■
JMB562020G6B.0Z2-SIRA	03171293	6	G	2,0	6,0	2,0	80,0	30,0	1,94	1,0	3,14	2	Cylindrical	■
JMB562030G6B.0Z2-SIRA	03171295	6	G	3,0	6,0	3,0	90,0	45,0	2,85	1,5	1,74	2	Cylindrical	■
JMB562010G7B.0Z2-SIRA	03171296	7	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	4,99	2	Cylindrical	■
JMB562012G7B.0Z2-SIRA	03171297	7	G	1,2	6,0	1,2	80,0	24,0	1,15	0,6	4,27	2	Cylindrical	■
JMB562015G7B.0Z2-SIRA	03171298	7	G	1,5	6,0	1,5	80,0	30,0	1,45	0,75	3,43	2	Cylindrical	■
JMB562020G7B.0Z2-SIRA	03171299	7	G	2,0	6,0	2,0	80,0	40,0	1,94	1,0	2,47	2	Cylindrical	■
JMB562030G7B.0Z2-SIRA	03171301	7	G	3,0	6,0	3,0	100,0	60,0	2,85	1,5	1,34	2	Cylindrical	■

■ **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 *0,0500*	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 699 - 707

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)*

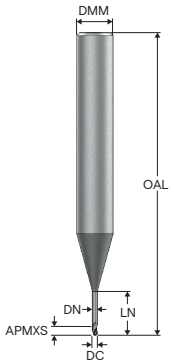
Tabella basata su LV1, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine 699 - 707

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

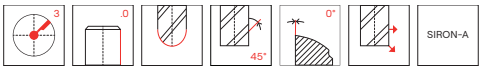
Miniaturizzato – Universale – A testa sferica – 3 Eliche – DMM 6 – Cilindrico





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	Attacco	Prodotto standard
				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	Cylindrical	■
JMB563012G2B.0Z3-SIRA	03171308	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	10,67	3	Cylindrical	■
JMB563015G2B.0Z3-SIRA	03171309	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,07	3	Cylindrical	■
JMB563020G2B.0Z3-SIRA	03171310	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,05	3	Cylindrical	■
JMB563025G2B.0Z3-SIRA	03171311	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	7,71	3	Cylindrical	■
JMB563030G2B.0Z3-SIRA	03171312	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	6,35	3	Cylindrical	■
JMB563010G4B.0Z3-SIRA	03171316	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	3	Cylindrical	■
JMB563012G4B.0Z3-SIRA	03171317	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	8,22	3	Cylindrical	■
JMB563015G4B.0Z3-SIRA	03171318	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	7,07	3	Cylindrical	■
JMB563020G4B.0Z3-SIRA	03171319	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	5,57	3	Cylindrical	■
JMB563030G4B.0Z3-SIRA	03171321	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	3,38	3	Cylindrical	■

■ **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 699 - 707

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.

- ST5541, JHP993, JHP951 e JH142 per tipo con smusso o raggio.
- ST5341, JHB970, JH112, JH150, JH160 per tipo a testa sferica.

Selezione utensile acciaio e ghisa

							
Nome		ST5541	JHP993	JHP951	JH142	ST5341	JHB970
Pag.		276	293	299	303, 514	306	228, 311
Famiglia		Stabilizer	HPM	HPM	HSM/TORNADO	Stabilizer	HSM/TORNADO
Tipo di fresa							
Attacco	Cilindrico	■	■	■	■	■	■
	Weldon	□	■	■		□	
Numero di eliche		4	3,4,5	3,4,5	2-4-5-6	4	2
CSP							
	Metrico	3-25	4-25	3-20	2-12	6-20	2-16
	Pollici	1/8-1				1/4-1	
Lunghezze disponibili		1,2,3,4	2,3	2	2,3,6	2.3	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

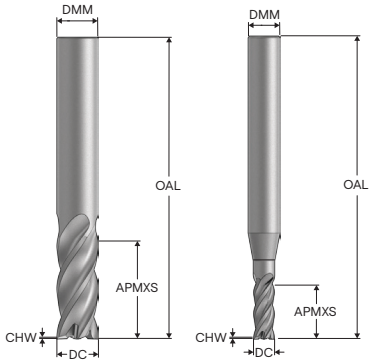
				
Nome		JH112	JH150	JH160
Pag.		313, 517	520	522
Famiglia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Tipo di fresa		U	U	U
Attacco	Cilindrico	■	■	■
	Weldon			
Numero di eliche		2	4	4
CSP				
	Metrico	2-12	6-12	3-12
	Pollici			
Lunghezze disponibili		1,2,3,4,5,6	2	2
Operazione				
				
SMG				
P1				●
P2				●
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

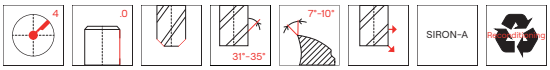
ST5541

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





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



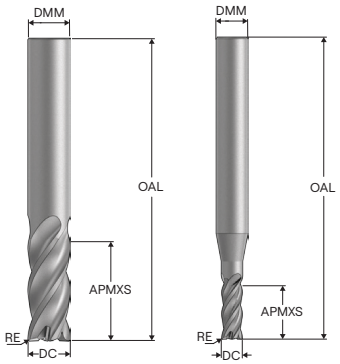
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
ST5541-030F2C.0Z4	SIRA	10302942	2	F	3,0	6,0	7,0	58,0	0,035	4	Cylindrical	■
ST5541-040F2C.0Z4	SIRA	10302943	2	F	4,0	6,0	10,0	58,0	0,045	4	Cylindrical	■
ST5541-050F2C.0Z4	SIRA	10302944	2	F	5,0	6,0	12,0	58,0	0,055	4	Cylindrical	■
ST5541-060D2C.0Z4	SIRA	10302945	2	D	6,0	6,0	14,0	58,0	0,075	4	Cylindrical	■
ST5541-080D2C.0Z4	SIRA	10302946	2	D	8,0	8,0	18,0	64,0	0,1	4	Cylindrical	■
ST5541-100D2C.0Z4	SIRA	10302947	2	D	10,0	10,0	22,0	73,0	0,125	4	Cylindrical	■
ST5541-120D2C.0Z4	SIRA	10302948	2	D	12,0	12,0	26,0	84,0	0,15	4	Cylindrical	■
ST5541-160D2C.0Z4	SIRA	10302949	2	D	16,0	16,0	34,0	95,0	0,2	4	Cylindrical	■
ST5541-200D2C.0Z4	SIRA	10302950	2	D	20,0	20,0	42,0	109,0	0,25	4	Cylindrical	■
ST5541-250D2C.0Z4	SIRA	10302951	2	D	25,0	25,0	52,0	125,0	0,3	4	Cylindrical	■
ST5541-030F3C.0Z4	SIRA	10302952	3	F	3,0	6,0	9,0	58,0	0,035	4	Cylindrical	■
ST5541-040F3C.0Z4	SIRA	10302953	3	F	4,0	6,0	12,0	58,0	0,045	4	Cylindrical	■
ST5541-050F3C.0Z4	SIRA	10302954	3	F	5,0	6,0	15,0	58,0	0,055	4	Cylindrical	■
ST5541-060D3C.0Z4	SIRA	10302955	3	D	6,0	6,0	18,0	64,0	0,075	4	Cylindrical	■
ST5541-080D3C.0Z4	SIRA	10302956	3	D	8,0	8,0	24,0	73,0	0,1	4	Cylindrical	■
ST5541-100D3C.0Z4	SIRA	10302957	3	D	10,0	10,0	30,0	85,0	0,125	4	Cylindrical	■
ST5541-120D3C.0Z4	SIRA	10302958	3	D	12,0	12,0	36,0	100,0	0,15	4	Cylindrical	■
ST5541-160D3C.0Z4	SIRA	10302959	3	D	16,0	16,0	48,0	115,0	0,2	4	Cylindrical	■
ST5541-200D3C.0Z4	SIRA	10302960	3	D	20,0	20,0	60,0	125,0	0,25	4	Cylindrical	■
ST5541-250D3C.0Z4	SIRA	10302961	3	D	25,0	25,0	75,0	155,0	0,3	4	Cylindrical	■

■ **Prodotto standard.**

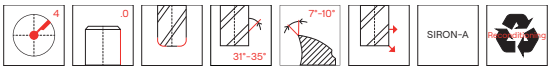
ST5541

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





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



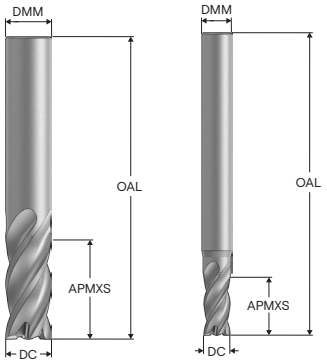
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
ST5541-030F2R020.0Z4	SIRA	10302962	2	F	3,0	6,0	7,0	58,0	0,2	4	Cylindrical	■
ST5541-040F2R020.0Z4	SIRA	10302963	2	F	4,0	6,0	10,0	58,0	0,2	4	Cylindrical	■
ST5541-050F2R020.0Z4	SIRA	10302964	2	F	5,0	6,0	12,0	58,0	0,2	4	Cylindrical	■
ST5541-060D2R050.0Z4	SIRA	10302965	2	D	6,0	6,0	14,0	58,0	0,5	4	Cylindrical	■
ST5541-080D2R050.0Z4	SIRA	10302966	2	D	8,0	8,0	18,0	64,0	0,5	4	Cylindrical	■
ST5541-100D2R050.0Z4	SIRA	10302967	2	D	10,0	10,0	22,0	73,0	0,5	4	Cylindrical	■
ST5541-120D2R050.0Z4	SIRA	10302968	2	D	12,0	12,0	26,0	84,0	0,5	4	Cylindrical	■
ST5541-120D2R100.0Z4	SIRA	10302969	2	D	12,0	12,0	26,0	84,0	1,0	4	Cylindrical	■
ST5541-160D2R050.0Z4	SIRA	10302970	2	D	16,0	16,0	34,0	95,0	0,5	4	Cylindrical	■
ST5541-160D2R100.0Z4	SIRA	10302972	2	D	16,0	16,0	34,0	95,0	1,0	4	Cylindrical	■
ST5541-160D2R300.0Z4	SIRA	10302971	2	D	16,0	16,0	34,0	95,0	3,0	4	Cylindrical	■
ST5541-200D2R050.0Z4	SIRA	10302973	2	D	20,0	20,0	42,0	109,0	0,5	4	Cylindrical	■
ST5541-200D2R100.0Z4	SIRA	10302975	2	D	20,0	20,0	42,0	109,0	1,0	4	Cylindrical	■
ST5541-200D2R300.0Z4	SIRA	10302974	2	D	20,0	20,0	42,0	109,0	3,0	4	Cylindrical	■
ST5541-250D2R050.0Z4	SIRA	10302976	2	D	25,0	25,0	52,0	125,0	0,5	4	Cylindrical	■
ST5541-250D2R100.0Z4	SIRA	10302978	2	D	25,0	25,0	52,0	125,0	1,0	4	Cylindrical	■
ST5541-250D2R300.0Z4	SIRA	10302977	2	D	25,0	25,0	52,0	125,0	3,0	4	Cylindrical	■
ST5541-030F3R020.0Z4	SIRA	10302979	3	F	3,0	6,0	9,0	58,0	0,2	4	Cylindrical	■
ST5541-040F3R020.0Z4	SIRA	10302980	3	F	4,0	6,0	12,0	58,0	0,2	4	Cylindrical	■
ST5541-050F3R020.0Z4	SIRA	10302981	3	F	5,0	6,0	15,0	58,0	0,2	4	Cylindrical	■
ST5541-060D3R050.0Z4	SIRA	10302982	3	D	6,0	6,0	18,0	64,0	0,5	4	Cylindrical	■
ST5541-080D3R050.0Z4	SIRA	10302983	3	D	8,0	8,0	24,0	73,0	0,5	4	Cylindrical	■
ST5541-100D3R050.0Z4	SIRA	10302984	3	D	10,0	10,0	30,0	85,0	0,5	4	Cylindrical	■
ST5541-120D3R050.0Z4	SIRA	10302985	3	D	12,0	12,0	36,0	100,0	0,5	4	Cylindrical	■
ST5541-120D3R100.0Z4	SIRA	10302986	3	D	12,0	12,0	36,0	100,0	1,0	4	Cylindrical	■
ST5541-160D3R050.0Z4	SIRA	10302987	3	D	16,0	16,0	48,0	115,0	0,5	4	Cylindrical	■
ST5541-160D3R100.0Z4	SIRA	10302989	3	D	16,0	16,0	48,0	115,0	1,0	4	Cylindrical	■
ST5541-160D3R300.0Z4	SIRA	10302988	3	D	16,0	16,0	48,0	115,0	3,0	4	Cylindrical	■
ST5541-200D3R050.0Z4	SIRA	10302990	3	D	20,0	20,0	60,0	125,0	0,5	4	Cylindrical	■
ST5541-200D3R100.0Z4	SIRA	10302992	3	D	20,0	20,0	60,0	125,0	1,0	4	Cylindrical	■
ST5541-200D3R300.0Z4	SIRA	10302991	3	D	20,0	20,0	60,0	125,0	3,0	4	Cylindrical	■
ST5541-250D3R050.0Z4	SIRA	10302993	3	D	25,0	25,0	75,0	155,0	0,5	4	Cylindrical	■
ST5541-250D3R100.0Z4	SIRA	10302995	3	D	25,0	25,0	75,0	155,0	1,0	4	Cylindrical	■
ST5541-250D3R300.0Z4	SIRA	10302994	3	D	25,0	25,0	75,0	155,0	3,0	4	Cylindrical	■

■ **Prodotto standard.**

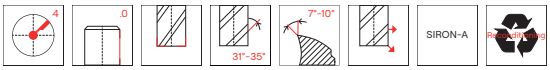
ST5541

Alte prestazioni – Acciaio – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Riaffilatura possibile se DC è ≥Ø.250



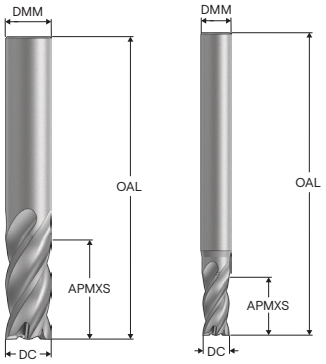
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
ST5541-.125D1S.0Z4	SIRA	10302742	1	D	0.125	0.125	0.125	1.500	4	Cylindrical	■
ST5541-.156F1S.0Z4	SIRA	10302743	1	F	0.156	0.188	0.156	2.000	4	Cylindrical	■
ST5541-.188D1S.0Z4	SIRA	10302744	1	D	0.188	0.188	0.188	2.000	4	Cylindrical	■
ST5541-.219F1S.0Z4	SIRA	10302745	1	F	0.219	0.250	0.219	2.000	4	Cylindrical	■
ST5541-.250D1S.0Z4	SIRA	10302746	1	D	0.250	0.250	0.250	2.000	4	Cylindrical	■
ST5541-.281F1S.0Z4	SIRA	10302747	1	F	0.281	0.313	0.281	2.000	4	Cylindrical	■
ST5541-.313D1S.0Z4	SIRA	10302748	1	D	0.313	0.313	0.313	2.000	4	Cylindrical	■
ST5541-.375D1S.0Z4	SIRA	10302749	1	D	0.375	0.375	0.375	2.000	4	Cylindrical	■
ST5541-.438D1S.0Z4	SIRA	10302750	1	D	0.438	0.438	0.438	2.750	4	Cylindrical	■
ST5541-.500D1S.0Z4	SIRA	10302751	1	D	0.500	0.500	0.500	2.500	4	Cylindrical	■
ST5541-.625D1S.0Z4	SIRA	10302752	1	D	0.625	0.625	0.625	3.000	4	Cylindrical	■
ST5541-.750D1S.0Z4	SIRA	10302753	1	D	0.750	0.750	0.750	3.000	4	Cylindrical	■
ST5541-.875D1S.0Z4	SIRA	10302754	1	D	0.875	0.875	0.875	4.000	4	Cylindrical	■
ST5541-1.00D1S.0Z4	SIRA	10302755	1	D	1.000	1.000	1.000	4.000	4	Cylindrical	■
ST5541-.125D2S.0Z4	SIRA	10302756	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
ST5541-.156F2S.0Z4	SIRA	10302757	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
ST5541-.188D2S.0Z4	SIRA	10302758	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
ST5541-.219F2S.0Z4	SIRA	10302759	2	F	0.219	0.250	0.438	2.500	4	Cylindrical	■
ST5541-.250D2S.0Z4	SIRA	10302760	2	D	0.250	0.250	0.500	2.500	4	Cylindrical	■
ST5541-.281F2S.0Z4	SIRA	10302761	2	F	0.281	0.313	0.563	2.500	4	Cylindrical	■
ST5541-.313D2S.0Z4	SIRA	10302762	2	D	0.313	0.313	0.625	2.500	4	Cylindrical	■
ST5541-.375D2S.0Z4	SIRA	10302763	2	D	0.375	0.375	0.750	2.500	4	Cylindrical	■
ST5541-.438D2S.0Z4	SIRA	10302764	2	D	0.438	0.438	0.875	2.750	4	Cylindrical	■
ST5541-.500D2S.0Z4	SIRA	10302765	2	D	0.500	0.500	1.000	3.000	4	Cylindrical	■
ST5541-.625D2S.0Z4	SIRA	10302766	2	D	0.625	0.625	1.250	3.500	4	Cylindrical	■
ST5541-.750D2S.0Z4	SIRA	10302767	2	D	0.750	0.750	1.500	4.000	4	Cylindrical	■
ST5541-.875D2S.0Z4	SIRA	10302768	2	D	0.875	0.875	1.750	4.000	4	Cylindrical	■
ST5541-1.00D2S.0Z4	SIRA	10302769	2	D	1.000	1.000	2.000	5.000	4	Cylindrical	■

■ **Prodotto standard.**

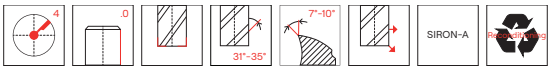
ST5541

Alte prestazioni – Acciaio – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Riaffilatura possibile se DC è ≥Ø.250



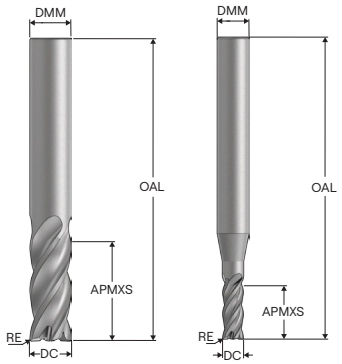
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
ST5541-.125D3S.0Z4	SIRA	10302770	3	D	0.125	0.125	0.375	1.500	4	Cylindrical	■
ST5541-.156F3S.0Z4	SIRA	10302771	3	F	0.156	0.188	0.469	2.000	4	Cylindrical	■
ST5541-.188D3S.0Z4	SIRA	10302772	3	D	0.188	0.188	0.563	2.000	4	Cylindrical	■
ST5541-.219F3S.0Z4	SIRA	10302773	3	F	0.219	0.250	0.656	2.500	4	Cylindrical	■
ST5541-.250D3S.0Z4	SIRA	10302774	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
ST5541-.281F3S.0Z4	SIRA	10302775	3	F	0.281	0.313	0.844	2.500	4	Cylindrical	■
ST5541-.313D3S.0Z4	SIRA	10302776	3	D	0.313	0.313	0.938	2.500	4	Cylindrical	■
ST5541-.375D3S.0Z4	SIRA	10302777	3	D	0.375	0.375	1.125	3.000	4	Cylindrical	■
ST5541-.438D3S.0Z4	SIRA	10302778	3	D	0.438	0.438	1.313	4.000	4	Cylindrical	■
ST5541-.500D3S.0Z4	SIRA	10302779	3	D	0.500	0.500	1.250	3.000	4	Cylindrical	■
ST5541-.625D3S.0Z4	SIRA	10302780	3	D	0.625	0.625	1.875	4.000	4	Cylindrical	■
ST5541-.750D3S.0Z4	SIRA	10302781	3	D	0.750	0.750	2.250	5.000	4	Cylindrical	■
ST5541-.875D3S.0Z4	SIRA	10302782	3	D	0.875	0.875	2.625	5.000	4	Cylindrical	■
ST5541-1.00D3S.0Z4	SIRA	10302783	3	D	1.000	1.000	3.000	6.000	4	Cylindrical	■
ST5541-.500D4S.0Z4	SIRA	10302784	4	D	0.500	0.500	1.500	4.000	4	Cylindrical	■

■ **Prodotto standard.**

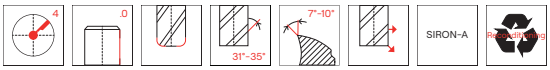
ST5541

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





– Tolleranze:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– RE= ±.0008"
– Riaffilatura possibile se DC è ≥Ø.250



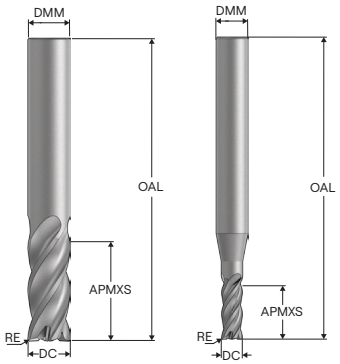
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
ST5541-.125D1R010.0Z4	SIRA	10302785	1	D	0.125	0.125	0.125	1.500	0.010	4	Cylindrical	■
ST5541-.156F1R010.0Z4	SIRA	10302786	1	F	0.156	0.188	0.156	2.000	0.010	4	Cylindrical	■
ST5541-.188D1R010.0Z4	SIRA	10302787	1	D	0.188	0.188	0.188	2.000	0.010	4	Cylindrical	■
ST5541-.219F1R020.0Z4	SIRA	10302788	1	F	0.219	0.250	0.219	2.000	0.020	4	Cylindrical	■
ST5541-.250D1R020.0Z4	SIRA	10302789	1	D	0.250	0.250	0.250	2.000	0.020	4	Cylindrical	■
ST5541-.281F1R020.0Z4	SIRA	10302790	1	F	0.281	0.313	0.281	2.000	0.020	4	Cylindrical	■
ST5541-.313D1R020.0Z4	SIRA	10302791	1	D	0.313	0.313	0.313	2.000	0.020	4	Cylindrical	■
ST5541-.375D1R020.0Z4	SIRA	10302792	1	D	0.375	0.375	0.375	2.000	0.020	4	Cylindrical	■
ST5541-.438D1R020.0Z4	SIRA	10302793	1	D	0.438	0.438	0.438	2.750	0.020	4	Cylindrical	■
ST5541-.500D1R030.0Z4	SIRA	10302794	1	D	0.500	0.500	0.500	2.500	0.030	4	Cylindrical	■
ST5541-.625D1R030.0Z4	SIRA	10302795	1	D	0.625	0.625	0.625	3.000	0.030	4	Cylindrical	■
ST5541-.750D1R030.0Z4	SIRA	10302796	1	D	0.750	0.750	0.750	3.000	0.030	4	Cylindrical	■
ST5541-.875D1R030.0Z4	SIRA	10302797	1	D	0.875	0.875	0.875	4.000	0.030	4	Cylindrical	■
ST5541-1.00D1R030.0Z4	SIRA	10302798	1	D	1.000	1.000	1.000	4.000	0.030	4	Cylindrical	■
ST5541-.125D2R010.0Z4	SIRA	10302799	2	D	0.125	0.125	0.250	1.500	0.010	4	Cylindrical	■
ST5541-.156F2R010.0Z4	SIRA	10302800	2	F	0.156	0.188	0.313	2.000	0.010	4	Cylindrical	■
ST5541-.188D2R010.0Z4	SIRA	10302801	2	D	0.188	0.188	0.375	2.000	0.010	4	Cylindrical	■
ST5541-.219F2R020.0Z4	SIRA	10302802	2	F	0.219	0.250	0.438	2.500	0.020	4	Cylindrical	■
ST5541-.250D2R020.0Z4	SIRA	10302803	2	D	0.250	0.250	0.500	2.500	0.020	4	Cylindrical	■
ST5541-.281F2R020.0Z4	SIRA	10302805	2	F	0.281	0.313	0.563	2.500	0.020	4	Cylindrical	■
ST5541-.313D2R020.0Z4	SIRA	10302806	2	D	0.313	0.313	0.625	2.500	0.020	4	Cylindrical	■
ST5541-.375D2R020.0Z4	SIRA	10302808	2	D	0.375	0.375	0.750	2.500	0.020	4	Cylindrical	■
ST5541-.438D2R020.0Z4	SIRA	10302810	2	D	0.438	0.438	0.875	2.750	0.020	4	Cylindrical	■
ST5541-.500D2R030.0Z4	SIRA	10302812	2	D	0.500	0.500	1.000	3.000	0.030	4	Cylindrical	■
ST5541-.500D2R060.0Z4	SIRA	10302813	2	D	0.500	0.500	1.000	3.000	0.060	4	Cylindrical	■
ST5541-.500D2R120.0Z4	SIRA	10302814	2	D	0.500	0.500	1.000	3.000	0.120	4	Cylindrical	■
ST5541-.625D2R030.0Z4	SIRA	10302816	2	D	0.625	0.625	1.250	3.500	0.030	4	Cylindrical	■
ST5541-.625D2R060.0Z4	SIRA	10302817	2	D	0.625	0.625	1.250	3.500	0.060	4	Cylindrical	■
ST5541-.625D2R090.0Z4	SIRA	10302818	2	D	0.625	0.625	1.250	3.500	0.090	4	Cylindrical	■
ST5541-.625D2R120.0Z4	SIRA	10302819	2	D	0.625	0.625	1.250	3.500	0.120	4	Cylindrical	■
ST5541-.750D2R030.0Z4	SIRA	10302821	2	D	0.750	0.750	1.500	4.000	0.030	4	Cylindrical	■
ST5541-.750D2R060.0Z4	SIRA	10302822	2	D	0.750	0.750	1.500	4.000	0.060	4	Cylindrical	■
ST5541-.750D2R090.0Z4	SIRA	10302823	2	D	0.750	0.750	1.500	4.000	0.090	4	Cylindrical	■
ST5541-.750D2R120.0Z4	SIRA	10302824	2	D	0.750	0.750	1.500	4.000	0.120	4	Cylindrical	■
ST5541-.750D2R250.0Z4	SIRA	10302825	2	D	0.750	0.750	1.500	4.000	0.250	4	Cylindrical	■
ST5541-.875D2R030.0Z4	SIRA	10302827	2	D	0.875	0.875	1.750	4.000	0.030	4	Cylindrical	■
ST5541-1.00D2R030.0Z4	SIRA	10302828	2	D	1.000	1.000	2.000	5.000	0.030	4	Cylindrical	■

■ **Prodotto standard.**

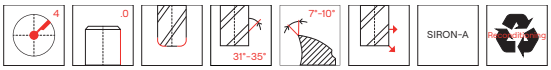
ST5541

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





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
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—Riaffilatura possibile se DC è ≥Ø.250



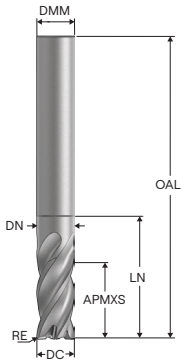
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
ST5541-.125D3R010.0Z4	SIRA	10302830	3	D	0.125	0.125	0.375	1.500	0.010	4	Cylindrical	■
ST5541-.156F3R010.0Z4	SIRA	10302831	3	F	0.156	0.188	0.469	2.000	0.010	4	Cylindrical	■
ST5541-.188D3R010.0Z4	SIRA	10302832	3	D	0.188	0.188	0.563	2.000	0.010	4	Cylindrical	■
ST5541-.219F3R020.0Z4	SIRA	10302833	3	F	0.219	0.250	0.656	2.500	0.020	4	Cylindrical	■
ST5541-.250D3R020.0Z4	SIRA	10302834	3	D	0.250	0.250	0.750	2.500	0.020	4	Cylindrical	■
ST5541-.281F3R020.0Z4	SIRA	10302835	3	F	0.281	0.313	0.844	2.500	0.020	4	Cylindrical	■
ST5541-.313D3R020.0Z4	SIRA	10302836	3	D	0.313	0.313	0.938	2.500	0.020	4	Cylindrical	■
ST5541-.375D3R020.0Z4	SIRA	10302837	3	D	0.375	0.375	1.125	3.000	0.020	4	Cylindrical	■
ST5541-.438D3R020.0Z4	SIRA	10302838	3	D	0.438	0.438	1.313	4.000	0.020	4	Cylindrical	■
ST5541-.500D3R030.0Z4	SIRA	10302839	3	D	0.500	0.500	1.250	3.000	0.030	4	Cylindrical	■
ST5541-.500D3R060.0Z4	SIRA	10302840	3	D	0.500	0.500	1.250	3.000	0.060	4	Cylindrical	■
ST5541-.500D3R120.0Z4	SIRA	10302841	3	D	0.500	0.500	1.250	3.000	0.120	4	Cylindrical	■
ST5541-.625D3R030.0Z4	SIRA	10302842	3	D	0.625	0.625	1.875	4.000	0.030	4	Cylindrical	■
ST5541-.625D3R060.0Z4	SIRA	10302843	3	D	0.625	0.625	1.875	4.000	0.060	4	Cylindrical	■
ST5541-.625D3R090.0Z4	SIRA	10302844	3	D	0.625	0.625	1.875	4.000	0.090	4	Cylindrical	■
ST5541-.625D3R120.0Z4	SIRA	10302845	3	D	0.625	0.625	1.875	4.000	0.120	4	Cylindrical	■
ST5541-.750D3R030.0Z4	SIRA	10302846	3	D	0.750	0.750	2.250	5.000	0.030	4	Cylindrical	■
ST5541-.750D3R060.0Z4	SIRA	10302847	3	D	0.750	0.750	2.250	5.000	0.060	4	Cylindrical	■
ST5541-.750D3R090.0Z4	SIRA	10302848	3	D	0.750	0.750	2.250	5.000	0.090	4	Cylindrical	■
ST5541-.750D3R120.0Z4	SIRA	10302849	3	D	0.750	0.750	2.250	5.000	0.120	4	Cylindrical	■
ST5541-.750D3R250.0Z4	SIRA	10302850	3	D	0.750	0.750	2.250	5.000	0.250	4	Cylindrical	■
ST5541-.875D3R030.0Z4	SIRA	10302851	3	D	0.875	0.875	2.625	5.000	0.030	4	Cylindrical	■
ST5541-1.00D3R030.0Z4	SIRA	10302852	3	D	1.000	1.000	3.000	6.000	0.030	4	Cylindrical	■
ST5541-.500D4R030.0Z4	SIRA	10302853	4	D	0.500	0.500	1.500	4.000	0.030	4	Cylindrical	■

■ **Prodotto standard.**

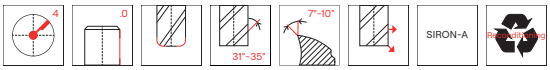
ST5541

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





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Riaffilatura possibile



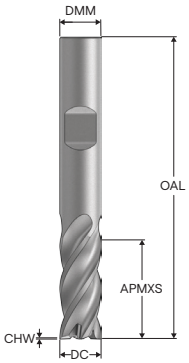
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch	inch	inch			
ST5541-.250E2R020.0Z4	SIRA	10302804	2	E	0.250	0.250	0.500	2.500	0.750	0.240	0.020	4	Cylindrical	■
ST5541-.313E2R020.0Z4	SIRA	10302807	2	E	0.313	0.313	0.625	3.000	0.938	0.300	0.020	4	Cylindrical	■
ST5541-.375E2R020.0Z4	SIRA	10302809	2	E	0.375	0.375	0.750	3.000	1.125	0.360	0.020	4	Cylindrical	■
ST5541-.438E2R020.0Z4	SIRA	10302811	2	E	0.438	0.438	0.875	4.000	1.313	0.420	0.020	4	Cylindrical	■
ST5541-.500E2R030.0Z4	SIRA	10302815	2	E	0.500	0.500	1.000	3.000	1.500	0.480	0.030	4	Cylindrical	■
ST5541-.625E2R030.0Z4	SIRA	10302820	2	E	0.625	0.625	1.250	3.500	1.875	0.600	0.030	4	Cylindrical	■
ST5541-.750E2R030.0Z4	SIRA	10302826	2	E	0.750	0.750	1.500	4.000	2.250	0.720	0.030	4	Cylindrical	■
ST5541-1.00E2R030.0Z4	SIRA	10302829	2	E	1.000	1.000	2.000	5.000	3.000	0.960	0.030	4	Cylindrical	■

■ **Prodotto standard.**

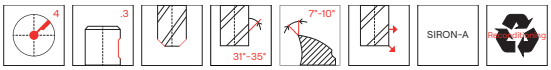
ST5541

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





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



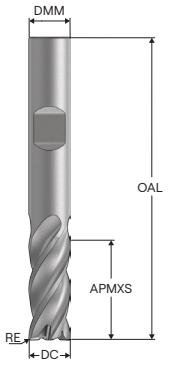
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
ST5541-060D2C.3Z4	SIRA	10302996	2	D	6,0	6,0	14,0	58,0	0,075	4	Weldon	☐
ST5541-080D2C.3Z4	SIRA	10302997	2	D	8,0	8,0	18,0	64,0	0,1	4	Weldon	☐
ST5541-100D2C.3Z4	SIRA	10302998	2	D	10,0	10,0	22,0	73,0	0,125	4	Weldon	☐
ST5541-120D2C.3Z4	SIRA	10302999	2	D	12,0	12,0	26,0	84,0	0,15	4	Weldon	☐
ST5541-160D2C.3Z4	SIRA	10303000	2	D	16,0	16,0	34,0	95,0	0,2	4	Weldon	☐
ST5541-200D2C.3Z4	SIRA	10303001	2	D	20,0	20,0	42,0	109,0	0,25	4	Weldon	☐
ST5541-250D2C.3Z4	SIRA	10303002	2	D	25,0	25,0	52,0	125,0	0,3	4	Weldon	☐
ST5541-060D3C.3Z4	SIRA	10303003	3	D	6,0	6,0	18,0	64,0	0,075	4	Weldon	☐
ST5541-080D3C.3Z4	SIRA	10303004	3	D	8,0	8,0	24,0	73,0	0,1	4	Weldon	☐
ST5541-100D3C.3Z4	SIRA	10303005	3	D	10,0	10,0	30,0	85,0	0,125	4	Weldon	☐
ST5541-120D3C.3Z4	SIRA	10303006	3	D	12,0	12,0	36,0	100,0	0,15	4	Weldon	☐
ST5541-160D3C.3Z4	SIRA	10303007	3	D	16,0	16,0	48,0	115,0	0,2	4	Weldon	☐
ST5541-200D3C.3Z4	SIRA	10303008	3	D	20,0	20,0	60,0	125,0	0,25	4	Weldon	☐
ST5541-250D3C.3Z4	SIRA	10303009	3	D	25,0	25,0	75,0	155,0	0,3	4	Weldon	☐

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

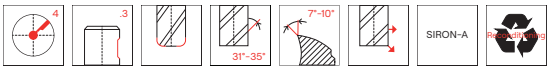
ST5541

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





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



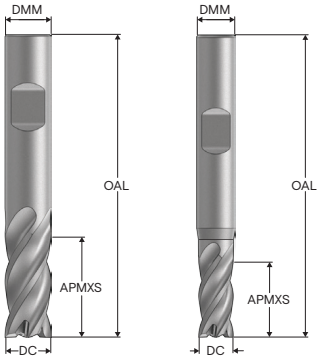
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
ST5541-060D2R050.3Z4	SIRA	10303010	2	D	6,0	6,0	14,0	58,0	0,5	4	Weldon	☐
ST5541-080D2R050.3Z4	SIRA	10303011	2	D	8,0	8,0	18,0	64,0	0,5	4	Weldon	☐
ST5541-100D2R050.3Z4	SIRA	10303012	2	D	10,0	10,0	22,0	73,0	0,5	4	Weldon	☐
ST5541-120D2R050.3Z4	SIRA	10303013	2	D	12,0	12,0	26,0	84,0	0,5	4	Weldon	☐
ST5541-120D2R100.3Z4	SIRA	10303014	2	D	12,0	12,0	26,0	84,0	1,0	4	Weldon	☐
ST5541-160D2R050.3Z4	SIRA	10303015	2	D	16,0	16,0	34,0	95,0	0,5	4	Weldon	☐
ST5541-160D2R100.3Z4	SIRA	10303017	2	D	16,0	16,0	34,0	95,0	1,0	4	Weldon	☐
ST5541-160D2R300.3Z4	SIRA	10303016	2	D	16,0	16,0	34,0	95,0	3,0	4	Weldon	☐
ST5541-200D2R050.3Z4	SIRA	10303018	2	D	20,0	20,0	42,0	109,0	0,5	4	Weldon	☐
ST5541-200D2R100.3Z4	SIRA	10303020	2	D	20,0	20,0	42,0	109,0	1,0	4	Weldon	☐
ST5541-200D2R300.3Z4	SIRA	10303019	2	D	20,0	20,0	42,0	109,0	3,0	4	Weldon	☐
ST5541-250D2R050.3Z4	SIRA	10303021	2	D	25,0	25,0	52,0	125,0	0,5	4	Weldon	☐
ST5541-250D2R100.3Z4	SIRA	10303023	2	D	25,0	25,0	52,0	125,0	1,0	4	Weldon	☐
ST5541-250D2R300.3Z4	SIRA	10303022	2	D	25,0	25,0	52,0	125,0	3,0	4	Weldon	☐
ST5541-060D3R050.3Z4	SIRA	10303024	3	D	6,0	6,0	18,0	64,0	0,5	4	Weldon	☐
ST5541-080D3R050.3Z4	SIRA	10303025	3	D	8,0	8,0	24,0	73,0	0,5	4	Weldon	☐
ST5541-100D3R050.3Z4	SIRA	10303026	3	D	10,0	10,0	30,0	85,0	0,5	4	Weldon	☐
ST5541-120D3R050.3Z4	SIRA	10303027	3	D	12,0	12,0	36,0	100,0	0,5	4	Weldon	☐
ST5541-120D3R100.3Z4	SIRA	10303028	3	D	12,0	12,0	36,0	100,0	1,0	4	Weldon	☐
ST5541-160D3R050.3Z4	SIRA	10303029	3	D	16,0	16,0	48,0	115,0	0,5	4	Weldon	☐
ST5541-160D3R100.3Z4	SIRA	10303031	3	D	16,0	16,0	48,0	115,0	1,0	4	Weldon	☐
ST5541-160D3R300.3Z4	SIRA	10303030	3	D	16,0	16,0	48,0	115,0	3,0	4	Weldon	☐
ST5541-200D3R050.3Z4	SIRA	10303032	3	D	20,0	20,0	60,0	125,0	0,5	4	Weldon	☐
ST5541-200D3R100.3Z4	SIRA	10303034	3	D	20,0	20,0	60,0	125,0	1,0	4	Weldon	☐
ST5541-200D3R300.3Z4	SIRA	10303033	3	D	20,0	20,0	60,0	125,0	3,0	4	Weldon	☐
ST5541-250D3R050.3Z4	SIRA	10303035	3	D	25,0	25,0	75,0	155,0	0,5	4	Weldon	☐
ST5541-250D3R100.3Z4	SIRA	10303037	3	D	25,0	25,0	75,0	155,0	1,0	4	Weldon	☐
ST5541-250D3R300.3Z4	SIRA	10303036	3	D	25,0	25,0	75,0	155,0	3,0	4	Weldon	☐

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

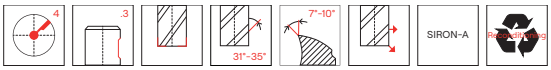
ST5541

Alte prestazioni – Acciaio – Spallamento – 4 Eliche – Weldon – Spigolo vivo – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Riaffilatura possibile



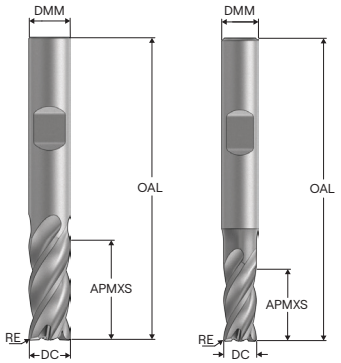
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
ST5541-.250D1S.3Z4	SIRA	10302854	1	D	0.250	0.250	0.250	2.000	4	Weldon	□
ST5541-.281F1S.3Z4	SIRA	10302855	1	F	0.281	0.313	0.281	2.000	4	Weldon	□
ST5541-.313D1S.3Z4	SIRA	10302856	1	D	0.313	0.313	0.313	2.000	4	Weldon	□
ST5541-.375D1S.3Z4	SIRA	10302857	1	D	0.375	0.375	0.375	2.000	4	Weldon	■
ST5541-.438D1S.3Z4	SIRA	10302858	1	D	0.438	0.438	0.438	2.750	4	Weldon	■
ST5541-.500D1S.3Z4	SIRA	10302859	1	D	0.500	0.500	0.500	2.500	4	Weldon	■
ST5541-.625D1S.3Z4	SIRA	10302860	1	D	0.625	0.625	0.625	3.000	4	Weldon	■
ST5541-.750D1S.3Z4	SIRA	10302861	1	D	0.750	0.750	0.750	3.000	4	Weldon	■
ST5541-.875D1S.3Z4	SIRA	10302862	1	D	0.875	0.875	0.875	4.000	4	Weldon	□
ST5541-1.00D1S.3Z4	SIRA	10302863	1	D	1.000	1.000	1.000	4.000	4	Weldon	■
ST5541-.250D2S.3Z4	SIRA	10302864	2	D	0.250	0.250	0.500	2.500	4	Weldon	□
ST5541-.281F2S.3Z4	SIRA	10302865	2	F	0.281	0.313	0.563	2.500	4	Weldon	□
ST5541-.313D2S.3Z4	SIRA	10302866	2	D	0.313	0.313	0.625	2.500	4	Weldon	□
ST5541-.375D2S.3Z4	SIRA	10302867	2	D	0.375	0.375	0.750	2.500	4	Weldon	■
ST5541-.438D2S.3Z4	SIRA	10302868	2	D	0.438	0.438	0.875	2.750	4	Weldon	■
ST5541-.500D2S.3Z4	SIRA	10302869	2	D	0.500	0.500	1.000	3.000	4	Weldon	■
ST5541-.625D2S.3Z4	SIRA	10302870	2	D	0.625	0.625	1.250	3.500	4	Weldon	■
ST5541-.750D2S.3Z4	SIRA	10302871	2	D	0.750	0.750	1.500	4.000	4	Weldon	■
ST5541-.875D2S.3Z4	SIRA	10302872	2	D	0.875	0.875	1.750	4.000	4	Weldon	□
ST5541-1.00D2S.3Z4	SIRA	10302873	2	D	1.000	1.000	2.000	5.000	4	Weldon	■
ST5541-.250D3S.3Z4	SIRA	10302874	3	D	0.250	0.250	0.750	2.500	4	Weldon	□
ST5541-.281F3S.3Z4	SIRA	10302875	3	F	0.281	0.313	0.844	2.500	4	Weldon	□
ST5541-.313D3S.3Z4	SIRA	10302876	3	D	0.313	0.313	0.938	2.500	4	Weldon	□
ST5541-.375D3S.3Z4	SIRA	10302877	3	D	0.375	0.375	1.125	3.000	4	Weldon	■
ST5541-.438D3S.3Z4	SIRA	10302878	3	D	0.438	0.438	1.313	4.000	4	Weldon	■
ST5541-.500D3S.3Z4	SIRA	10302879	3	D	0.500	0.500	1.250	3.000	4	Weldon	■
ST5541-.625D3S.3Z4	SIRA	10302880	3	D	0.625	0.625	1.875	4.000	4	Weldon	■
ST5541-.750D3S.3Z4	SIRA	10302881	3	D	0.750	0.750	2.250	5.000	4	Weldon	■
ST5541-.875D3S.3Z4	SIRA	10302882	3	D	0.875	0.875	2.625	5.000	4	Weldon	□
ST5541-1.00D3S.3Z4	SIRA	10302883	3	D	1.000	1.000	3.000	6.000	4	Weldon	■
ST5541-.500D4S.3Z4	SIRA	10302884	4	D	0.500	0.500	1.500	4.000	4	Weldon	■

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

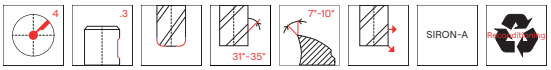
ST5541

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





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Riaffilatura possibile



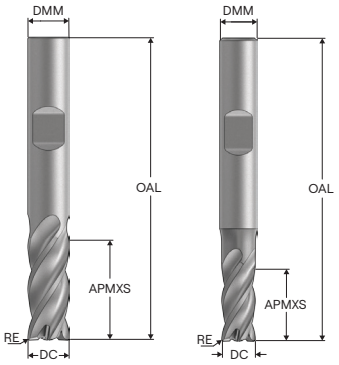
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
ST5541-.250D1R020.3Z4	SIRA	10302885	1	D	0.250	0.250	0.250	2.000	0.020	4	Weldon	□
ST5541-.281F1R020.3Z4	SIRA	10302886	1	F	0.281	0.313	0.281	2.000	0.020	4	Weldon	□
ST5541-.313D1R020.3Z4	SIRA	10302887	1	D	0.313	0.313	0.313	2.000	0.020	4	Weldon	□
ST5541-.375D1R020.3Z4	SIRA	10302888	1	D	0.375	0.375	0.375	2.000	0.020	4	Weldon	■
ST5541-.438D1R020.3Z4	SIRA	10302889	1	D	0.438	0.438	0.438	2.750	0.020	4	Weldon	□
ST5541-.500D1R030.3Z4	SIRA	10302890	1	D	0.500	0.500	0.500	2.500	0.030	4	Weldon	■
ST5541-.625D1R030.3Z4	SIRA	10302891	1	D	0.625	0.625	0.625	3.000	0.030	4	Weldon	■
ST5541-.750D1R030.3Z4	SIRA	10302892	1	D	0.750	0.750	0.750	3.000	0.030	4	Weldon	■
ST5541-.875D1R030.3Z4	SIRA	10302893	1	D	0.875	0.875	0.875	4.000	0.030	4	Weldon	□
ST5541-1.00D1R030.3Z4	SIRA	10302894	1	D	1.000	1.000	1.000	4.000	0.030	4	Weldon	■
ST5541-.250D2R020.3Z4	SIRA	10302895	2	D	0.250	0.250	0.500	2.500	0.020	4	Weldon	□
ST5541-.281F2R020.3Z4	SIRA	10302897	2	F	0.281	0.313	0.563	2.500	0.020	4	Weldon	□
ST5541-.313D2R020.3Z4	SIRA	10302898	2	D	0.313	0.313	0.625	2.500	0.020	4	Weldon	□
ST5541-.375D2R020.3Z4	SIRA	10302900	2	D	0.375	0.375	0.750	2.500	0.020	4	Weldon	■
ST5541-.438D2R020.3Z4	SIRA	10302902	2	D	0.438	0.438	0.875	2.750	0.020	4	Weldon	□
ST5541-.500D2R030.3Z4	SIRA	10302904	2	D	0.500	0.500	1.000	3.000	0.030	4	Weldon	■
ST5541-.500D2R060.3Z4	SIRA	10302905	2	D	0.500	0.500	1.000	3.000	0.060	4	Weldon	□
ST5541-.500D2R120.3Z4	SIRA	10302907	2	D	0.500	0.500	1.000	3.000	0.120	4	Weldon	□
ST5541-.625D2R030.3Z4	SIRA	10302908	2	D	0.625	0.625	1.250	3.500	0.030	4	Weldon	■
ST5541-.625D2R060.3Z4	SIRA	10302909	2	D	0.625	0.625	1.250	3.500	0.060	4	Weldon	□
ST5541-.625D2R090.3Z4	SIRA	10302910	2	D	0.625	0.625	1.250	3.500	0.090	4	Weldon	□
ST5541-.625D2R120.3Z4	SIRA	10302911	2	D	0.625	0.625	1.250	3.500	0.120	4	Weldon	□
ST5541-.750D2R030.3Z4	SIRA	10302913	2	D	0.750	0.750	1.500	4.000	0.030	4	Weldon	■
ST5541-.750D2R060.3Z4	SIRA	10302914	2	D	0.750	0.750	1.500	4.000	0.060	4	Weldon	□
ST5541-.750D2R090.3Z4	SIRA	10302915	2	D	0.750	0.750	1.500	4.000	0.090	4	Weldon	□
ST5541-.750D2R120.3Z4	SIRA	10302916	2	D	0.750	0.750	1.500	4.000	0.120	4	Weldon	□
ST5541-.750D2R250.3Z4	SIRA	10302917	2	D	0.750	0.750	1.500	4.000	0.250	4	Weldon	□
ST5541-.875D2R030.3Z4	SIRA	10302919	2	D	0.875	0.875	1.750	4.000	0.030	4	Weldon	□
ST5541-1.00D2R030.3Z4	SIRA	10302920	2	D	1.000	1.000	2.000	5.000	0.030	4	Weldon	■

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

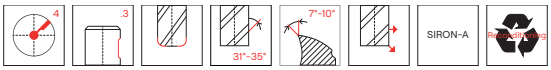
ST5541

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





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Riaffilatura possibile



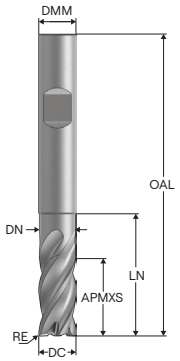
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
ST5541-.250D3R020.3Z4	SIRA	10302922	3	D	0.250	0.250	0.750	2.500	0.020	4	Weldon	□
ST5541-.281F3R020.3Z4	SIRA	10302923	3	F	0.281	0.313	0.844	2.500	0.020	4	Weldon	□
ST5541-.313D3R020.3Z4	SIRA	10302924	3	D	0.313	0.313	0.938	2.500	0.020	4	Weldon	□
ST5541-.375D3R020.3Z4	SIRA	10302925	3	D	0.375	0.375	1.125	3.000	0.020	4	Weldon	■
ST5541-.438D3R020.3Z4	SIRA	10302926	3	D	0.438	0.438	1.313	4.000	0.020	4	Weldon	□
ST5541-.500D3R030.3Z4	SIRA	10302927	3	D	0.500	0.500	1.250	3.000	0.030	4	Weldon	■
ST5541-.500D3R060.3Z4	SIRA	10302928	3	D	0.500	0.500	1.250	3.000	0.060	4	Weldon	□
ST5541-.500D3R120.3Z4	SIRA	10302929	3	D	0.500	0.500	1.250	3.000	0.120	4	Weldon	□
ST5541-.625D3R030.3Z4	SIRA	10302930	3	D	0.625	0.625	1.875	4.000	0.030	4	Weldon	■
ST5541-.625D3R060.3Z4	SIRA	10302931	3	D	0.625	0.625	1.875	4.000	0.060	4	Weldon	□
ST5541-.625D3R090.3Z4	SIRA	10302932	3	D	0.625	0.625	1.875	4.000	0.090	4	Weldon	□
ST5541-.625D3R120.3Z4	SIRA	10302933	3	D	0.625	0.625	1.875	4.000	0.120	4	Weldon	□
ST5541-.750D3R030.3Z4	SIRA	10302934	3	D	0.750	0.750	2.250	5.000	0.030	4	Weldon	■
ST5541-.750D3R060.3Z4	SIRA	10302935	3	D	0.750	0.750	2.250	5.000	0.060	4	Weldon	□
ST5541-.750D3R090.3Z4	SIRA	10302936	3	D	0.750	0.750	2.250	5.000	0.090	4	Weldon	□
ST5541-.750D3R120.3Z4	SIRA	10302937	3	D	0.750	0.750	2.250	5.000	0.120	4	Weldon	□
ST5541-.750D3R250.3Z4	SIRA	10302938	3	D	0.750	0.750	2.250	5.000	0.250	4	Weldon	□
ST5541-.875D3R030.3Z4	SIRA	10302939	3	D	0.875	0.875	2.625	5.000	0.030	4	Weldon	□
ST5541-1.00D3R030.3Z4	SIRA	10302940	3	D	1.000	1.000	3.000	6.000	0.030	4	Weldon	■
ST5541-.500D4R030.3Z4	SIRA	10302941	4	D	0.500	0.500	1.500	4.000	0.030	4	Weldon	■

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

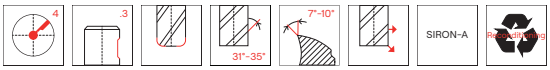
ST5541

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





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Riaffilatura possibile



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch	inch	inch			
ST5541-.250E2R020.3Z4	SIRA	10302896	2	E	0.250	0.250	0.500	2.500	0.750	0.240	0.020	4	Weldon	☐
ST5541-.313E2R020.3Z4	SIRA	10302899	2	E	0.313	0.313	0.625	3.000	0.938	0.300	0.020	4	Weldon	☐
ST5541-.375E2R020.3Z4	SIRA	10302901	2	E	0.375	0.375	0.750	3.000	1.125	0.360	0.020	4	Weldon	☐
ST5541-.438E2R020.3Z4	SIRA	10302903	2	E	0.438	0.438	0.875	4.000	1.313	0.420	0.020	4	Weldon	☐
ST5541-.500E2R030.3Z4	SIRA	10302906	2	E	0.500	0.500	1.000	3.000	1.500	0.480	0.030	4	Weldon	☐
ST5541-.625E2R030.3Z4	SIRA	10302912	2	E	0.625	0.625	1.250	3.500	1.875	0.600	0.030	4	Weldon	☐
ST5541-.750E2R030.3Z4	SIRA	10302918	2	E	0.750	0.750	1.500	4.000	2.250	0.720	0.030	4	Weldon	☐
ST5541-1.00E2R030.3Z4	SIRA	10302921	2	E	1.000	1.000	2.000	5.000	3.000	0.960	0.030	4	Weldon	☐

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

Parametri di taglio – ST5541 Contornatura

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	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,3 *0.012*	220 (170 — 230) *720 (560 — 750)*
P2	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,24 *0.0095*	0,26 *0.010*	0,3 *0.012*	215 (160 — 220) *710 (530 — 720)*
P3	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	190 (140 — 200) *620 (460 — 650)*
P4	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
P5	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	160 (120 — 170) *520 (400 — 550)*
P6	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,28 *0.011*	180 (140 — 190) *590 (460 — 620)*
P7	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,28 *0.011*	170 (130 — 180) *560 (430 — 590)*
P8	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	160 (120 — 160) *520 (400 — 520)*
P11	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
P12	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,03 *0.0012*	0,038 *0.0015*	0,048 *0.0019*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	110 (80 — 110) *360 (270 — 360)*
K1	E	0,25 *0.25*	1,5 *1.5*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,24 *0.0095*	0,26 *0.010*	0,3 *0.012*	215 (170 — 230) *710 (560 — 750)*
K2	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	195 (150 — 200) *640 (500 — 650)*
K3	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
K4	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	160 (120 — 160) *520 (400 — 520)*
K5	E	0,25 *0.25*	1,5 *1.5*	0,038 *0.0015*	0,05 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,1 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	0,22 *0.0085*	0,25 *0.010*	95 (71 — 100) *310 (240 — 320)*
K6	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	140 (110 — 140) *460 (370 — 450)*
K7	E	0,25 *0.25*	1,5 *1.5*	0,038 *0.0015*	0,05 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,1 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	0,22 *0.0085*	0,25 *0.010*	120 (91 — 130) *395 (300 — 420)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – ST5541 Scanalatura

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	195 (150 — 200) *640 (500 — 650)*
P2	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	190 (140 — 200) *620 (460 — 650)*
P3	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	165 (130 — 170) *540 (430 — 550)*
P4	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	145 (110 — 150) *475 (370 — 490)*
P5	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	135 (110 — 140) *445 (370 — 450)*
P6	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	155 (120 — 160) *510 (400 — 520)*
P7	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	145 (110 — 150) *475 (370 — 490)*
P8	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	135 (110 — 140) *445 (370 — 450)*
P11	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 150) *460 (370 — 490)*
P12	M/A/D/E	1,5 *1.5*	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*	85 (64 — 92) *280 (210 — 300)*
K1	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	190 (150 — 200) *620 (500 — 650)*
K2	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	165 (130 — 170) *540 (430 — 550)*
K3	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 140) *460 (370 — 450)*
K4	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	135 (99 — 140) *445 (330 — 450)*
K5	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	80 (59 — 85) *260 (200 — 270)*
K6	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	120 (87 — 120) *395 (290 — 390)*
K7	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	100 (76 — 100) *330 (250 — 320)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – ST5541 Contornatura – Inch

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	
P1	M/A/D/E	0,25	1,5	0,05	0,06	0,075	0,085	0,1	0,11	0,12	0,15	0,17	0,19	0,22	0,25	0,28	0,3	220 (170 — 230)
		0.25	*1.5*	*0.0020*	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.011*	*0.012*	*720 (560 — 750)*
P2	M/A/D/E	0,25	1,5	0,05	0,065	0,075	0,09	0,1	0,11	0,13	0,15	0,17	0,2	0,24	0,26	0,28	0,3	215 (160 — 220)
		0.25	*1.5*	*0.0020*	*0.0026*	*0.0030*	*0.0036*	*0.0040*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.011*	*0.012*	*710 (530 — 720)*
P3	M/A/D/E	0,25	1,5	0,048	0,06	0,07	0,085	0,095	0,11	0,12	0,14	0,17	0,18	0,22	0,25	0,26	0,28	190 (140 — 200)
		0.25	*1.5*	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*0.0085*	*0.010*	*0.010*	*0.011*	*620 (460 — 650)*
P4	M/A/D/E	0,25	1,5	0,046	0,06	0,07	0,08	0,095	0,1	0,12	0,14	0,16	0,18	0,22	0,24	0,26	0,28	165 (130 — 170)
		0.25	*1.5*	*0.0018*	*0.0024*	*0.0028*	*0.0032*	*0.0038*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*0.0085*	*0.0095*	*0.010*	*0.011*	*540 (430 — 550)*
P5	M/A/D/E	0,25	1,5	0,046	0,055	0,07	0,08	0,09	0,1	0,11	0,14	0,16	0,18	0,2	0,24	0,26	0,28	160 (120 — 170)
		0.25	*1.5*	*0.0018*	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*0.0095*	*0.010*	*0.011*	*520 (400 — 550)*
P6	M/A/D/E	0,25	1,5	0,046	0,055	0,07	0,08	0,09	0,1	0,11	0,14	0,16	0,18	0,2	0,24	0,26	0,28	180 (140 — 190)
		0.25	*1.5*	*0.0018*	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*0.0095*	*0.010*	*0.011*	*590 (460 — 620)*
P7	M/A/D/E	0,25	1,5	0,046	0,055	0,07	0,08	0,09	0,1	0,11	0,14	0,16	0,18	0,2	0,24	0,26	0,28	170 (130 — 180)
		0.25	*1.5*	*0.0018*	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*0.0095*	*0.010*	*0.011*	*560 (430 — 590)*
P8	M/A/D/E	0,25	1,5	0,048	0,06	0,07	0,085	0,095	0,11	0,12	0,14	0,17	0,18	0,22	0,25	0,26	0,28	160 (120 — 160)
		0.25	*1.5*	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*0.0085*	*0.010*	*0.010*	*0.011*	*520 (400 — 520)*
P11	M/A/D/E	0,25	1,5	0,046	0,055	0,07	0,08	0,09	0,1	0,11	0,14	0,16	0,18	0,2	0,24	0,26	0,28	165 (130 — 170)
		0.25	*1.5*	*0.0018*	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*0.0095*	*0.010*	*0.011*	*540 (430 — 550)*
P12	M/A/D/E	0,25	1,5	0,03	0,038	0,046	0,055	0,06	0,07	0,075	0,095	0,11	0,12	0,14	0,16	0,18	0,19	110 (80 — 110)
		0.25	*1.5*	*0.0012*	*0.0015*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*0.0030*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*0.0075*	*360 (270 — 360)*
K1	E	0,25	1,5	0,05	0,065	0,075	0,09	0,1	0,11	0,13	0,15	0,17	0,2	0,24	0,26	0,28	0,3	215 (170 — 230)
		0.25	*1.5*	*0.0020*	*0.0026*	*0.0030*	*0.0036*	*0.0040*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.011*	*0.012*	*710 (560 — 750)*
K2	E	0,25	1,5	0,046	0,055	0,07	0,08	0,09	0,1	0,11	0,14	0,16	0,18	0,2	0,24	0,26	0,28	195 (150 — 200)
		0.25	*1.5*	*0.0018*	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*0.0095*	*0.010*	*0.011*	*640 (500 — 650)*
K3	E	0,25	1,5	0,046	0,055	0,07	0,08	0,09	0,1	0,11	0,14	0,16	0,18	0,2	0,24	0,26	0,28	165 (130 — 170)
		0.25	*1.5*	*0.0018*	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*0.0095*	*0.010*	*0.011*	*540 (430 — 550)*
K4	E	0,25	1,5	0,046	0,055	0,07	0,08	0,09	0,1	0,11	0,14	0,16	0,18	0,2	0,24	0,26	0,28	160 (120 — 160)
		0.25	*1.5*	*0.0018*	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*0.0095*	*0.010*	*0.011*	*520 (400 — 520)*
K5	E	0,25	1,5	0,04	0,05	0,06	0,07	0,08	0,09	0,1	0,12	0,14	0,16	0,19	0,22	0,24	0,25	95 (71 — 100)
		0.25	*1.5*	*0.0016*	*0.0020*	*0.0024*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*310 (240 — 320)*
K6	E	0,25	1,5	0,046	0,055	0,07	0,08	0,09	0,1	0,11	0,14	0,16	0,18	0,2	0,24	0,26	0,28	140 (110 — 140)
		0.25	*1.5*	*0.0018*	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*0.0095*	*0.010*	*0.011*	*460 (370 — 450)*
K7	E	0,25	1,5	0,04	0,05	0,06	0,07	0,08	0,09	0,1	0,12	0,14	0,16	0,19	0,22	0,24	0,25	120 (91 — 130)
		0.25	*1.5*	*0.0016*	*0.0020*	*0.0024*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*395 (300 — 420)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – ST5541 Scanalatura – Inch

SMG		a_p/DC	f_z														v_c
			1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	
P1	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,16	195 (150 — 200)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*640 (500 — 650)*
P2	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,17	190 (140 — 200)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*620 (460 — 650)*
P3	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,16	165 (130 — 170)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*540 (430 — 550)*
P4	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	145 (110 — 150)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*475 (370 — 490)*
P5	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	135 (110 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*445 (370 — 450)*
P6	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	155 (120 — 160)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*510 (400 — 520)*
P7	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	145 (110 — 150)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*475 (370 — 490)*
P8	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,16	135 (110 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*445 (370 — 450)*
P11	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	140 (110 — 150)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*460 (370 — 490)*
P12	M/A/D/E	1,5	0,017	0,022	0,025	0,030	0,034	0,038	0,042	0,050	0,060	0,065	0,080	0,085	0,095	0,10	85 (64 — 92)
		1.5	*0.00065*	*0.00085*	*0.0010*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*0.0034*	*0.0038*	*0.0040*	*280 (210 — 300)*
K1	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,17	190 (150 — 200)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*620 (500 — 650)*
K2	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	165 (130 — 170)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*540 (430 — 550)*
K3	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	140 (110 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*460 (370 — 450)*
K4	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	135 (99 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*445 (330 — 450)*
K5	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,13	0,14	80 (59 — 85)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0055*	*260 (200 — 270)*
K6	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	120 (87 — 120)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*395 (290 — 390)*
K7	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,13	0,14	100 (76 — 100)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0055*	*330 (250 — 320)*

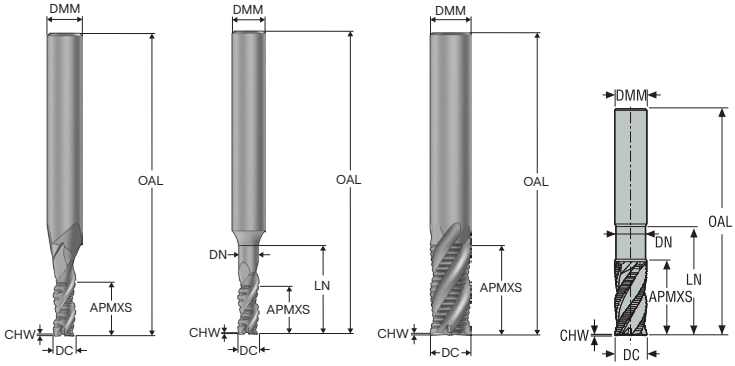
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

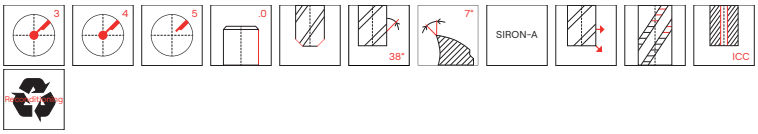
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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

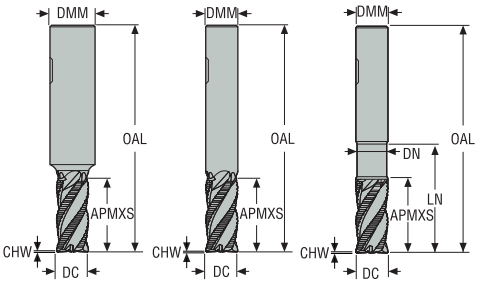
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
						mm	mm	mm	mm	mm	mm	mm			
JHP993040F2C.0Z3-SIRA	02826806	2	F	■	–	4,0	6,0	10,0	50,0	–	–	0,15	3	Cylindrical	■
JHP993050F2C.0Z4-SIRA	02826808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

■ **Prodotto standard.**

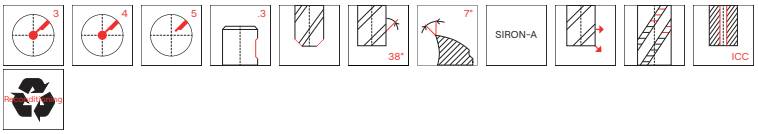
JHP993

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

■ **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 699 - 707

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 699 - 707

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

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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)*

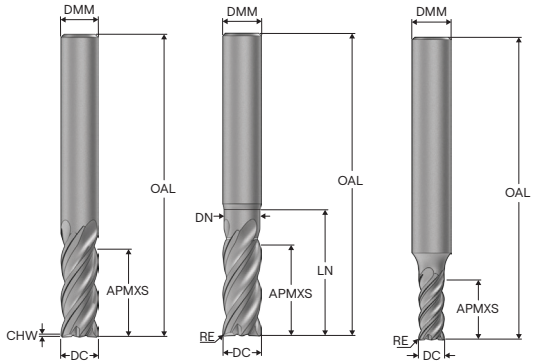
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

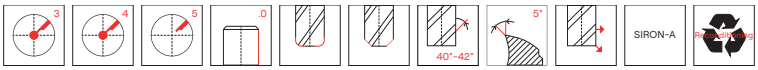
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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

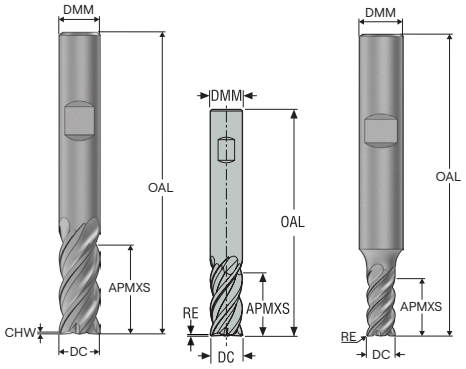
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm	mm			
JHP951030F2C.0Z3-SIRA	02828192	2	F	3,0	6,0	8,0	50,0	–	–	0,1	–	3	Cylindrical	■
JHP951030F2R020.0Z3-SIRA	02828191	2	F	3,0	6,0	8,0	50,0	–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

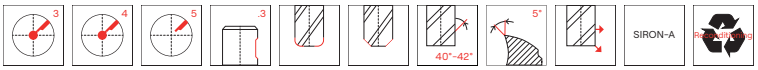
■ **Prodotto standard.**

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

■ **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 699 - 707

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)*

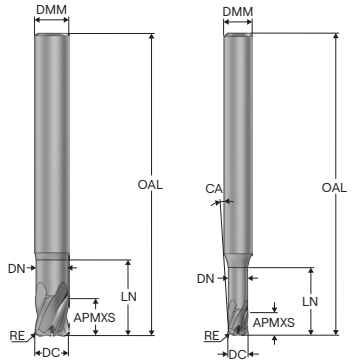
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

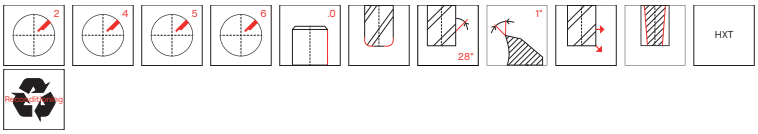
JH142

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



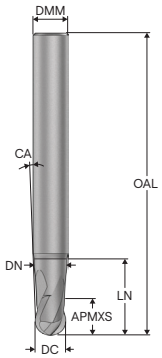
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	Cylindrical	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0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

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

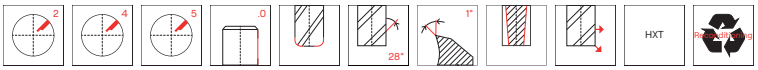
JH142

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

■ **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)*

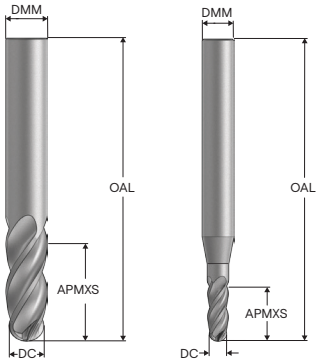
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

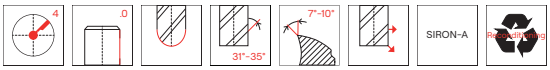
ST5341

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





– Tolleranze:
– DMM=h5
– DC=e7
– RE= ±0,01 mm
– Riaffilatura possibile se DC è ≥Ø6



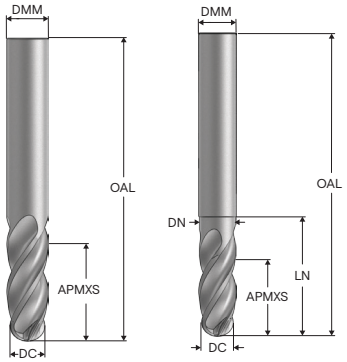
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
ST5341-030F2B.0Z4	SIRA	10302669	2	F	3,0	6,0	7,0	58,0	1,5	4	Cylindrical	■
ST5341-040F2B.0Z4	SIRA	10302670	2	F	4,0	6,0	10,0	58,0	2,0	4	Cylindrical	■
ST5341-050F2B.0Z4	SIRA	10302671	2	F	5,0	6,0	12,0	58,0	2,5	4	Cylindrical	■
ST5341-060D2B.0Z4	SIRA	10302672	2	D	6,0	6,0	14,0	58,0	3,0	4	Cylindrical	■
ST5341-080D2B.0Z4	SIRA	10302673	2	D	8,0	8,0	18,0	64,0	4,0	4	Cylindrical	■
ST5341-100D2B.0Z4	SIRA	10302674	2	D	10,0	10,0	22,0	73,0	5,0	4	Cylindrical	■
ST5341-120D2B.0Z4	SIRA	10302675	2	D	12,0	12,0	26,0	84,0	6,0	4	Cylindrical	■
ST5341-160D2B.0Z4	SIRA	10302676	2	D	16,0	16,0	34,0	95,0	8,0	4	Cylindrical	■
ST5341-200D2B.0Z4	SIRA	10302677	2	D	20,0	20,0	42,0	109,0	10,0	4	Cylindrical	■
ST5341-030F3B.0Z4	SIRA	10302678	3	F	3,0	6,0	9,0	58,0	1,5	4	Cylindrical	■
ST5341-040F3B.0Z4	SIRA	10302679	3	F	4,0	6,0	12,0	58,0	2,0	4	Cylindrical	■
ST5341-050F3B.0Z4	SIRA	10302680	3	F	5,0	6,0	15,0	58,0	2,5	4	Cylindrical	■
ST5341-060D3B.0Z4	SIRA	10302681	3	D	6,0	6,0	18,0	64,0	3,0	4	Cylindrical	■
ST5341-080D3B.0Z4	SIRA	10302682	3	D	8,0	8,0	24,0	73,0	4,0	4	Cylindrical	■
ST5341-100D3B.0Z4	SIRA	10302683	3	D	10,0	10,0	30,0	85,0	5,0	4	Cylindrical	■
ST5341-120D3B.0Z4	SIRA	10302684	3	D	12,0	12,0	36,0	100,0	6,0	4	Cylindrical	■
ST5341-160D3B.0Z4	SIRA	10302685	3	D	16,0	16,0	48,0	115,0	8,0	4	Cylindrical	■
ST5341-200D3B.0Z4	SIRA	10302686	3	D	20,0	20,0	60,0	125,0	10,0	4	Cylindrical	■

■ **Prodotto standard.**

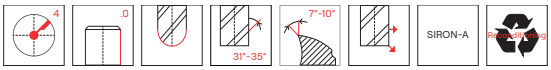
ST5341

Alte prestazioni – Acciaio – A testa sferica – 4 Eliche – Cilindrico – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0004"
—Riaffilatura possibile se DC è ≥Ø.250



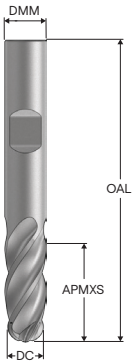
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch	inch	inch			
ST5341-.125D2B.0Z4	SIRA	10302637	2	D	0.125	0.125	0.250	1.500	–	–	0.063	4	Cylindrical	■
ST5341-.188D2B.0Z4	SIRA	10302638	2	D	0.188	0.188	0.375	2.000	–	–	0.094	4	Cylindrical	■
ST5341-.250D2B.0Z4	SIRA	10302639	2	D	0.250	0.250	0.500	2.500	–	–	0.125	4	Cylindrical	■
ST5341-.250E2B.0Z4	SIRA	10302640	2	E	0.250	0.250	0.500	2.500	0.750	0.240	0.125	4	Cylindrical	■
ST5341-.313D2B.0Z4	SIRA	10302641	2	D	0.313	0.313	0.625	2.500	–	–	0.156	4	Cylindrical	■
ST5341-.313E2B.0Z4	SIRA	10302642	2	E	0.313	0.313	0.625	3.000	0.938	0.300	0.156	4	Cylindrical	■
ST5341-.375D2B.0Z4	SIRA	10302643	2	D	0.375	0.375	0.750	2.500	–	–	0.188	4	Cylindrical	■
ST5341-.375E2B.0Z4	SIRA	10302644	2	E	0.375	0.375	0.750	3.000	1.125	0.360	0.188	4	Cylindrical	■
ST5341-.438D2B.0Z4	SIRA	10302645	2	D	0.438	0.438	0.875	2.750	–	–	0.219	4	Cylindrical	■
ST5341-.500D2B.0Z4	SIRA	10302646	2	D	0.500	0.500	1.000	3.000	–	–	0.250	4	Cylindrical	■
ST5341-.500E2B.0Z4	SIRA	10302647	2	E	0.500	0.500	1.000	3.000	1.500	0.480	0.250	4	Cylindrical	■
ST5341-.625D2B.0Z4	SIRA	10302648	2	D	0.625	0.625	1.250	3.500	–	–	0.313	4	Cylindrical	■
ST5341-.625E2B.0Z4	SIRA	10302649	2	E	0.625	0.625	1.250	3.500	1.875	0.600	0.313	4	Cylindrical	■
ST5341-.750D2B.0Z4	SIRA	10302650	2	D	0.750	0.750	1.500	4.000	–	–	0.375	4	Cylindrical	■
ST5341-.750E2B.0Z4	SIRA	10302651	2	E	0.750	0.750	1.500	4.000	2.250	0.720	0.375	4	Cylindrical	■
ST5341-1.00D2B.0Z4	SIRA	10302652	2	D	1.000	1.000	2.000	5.000	–	–	0.500	4	Cylindrical	■
ST5341-1.00E2B.0Z4	SIRA	10302653	2	E	1.000	1.000	2.000	5.000	3.000	0.960	0.500	4	Cylindrical	■

■ **Prodotto standard.**

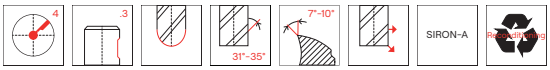
ST5341

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





—Tolleranze:
—DMM=h5
—DC=e7
—RE= ±0,01 mm
—Riaffilatura possibile



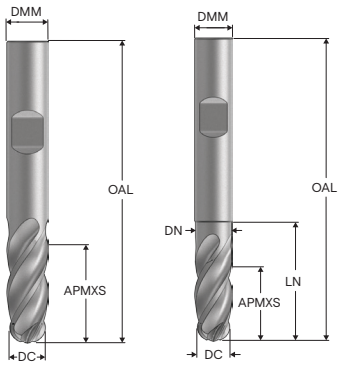
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
ST5341-060D2B.3Z4	SIRA	10302687	2	D	6,0	6,0	14,0	58,0	3,0	4	Weldon	☐
ST5341-080D2B.3Z4	SIRA	10302688	2	D	8,0	8,0	18,0	64,0	4,0	4	Weldon	☐
ST5341-100D2B.3Z4	SIRA	10302689	2	D	10,0	10,0	22,0	73,0	5,0	4	Weldon	☐
ST5341-120D2B.3Z4	SIRA	10302690	2	D	12,0	12,0	26,0	84,0	6,0	4	Weldon	☐
ST5341-160D2B.3Z4	SIRA	10302691	2	D	16,0	16,0	34,0	95,0	8,0	4	Weldon	☐
ST5341-200D2B.3Z4	SIRA	10302692	2	D	20,0	20,0	42,0	109,0	10,0	4	Weldon	☐
ST5341-060D3B.3Z4	SIRA	10302693	3	D	6,0	6,0	18,0	64,0	3,0	4	Weldon	☐
ST5341-080D3B.3Z4	SIRA	10302694	3	D	8,0	8,0	24,0	73,0	4,0	4	Weldon	☐
ST5341-100D3B.3Z4	SIRA	10302695	3	D	10,0	10,0	30,0	85,0	5,0	4	Weldon	☐
ST5341-120D3B.3Z4	SIRA	10302696	3	D	12,0	12,0	36,0	100,0	6,0	4	Weldon	☐
ST5341-160D3B.3Z4	SIRA	10302697	3	D	16,0	16,0	48,0	115,0	8,0	4	Weldon	☐
ST5341-200D3B.3Z4	SIRA	10302698	3	D	20,0	20,0	60,0	125,0	10,0	4	Weldon	☐

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

ST5341

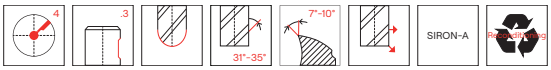
Alte prestazioni – Acciaio – A testa sferica – 4 Eliche – Weldon – Pollici





—Tolleranze:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0004"
—Riaffilatura possibile

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



Parametri di taglio – ST5341 Copiatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z										v_c
				1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	
P1	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	260 (210 — 310) *850 (690 — 1000)*
P2	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	250 (200 — 310) *820 (660 — 1000)*
P3	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	215 (180 — 260) *710 (600 — 850)*
P4	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P5	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P6	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	205 (170 — 250) *670 (560 — 820)*
P7	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P8	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P11	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
P12	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	110 (88 — 130) *360 (290 — 420)*
K1	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	255 (210 — 310) *840 (690 — 1000)*
K2	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	220 (180 — 270) *720 (600 — 880)*
K3	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
K4	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	175 (150 — 210) *570 (500 — 680)*
K5	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	105 (85 — 130) *345 (280 — 420)*
K6	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	155 (130 — 190) *510 (430 — 620)*
K7	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	135 (110 — 160) *445 (370 — 520)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – ST5341 Copiatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z										v_c
				1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	
P1	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	260 (210 — 310) *850 (690 — 1000)*
P2	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	250 (200 — 310) *820 (660 — 1000)*
P3	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	215 (180 — 260) *710 (600 — 850)*
P4	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P5	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P6	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	205 (170 — 250) *670 (560 — 820)*
P7	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P8	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P11	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
P12	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	110 (88 — 130) *360 (290 — 420)*
K1	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	255 (210 — 310) *840 (690 — 1000)*
K2	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	220 (180 — 270) *720 (600 — 880)*
K3	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
K4	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	175 (150 — 210) *570 (500 — 680)*
K5	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	105 (85 — 130) *345 (280 — 420)*
K6	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	155 (130 — 190) *510 (430 — 620)*
K7	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	135 (110 — 160) *445 (370 — 520)*

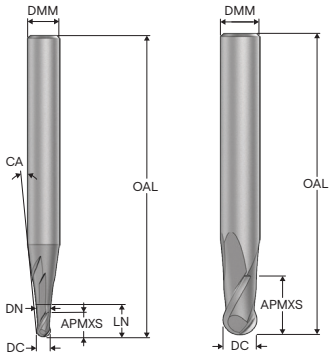
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

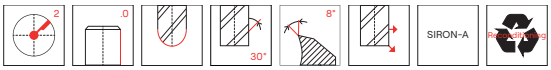
JHB970

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





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	RE	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm				
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	1,5	–	2	Cylindrical	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	2,0	–	2	Cylindrical	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	2,5	–	2	Cylindrical	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	3,0	–	2	Cylindrical	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	1,25	7,5	2	Cylindrical	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	1,75	4,5	2	Cylindrical	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	6,0	–	2	Cylindrical	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	8,0	–	2	Cylindrical	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	6,0	–	2	Cylindrical	■

■ **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)*

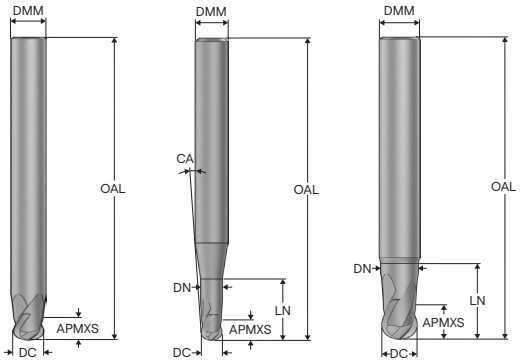
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

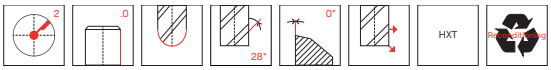
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

JH112

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







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

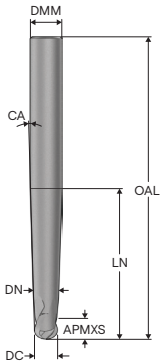
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	1,0	6,45	2	Cylindrical	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	1,5	3,3	2	Cylindrical	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	2,0	–	2	Cylindrical	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	3,0	–	2	Cylindrical	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	4,0	–	2	Cylindrical	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	5,0	–	2	Cylindrical	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	1,5	–	2	Cylindrical	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	2,0	–	2	Cylindrical	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	2,5	–	2	Cylindrical	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	3,0	–	2	Cylindrical	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	1,0	8,12	2	Cylindrical	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	1,25	7,39	2	Cylindrical	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	1,75	3,81	2	Cylindrical	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	2,0	3,34	2	Cylindrical	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	3,0	2,78	2	Cylindrical	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	4,0	–	2	Cylindrical	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	5,0	–	2	Cylindrical	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	6,0	–	2	Cylindrical	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	1,0	3,82	2	Cylindrical	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	1,5	2,91	2	Cylindrical	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	2,0	1,97	2	Cylindrical	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	2,5	0,53	2	Cylindrical	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	3,0	–	2	Cylindrical	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	4,0	–	2	Cylindrical	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	5,0	–	2	Cylindrical	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	6,0	–	2	Cylindrical	■

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

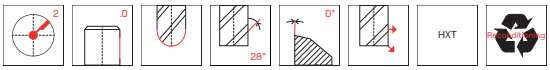
JH112

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	RE	CA°	NA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm					
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	35,0	1,9	1,0	3,3	3,55	2	Cylindrical	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	40,0	2,8	1,5	2,2	2,5	2	Cylindrical	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	52,0	3,7	2,0	1,2	1,4	2	Cylindrical	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	56,0	4,6	2,5	1,6	1,95	2	Cylindrical	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	56,0	5,6	3,0	1,1	1,4	2	Cylindrical	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	62,0	7,4	4,0	1,0	1,43	2	Cylindrical	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	61,0	9,4	5,0	1,0	1,5	2	Cylindrical	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	62,0	5,6	3,0	2,0	2,3	2	Cylindrical	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	67,0	7,4	4,0	1,8	2,3	2	Cylindrical	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	79,0	9,4	5,0	0,8	1,1	2	Cylindrical	■

■ **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 699 - 707

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)*

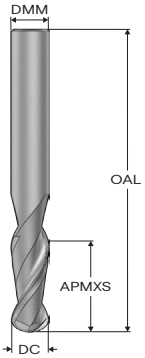
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

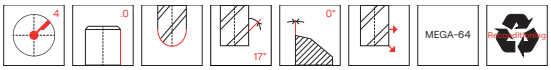
Alta velocità – Acciaio temprato – A testa sferica – 4 Eliche – Cilindrico





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	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	3,0	4	Cylindrical	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4,0	4	Cylindrical	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	5,0	4	Cylindrical	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	6,0	4	Cylindrical	■

■ **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)*

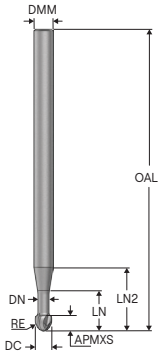
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	1,8	1,5	4	Cylindrical	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	2,4	2,0	4	Cylindrical	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	3,0	2,5	4	Cylindrical	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	3,6	3,0	4	Cylindrical	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	4,8	4,0	4	Cylindrical	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	6,0	5,0	4	Cylindrical	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	7,2	6,0	4	Cylindrical	■

■ **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 699 - 707

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









		JS754	JS755	JS720	JS730	JHP751	JHP760	JHP770
Nome		JS754	JS755	JS720	JS730	JHP751	JHP760	JHP770
Pag.		326	343	354	374	378	381	385
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
CSP		■					■	■
	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

										
Nome		JHP780	JHP794	JCG790	JH724	JH726	JH734	JH736	JH744	JH746
Pag.		392	381	399	431	431	405	407	409	411
Famiglia		HPM	HPM	Ceramic	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO
Tipo di fresa										
Attacco	Cilindrico	■		■	■	■	■	■	■	■
	Weldon	■	■							
	Safelock	□								
Numero di eliche		4	4	5-6	6	6	4	6	4	6
CSP		■	■						■	■
	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.		413	415	417	419	421	423	425
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
CSP								
	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

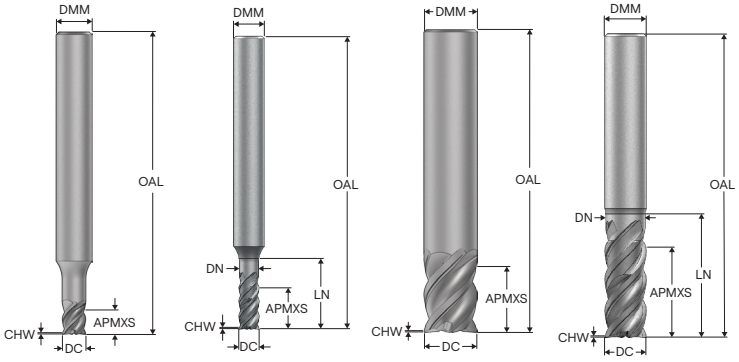
							
Nome		JHB720	JH721	JH722	SHF712	SME714/716	SMB713/714/416
Pag.		427	429	431	504	504	261
Famiglia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HFM	MINI	MINI
Tipo di fresa							
Attacco	Cilindrico	■	■	■	■	■	■
	Weldon						
	Safelock						
Numero di eliche		3	6	6	3-4-5	3-4-5	4
CSP							
	Metrico	2-16	6-8	10	1-10	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

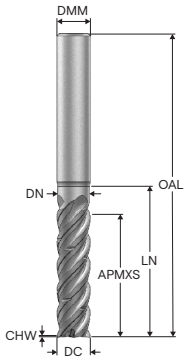
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1C.0Z4-HXT	10165556	1	F	3,0	6,0	4,0	50,0	–	–	0,035	–	4	Cylindrical	■
JS754040F1C.0Z4-HXT	10164855	1	F	4,0	6,0	6,0	50,0	–	–	0,045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

■ **Prodotto standard.**

JS754

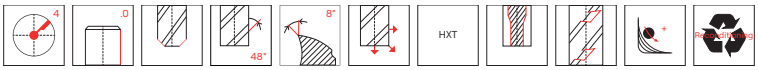
Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Cilindrico – Smusso





E

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



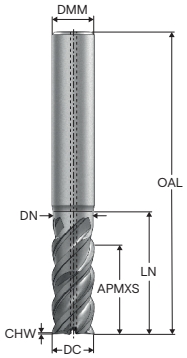
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JS754100E2C.0Z4C-HXT	03186817	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Cylindrical	■
JS754120E2C.0Z4C-HXT	03186818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

■ **Prodotto standard.**

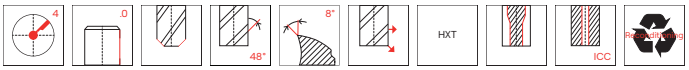
JS754

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





E



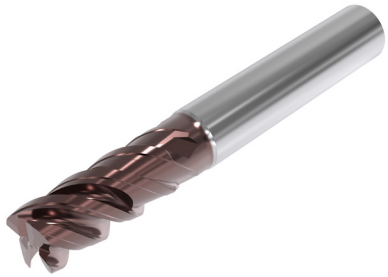
—Tolleranze:
—DMM= h5
—DC= e7
—Riaffilatura possibile

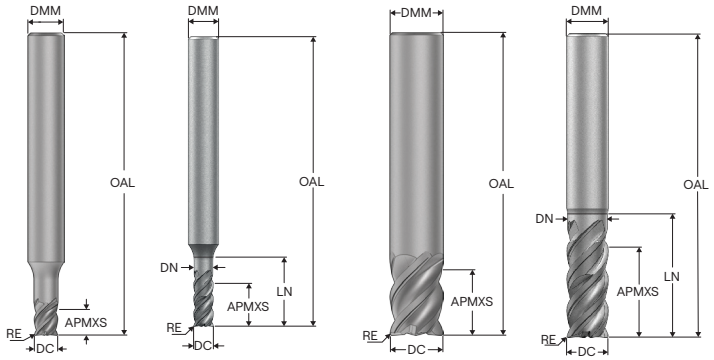
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.0Z4A-HXT	03186834	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Cylindrical	■
JS754080E2C.0Z4A-HXT	03186835	2	E	■	8,0	8,0	16,0	63,0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

■ **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

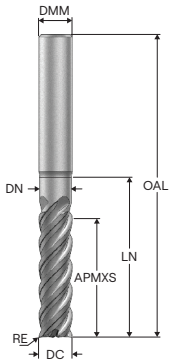
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1R020.0Z4-HXT	10165558	1	F	3,0	6,0	4,0	50,0	–	–	0,2	–	4	Cylindrical	■
JS754040F1R020.0Z4-HXT	10164867	1	F	4,0	6,0	6,0	50,0	–	–	0,2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

■ **Prodotto standard.**

JS754

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





E



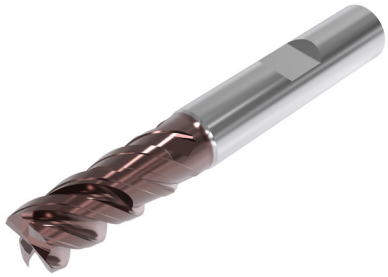
—Tolleranze:
—DMM= h5
—DC= e7
—RE= ±0,02 mm
—Riaffilatura possibile

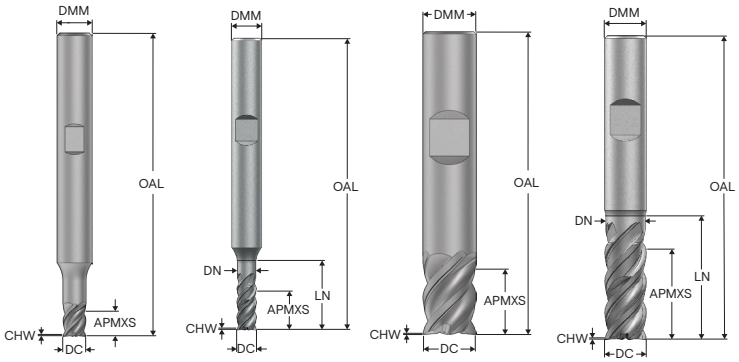
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS754160E2R300.0Z4-HXT	03186859	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	Cylindrical	■
JS754160E2R400.0Z4-HXT	03186860	2	E	16,0	16,0	32,0	92,0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

■ **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

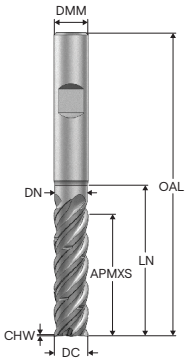
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1C.3Z4-HXT	10165658	1	F	3,0	6,0	4,0	50,0	–	–	0,035	–	4	Weldon	□
JS754040F1C.3Z4-HXT	10164861	1	F	4,0	6,0	6,0	50,0	–	–	0,045	–	4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

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

JS754

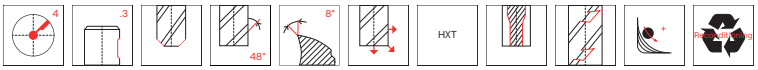
Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Weldon – Smusso





E

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

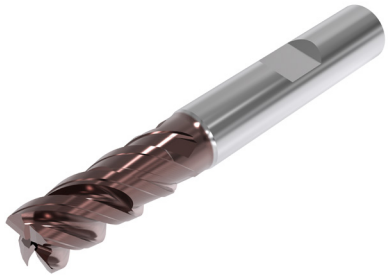


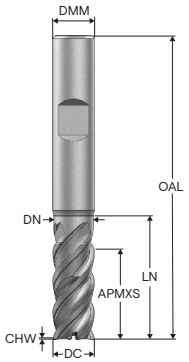
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JS754100E2C.3Z4C-HXT	03186985	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Weldon	■
JS754120E2C.3Z4C-HXT	03186986	2	E	■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

■ **Prodotto standard.**

JS754

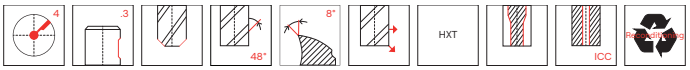
Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Weldon – Smusso





E

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

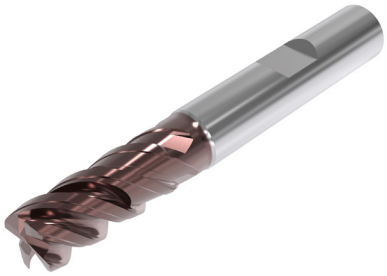


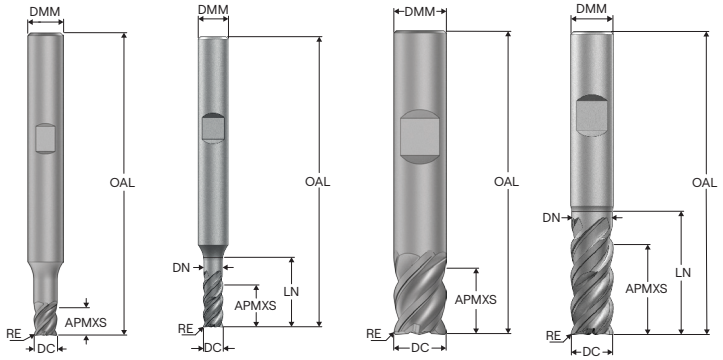
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.3Z4A-HXT	03187001	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Weldon	■
JS754080E2C.3Z4A-HXT	03187002	2	E	■	8,0	8,0	16,0	63,0	25,0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

■ **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

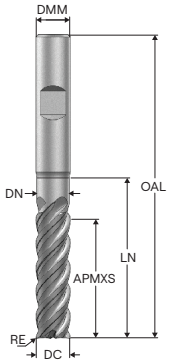
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1R020.3Z4-HXT	10165560	1	F	3,0	6,0	4,0	50,0	–	–	0,2	–	4	Weldon	□
JS754040F1R020.3Z4-HXT	10164879	1	F	4,0	6,0	6,0	50,0	–	–	0,2	–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

■ **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

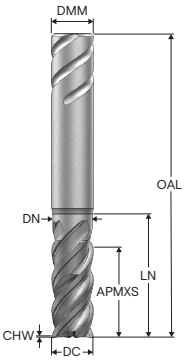
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS754200E2R050.3Z4-HXT	03187029	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	Weldon	■
JS754200E2R100.3Z4-HXT	03187030	2	E	20,0	20,0	40,0	104,0	51,0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

■ **Prodotto standard.** □ 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

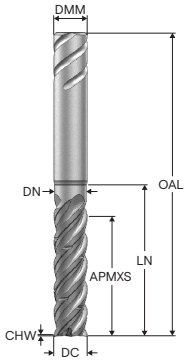
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.9Z4-HXT	03187144	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Safe-lock	☐
JS754080E2C.9Z4-HXT	03187145	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1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

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

JS754

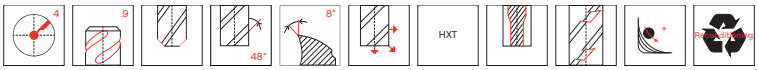
Alte prestazioni – Spallamento – ISO– M e ISO– S – 4 Eliche – Safelock – Smusso





E

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



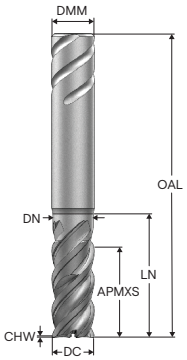
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JS754100E2C.9Z4C-HXT	03187151	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Safe-lock	□
JS754120E2C.9Z4C-HXT	03187152	2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

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

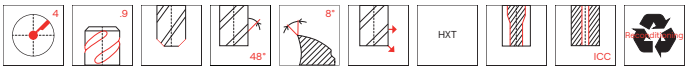
JS754

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





E



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

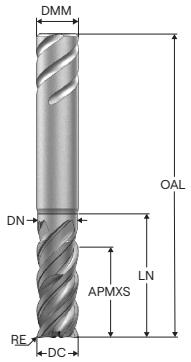
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.9Z4A-HXT	03187164	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Safe-lock	☐
JS754080E2C.9Z4A-HXT	03187165	2	E	■	8,0	8,0	16,0	63,0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

☐ 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

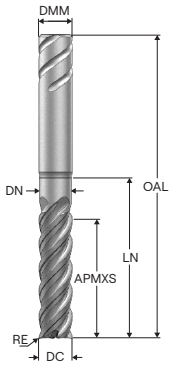
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS754060E2R020.9Z4-HXT	03187170	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	Safe-lock	☐
JS754060E2R050.9Z4-HXT	03187171	2	E	6,0	6,0	12,0	57,0	18,0	5,7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

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

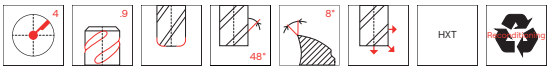
JS754

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	Attacco	Prodotto standard
				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	Safe-lock	☐
JS754060E3R050.9Z4-HXT	03187198	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	Safe-lock	☐
JS754060E3R100.9Z4-HXT	03187199	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	Safe-lock	☐
JS754080E3R050.9Z4-HXT	03187200	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	Safe-lock	☐
JS754080E3R100.9Z4-HXT	03187201	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	Safe-lock	☐
JS754100E3R050.9Z4-HXT	03187202	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	Safe-lock	☐
JS754100E3R100.9Z4-HXT	03187203	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	Safe-lock	☐
JS754100E3R200.9Z4-HXT	03187204	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	Safe-lock	☐
JS754100E3R300.9Z4-HXT	03187205	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	Safe-lock	☐
JS754120E3R050.9Z4-HXT	03187206	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	Safe-lock	☐
JS754120E3R100.9Z4-HXT	03187207	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	Safe-lock	☐
JS754120E3R200.9Z4-HXT	03187208	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	Safe-lock	☐
JS754120E3R300.9Z4-HXT	03187209	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	Safe-lock	☐
JS754160E3R050.9Z4-HXT	03187210	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	Safe-lock	☐
JS754160E3R100.9Z4-HXT	03187211	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	Safe-lock	☐
JS754160E3R200.9Z4-HXT	03187212	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	Safe-lock	☐
JS754160E3R300.9Z4-HXT	03187213	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	Safe-lock	☐
JS754160E3R400.9Z4-HXT	03187214	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	Safe-lock	☐
JS754160E3R600.9Z4-HXT	03187215	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	Safe-lock	☐
JS754200E3R050.9Z4-HXT	03187216	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	Safe-lock	☐
JS754200E3R100.9Z4-HXT	03187217	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	Safe-lock	☐
JS754200E3R200.9Z4-HXT	03187218	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	Safe-lock	☐
JS754200E3R300.9Z4-HXT	03187219	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	Safe-lock	☐
JS754200E3R400.9Z4-HXT	03187220	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	Safe-lock	☐
JS754200E3R600.9Z4-HXT	03187221	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	Safe-lock	☐

☐ 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 699 - 707

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%

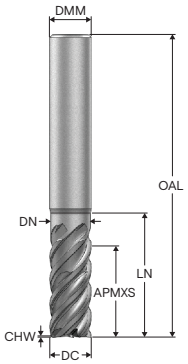
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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



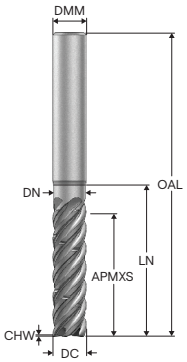
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2C.0Z5-HXT	03186907	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	Cylindrical	■
JS755080E2C.0Z5-HXT	03186908	2	E	8,0	8,0	16,0	63,0	25,0	7,6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

■ **Prodotto standard.**

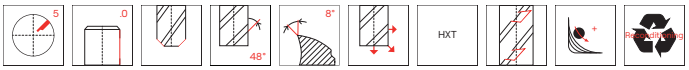
JS755

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





E



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

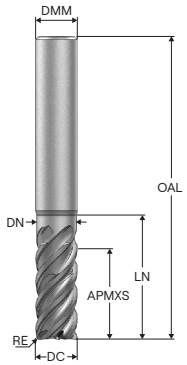
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JS755100E3C.0Z5C-HXT	03186921	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Cylindrical	■
JS755120E3C.0Z5C-HXT	03186922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

■ **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

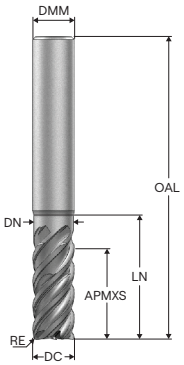
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2R020.0Z5-HXT	03186925	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	Cylindrical	■
JS755060E2R050.0Z5-HXT	03186926	2	E	6,0	6,0	12,0	57,0	18,0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

■ **Prodotto standard.**

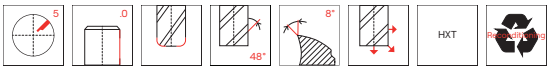
JS755

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

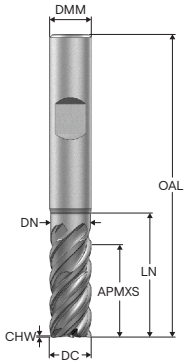
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E3R020.0Z5-HXT	03186946	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	Cylindrical	■
JS755060E3R050.0Z5-HXT	03186947	3	E	6,0	6,0	21,0	65,0	26,0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

■ **Prodotto standard.**

JS755

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





E

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



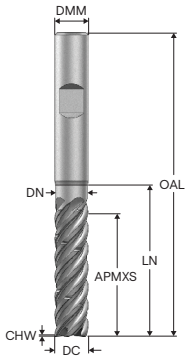
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2C.3Z5-HXT	03187083	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	Weldon	■
JS755080E2C.3Z5-HXT	03187084	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1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

■ **Prodotto standard.**

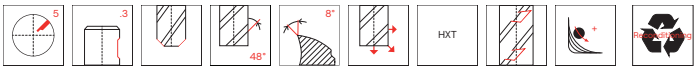
JS755

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





E



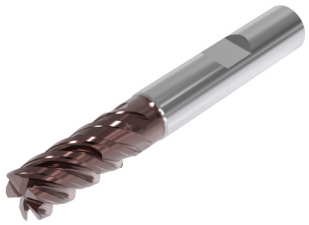
—Tolleranze:
—DMM= h5
—DC= e7
—Riaffilatura possibile

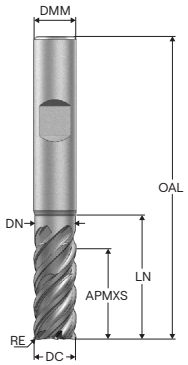
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JS755100E3C.3Z5C-HXT	03187097	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Weldon	■
JS755120E3C.3Z5C-HXT	03187098	3	E	■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

■ **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



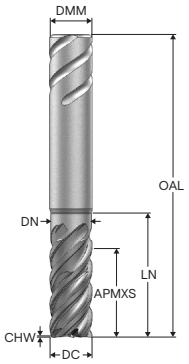
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2R020.3Z5-HXT	03187101	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	Weldon	■
JS755060E2R050.3Z5-HXT	03187102	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5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

■ **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

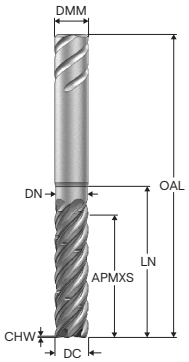
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2C.9Z5-HXT	03187235	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	Safe-lock	☐
JS755080E2C.9Z5-HXT	03187236	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1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

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

JS755

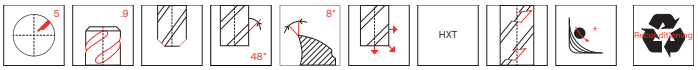
Alte prestazioni – Spallamento – ISO– M e ISO– S – 5 Eliche – Safelock – Smusso





E

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



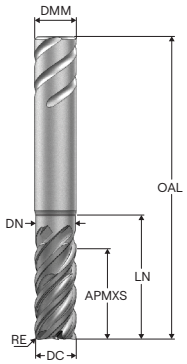
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JS755100E3C.9Z5C-HXT	03187249	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Safe-lock	□
JS755120E3C.9Z5C-HXT	03187250	3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

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

☐ 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%

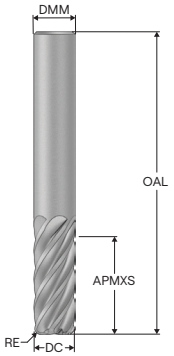
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

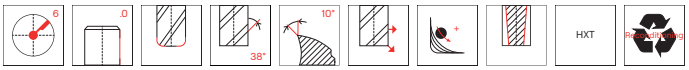
JS720

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





D



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

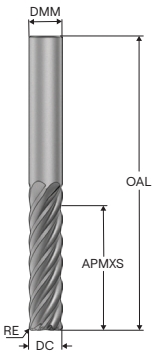
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS720060D2R050.0Z6-HXT	03060293	2	D	6,0	6,0	17,0	57,0	0,5	6	Cylindrical	■
JS720060D2R100.0Z6-HXT	03060294	2	D	6,0	6,0	17,0	57,0	1,0	6	Cylindrical	■
JS720080D2R050.0Z6-HXT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

■ **Prodotto standard.**

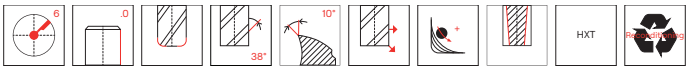
JS720

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





D



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

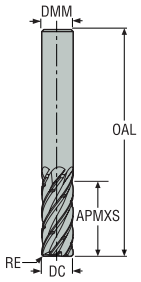
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS720080D3R050.0Z6-HXT	10228433	3	D	8,0	8,0	32,0	80,0	0,5	6	Cylindrical	■
JS720080D3R100.0Z6-HXT	10228434	3	D	8,0	8,0	32,0	80,0	1,0	6	Cylindrical	■
JS720100D3R050.0Z6-HXT	10228435	3	D	10,0	10,0	40,0	89,0	0,5	6	Cylindrical	■
JS720100D3R100.0Z6-HXT	10228436	3	D	10,0	10,0	40,0	89,0	1,0	6	Cylindrical	■
JS720100D3R200.0Z6-HXT	10228437	3	D	10,0	10,0	40,0	89,0	2,0	6	Cylindrical	■
JS720120D3R050.0Z6-HXT	10228438	3	D	12,0	12,0	45,0	100,0	0,5	6	Cylindrical	■
JS720120D3R100.0Z6-HXT	10228439	3	D	12,0	12,0	45,0	100,0	1,0	6	Cylindrical	■
JS720120D3R200.0Z6-HXT	10228440	3	D	12,0	12,0	45,0	100,0	2,0	6	Cylindrical	■
JS720160D3R050.0Z6-HXT	10228441	3	D	16,0	16,0	65,0	130,0	0,5	6	Cylindrical	■
JS720160D3R100.0Z6-HXT	10228442	3	D	16,0	16,0	65,0	130,0	1,0	6	Cylindrical	■
JS720160D3R200.0Z6-HXT	10228443	3	D	16,0	16,0	65,0	130,0	2,0	6	Cylindrical	■
JS720160D3R300.0Z6-HXT	03169497	3	D	16,0	16,0	65,0	130,0	3,0	6	Cylindrical	■
JS720200D3R050.0Z6-HXT	03060314	3	D	20,0	20,0	62,0	121,0	0,5	6	Cylindrical	■
JS720200D3R100.0Z6-HXT	03060316	3	D	20,0	20,0	62,0	121,0	1,0	6	Cylindrical	■
JS720200D3R200.0Z6-HXT	03060317	3	D	20,0	20,0	62,0	121,0	2,0	6	Cylindrical	■
JS720200D3R300.0Z6-HXT	03060318	3	D	20,0	20,0	62,0	121,0	3,0	6	Cylindrical	■
JS720200D3R400.0Z6-HXT	03060319	3	D	20,0	20,0	62,0	121,0	4,0	6	Cylindrical	■
JS720200D3R500.0Z6-HXT	03060320	3	D	20,0	20,0	62,0	121,0	5,0	6	Cylindrical	■
JS720200D3R600.0Z6-HXT	03060321	3	D	20,0	20,0	62,0	121,0	6,0	6	Cylindrical	■
JS720250D3R050.0Z6-HXT	03060322	3	D	25,0	25,0	78,0	146,0	0,5	6	Cylindrical	■
JS720250D3R100.0Z6-HXT	03060323	3	D	25,0	25,0	78,0	146,0	1,0	6	Cylindrical	■
JS720250D3R200.0Z6-HXT	03060324	3	D	25,0	25,0	78,0	146,0	2,0	6	Cylindrical	■
JS720250D3R300.0Z6-HXT	03060325	3	D	25,0	25,0	78,0	146,0	3,0	6	Cylindrical	■
JS720250D3R400.0Z6-HXT	03060326	3	D	25,0	25,0	78,0	146,0	4,0	6	Cylindrical	■
JS720250D3R600.0Z6-HXT	03060327	3	D	25,0	25,0	78,0	146,0	6,0	6	Cylindrical	■

■ **Prodotto standard.**

JS720

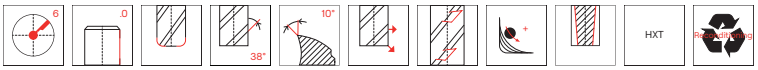
Alte prestazioni – Titanio – Spallamento – 6 Eliche – Cilindrico – Raggio di punta





D

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



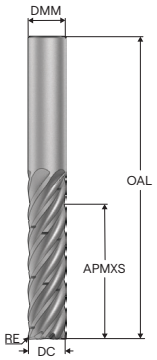
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS720080D2R050.0Z6C-HXT	10228513	2	D	■	8,0	8,0	23,0	63,0	0,5	6	Cylindrical	■
JS720080D2R100.0Z6C-HXT	10228514	2	D	■	8,0	8,0	23,0	63,0	1,0	6	Cylindrical	■
JS720100D2R050.0Z6C-HXT	03060297	2	D	■	10,0	10,0	26,0	72,0	0,5	6	Cylindrical	■
JS720100D2R100.0Z6C-HXT	10228515	2	D	■	10,0	10,0	26,0	72,0	1,0	6	Cylindrical	■
JS720120D2R050.0Z6C-HXT	03060302	2	D	■	12,0	12,0	30,0	83,0	0,5	6	Cylindrical	■
JS720120D2R100.0Z6C-HXT	03298280	2	D	■	12,0	12,0	30,0	83,0	1,0	6	Cylindrical	■
JS720120D2R200.0Z6C-HXT	03298281	2	D	■	12,0	12,0	30,0	83,0	2,0	6	Cylindrical	■
JS720120D2R250.0Z6C-HXT	03298282	2	D	■	12,0	12,0	30,0	83,0	2,5	6	Cylindrical	■
JS720120D2R300.0Z6C-HXT	03298283	2	D	■	12,0	12,0	30,0	83,0	3,0	6	Cylindrical	■
JS720120D2R310.0Z6C-HXT	03298284	2	D	■	12,0	12,0	30,0	83,0	3,1	6	Cylindrical	■
JS720160D2R050.0Z6C-HXT	03060308	2	D	■	16,0	16,0	44,0	99,0	0,5	6	Cylindrical	■
JS720160D2R100.0Z6C-HXT	03298285	2	D	■	16,0	16,0	44,0	99,0	1,0	6	Cylindrical	■
JS720160D2R200.0Z6C-HXT	03298286	2	D	■	16,0	16,0	44,0	99,0	2,0	6	Cylindrical	■
JS720160D2R250.0Z6C-HXT	03298287	2	D	■	16,0	16,0	44,0	99,0	2,5	6	Cylindrical	■
JS720160D2R300.0Z6C-HXT	03298288	2	D	■	16,0	16,0	44,0	99,0	3,0	6	Cylindrical	■
JS720160D2R400.0Z6C-HXT	03298290	2	D	■	16,0	16,0	44,0	99,0	4,0	6	Cylindrical	■
JS720160D2R600.0Z6C-HXT	03298291	2	D	■	16,0	16,0	44,0	99,0	6,0	6	Cylindrical	■

■ **Prodotto standard.**

JS720

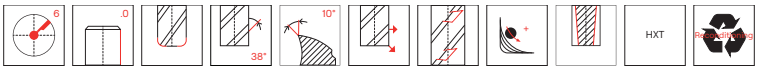
Alte prestazioni – Titanio – Spallamento – 6 Eliche – Cilindrico – Raggio di punta





D

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



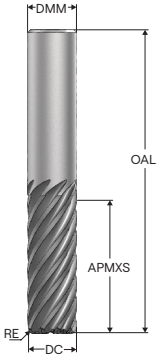
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS720160D3R050.0Z6C-HXT	10228516	3	D	■	16,0	16,0	65,0	130,0	0,5	6	Cylindrical	■
JS720160D3R100.0Z6C-HXT	10228517	3	D	■	16,0	16,0	65,0	130,0	1,0	6	Cylindrical	■
JS720160D3R200.0Z6C-HXT	10228518	3	D	■	16,0	16,0	65,0	130,0	2,0	6	Cylindrical	■
JS720160D3R300.0Z6C-HXT	10228519	3	D	■	16,0	16,0	65,0	130,0	3,0	6	Cylindrical	■
JS720200D3R050.0Z6C-HXT	03060315	3	D	■	20,0	20,0	62,0	121,0	0,5	6	Cylindrical	■
JS720200D3R100.0Z6C-HXT	03298292	3	D	■	20,0	20,0	62,0	121,0	1,0	6	Cylindrical	■
JS720200D3R300.0Z6C-HXT	03298295	3	D	■	20,0	20,0	62,0	121,0	3,0	6	Cylindrical	■
JS720200D3R400.0Z6C-HXT	03298297	3	D	■	20,0	20,0	62,0	121,0	4,0	6	Cylindrical	■
JS720200D3R500.0Z6C-HXT	03298298	3	D	■	20,0	20,0	62,0	121,0	5,0	6	Cylindrical	■
JS720200D3R600.0Z6C-HXT	03298299	3	D	■	20,0	20,0	62,0	121,0	6,0	6	Cylindrical	■
JS720250D3R050.0Z6C-HXT	03066270	3	D	■	25,0	25,0	78,0	146,0	0,5	6	Cylindrical	■
JS720250D3R400.0Z6C-HXT	03298303	3	D	■	25,0	25,0	78,0	146,0	4,0	6	Cylindrical	■
JS720250D3R600.0Z6C-HXT	03298304	3	D	■	25,0	25,0	78,0	146,0	6,0	6	Cylindrical	■

■ **Prodotto standard.**

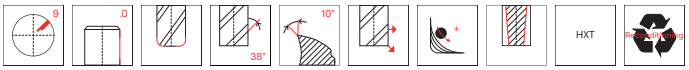
JS720

Alte prestazioni – Titanio – Spallamento – 9 Eliche – Cilindrico – Raggio di punta





D



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

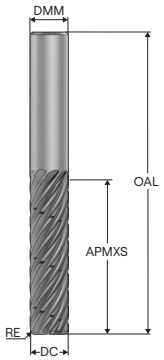
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS720100D2R050.0Z9-HXT	10067510	2	D	10,0	10,0	26,0	72,0	0,5	9	Cylindrical	■
JS720100D2R100.0Z9-HXT	10067511	2	D	10,0	10,0	26,0	72,0	1,0	9	Cylindrical	■
JS720100D2R200.0Z9-HXT	10067512	2	D	10,0	10,0	26,0	72,0	2,0	9	Cylindrical	■
JS720120D2R050.0Z9-HXT	10067513	2	D	12,0	12,0	30,0	83,0	0,5	9	Cylindrical	■
JS720120D2R100.0Z9-HXT	10067514	2	D	12,0	12,0	30,0	83,0	1,0	9	Cylindrical	■
JS720120D2R200.0Z9-HXT	10067515	2	D	12,0	12,0	30,0	83,0	2,0	9	Cylindrical	■
JS720160D2R100.0Z9-HXT	10008152	2	D	16,0	16,0	44,0	99,0	1,0	9	Cylindrical	■
JS720160D2R200.0Z9-HXT	10008153	2	D	16,0	16,0	44,0	99,0	2,0	9	Cylindrical	■
JS720160D2R300.0Z9-HXT	10008154	2	D	16,0	16,0	44,0	99,0	3,0	9	Cylindrical	■
JS720200D2R100.0Z9-HXT	10228393	2	D	20,0	20,0	45,0	105,0	1,0	9	Cylindrical	■
JS720200D2R200.0Z9-HXT	10228394	2	D	20,0	20,0	45,0	105,0	2,0	9	Cylindrical	■
JS720200D2R300.0Z9-HXT	10228395	2	D	20,0	20,0	45,0	105,0	3,0	9	Cylindrical	■
JS720250D2R100.0Z9-HXT	10008155	2	D	25,0	25,0	50,0	125,0	1,0	9	Cylindrical	■
JS720250D2R200.0Z9-HXT	10008156	2	D	25,0	25,0	50,0	125,0	2,0	9	Cylindrical	■
JS720250D2R300.0Z9-HXT	10008157	2	D	25,0	25,0	50,0	125,0	3,0	9	Cylindrical	■
JS720100D3R050.0Z9-HXT	10067516	3	D	10,0	10,0	40,0	89,0	0,5	9	Cylindrical	■
JS720100D3R100.0Z9-HXT	10067517	3	D	10,0	10,0	40,0	89,0	1,0	9	Cylindrical	■
JS720100D3R200.0Z9-HXT	10067518	3	D	10,0	10,0	40,0	89,0	2,0	9	Cylindrical	■
JS720120D3R050.0Z9-HXT	10067519	3	D	12,0	12,0	45,0	100,0	0,5	9	Cylindrical	■
JS720120D3R100.0Z9-HXT	10067520	3	D	12,0	12,0	45,0	100,0	1,0	9	Cylindrical	■
JS720120D3R200.0Z9-HXT	10067521	3	D	12,0	12,0	45,0	100,0	2,0	9	Cylindrical	■
JS720160D3R100.0Z9-HXT	10008158	3	D	16,0	16,0	65,0	130,0	1,0	9	Cylindrical	■
JS720160D3R200.0Z9-HXT	10008159	3	D	16,0	16,0	65,0	130,0	2,0	9	Cylindrical	■
JS720160D3R300.0Z9-HXT	10008160	3	D	16,0	16,0	65,0	130,0	3,0	9	Cylindrical	■
JS720200D3R100.0Z9-HXT	10008161	3	D	20,0	20,0	62,0	121,0	1,0	9	Cylindrical	■
JS720200D3R200.0Z9-HXT	10008162	3	D	20,0	20,0	62,0	121,0	2,0	9	Cylindrical	■
JS720200D3R300.0Z9-HXT	10008163	3	D	20,0	20,0	62,0	121,0	3,0	9	Cylindrical	■
JS720250D3R100.0Z9-HXT	10008164	3	D	25,0	25,0	78,0	146,0	1,0	9	Cylindrical	■
JS720250D3R300.0Z9-HXT	10008166	3	D	25,0	25,0	78,0	146,0	3,0	9	Cylindrical	■

■ **Prodotto standard.**

JS720

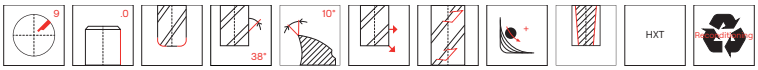
Alte prestazioni – Titanio – Spallamento – 9 Eliche – Cilindrico – Raggio di punta





D

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



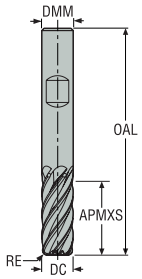
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS720100D3R050.0Z9C-HXT	10067522	3	D	■	10,0	10,0	40,0	89,0	0,5	9	Cylindrical	■
JS720100D3R100.0Z9C-HXT	10067523	3	D	■	10,0	10,0	40,0	89,0	1,0	9	Cylindrical	■
JS720100D3R200.0Z9C-HXT	10067524	3	D	■	10,0	10,0	40,0	89,0	2,0	9	Cylindrical	■
JS720120D3R050.0Z9C-HXT	10067525	3	D	■	12,0	12,0	45,0	100,0	0,5	9	Cylindrical	■
JS720120D3R100.0Z9C-HXT	10067526	3	D	■	12,0	12,0	45,0	100,0	1,0	9	Cylindrical	■
JS720120D3R200.0Z9C-HXT	10067527	3	D	■	12,0	12,0	45,0	100,0	2,0	9	Cylindrical	■
JS720160D3R100.0Z9C-HXT	10067528	3	D	■	16,0	16,0	65,0	130,0	1,0	9	Cylindrical	■
JS720160D3R200.0Z9C-HXT	10067529	3	D	■	16,0	16,0	65,0	130,0	2,0	9	Cylindrical	■
JS720160D3R300.0Z9C-HXT	10067530	3	D	■	16,0	16,0	65,0	130,0	3,0	9	Cylindrical	■
JS720200D3R100.0Z9C-HXT	10067531	3	D	■	20,0	20,0	62,0	121,0	1,0	9	Cylindrical	■
JS720200D3R200.0Z9C-HXT	10067532	3	D	■	20,0	20,0	62,0	121,0	2,0	9	Cylindrical	■
JS720200D3R300.0Z9C-HXT	10067533	3	D	■	20,0	20,0	62,0	121,0	3,0	9	Cylindrical	■

■ **Prodotto standard.**

JS720

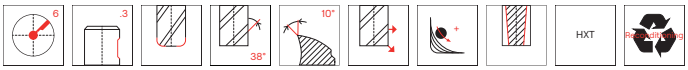
Alte prestazioni – Titanio – Spallamento – 6 Eliche – Weldon – Raggio di punta





D

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



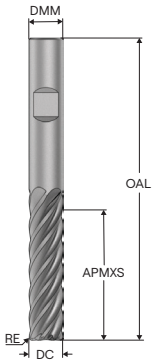
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS720060D2R050.3Z6-HXT	03060339	2	D	6,0	6,0	17,0	57,0	0,5	6	Weldon	☐
JS720060D2R100.3Z6-HXT	03060340	2	D	6,0	6,0	17,0	57,0	1,0	6	Weldon	☐
JS720080D2R050.3Z6-HXT	03060341	2	D	8,0	8,0	23,0	63,0	0,5	6	Weldon	☐
JS720080D2R100.3Z6-HXT	03061295	2	D	8,0	8,0	23,0	63,0	1,0	6	Weldon	☐
JS720100D2R050.3Z6-HXT	03060342	2	D	10,0	10,0	26,0	72,0	0,5	6	Weldon	☐
JS720100D2R100.3Z6-HXT	03060344	2	D	10,0	10,0	26,0	72,0	1,0	6	Weldon	☐
JS720100D2R200.3Z6-HXT	03060345	2	D	10,0	10,0	26,0	72,0	2,0	6	Weldon	☐
JS720100D2R300.3Z6-HXT	03060346	2	D	10,0	10,0	26,0	72,0	3,0	6	Weldon	☐
JS720120D2R050.3Z6-HXT	03060347	2	D	12,0	12,0	30,0	83,0	0,5	6	Weldon	☐
JS720120D2R100.3Z6-HXT	03060349	2	D	12,0	12,0	30,0	83,0	1,0	6	Weldon	☐
JS720120D2R200.3Z6-HXT	03060350	2	D	12,0	12,0	30,0	83,0	2,0	6	Weldon	☐
JS720120D2R300.3Z6-HXT	03060351	2	D	12,0	12,0	30,0	83,0	3,0	6	Weldon	☐
JS720160D2R050.3Z6-HXT	03060352	2	D	16,0	16,0	44,0	99,0	0,5	6	Weldon	☐
JS720160D2R100.3Z6-HXT	03060354	2	D	16,0	16,0	44,0	99,0	1,0	6	Weldon	☐
JS720160D2R200.3Z6-HXT	03060355	2	D	16,0	16,0	44,0	99,0	2,0	6	Weldon	■
JS720160D2R300.3Z6-HXT	03060356	2	D	16,0	16,0	44,0	99,0	3,0	6	Weldon	■
JS720160D2R400.3Z6-HXT	03060357	2	D	16,0	16,0	44,0	99,0	4,0	6	Weldon	☐
JS720160D2R600.3Z6-HXT	03060358	2	D	16,0	16,0	44,0	99,0	6,0	6	Weldon	☐
JS720200D2R050.3Z6-HXT	10228444	2	D	20,0	20,0	45,0	105,0	0,5	6	Weldon	☐
JS720200D2R100.3Z6-HXT	10228445	2	D	20,0	20,0	45,0	105,0	1,0	6	Weldon	☐
JS720200D2R200.3Z6-HXT	10228446	2	D	20,0	20,0	45,0	105,0	2,0	6	Weldon	☐
JS720200D2R300.3Z6-HXT	10228447	2	D	20,0	20,0	45,0	105,0	3,0	6	Weldon	☐
JS720250D2R050.3Z6-HXT	10228448	2	D	25,0	25,0	50,0	125,0	0,5	6	Weldon	☐
JS720250D2R100.3Z6-HXT	10228449	2	D	25,0	25,0	50,0	125,0	1,0	6	Weldon	☐
JS720250D2R200.3Z6-HXT	10228450	2	D	25,0	25,0	50,0	125,0	2,0	6	Weldon	☐
JS720250D2R300.3Z6-HXT	10228451	2	D	25,0	25,0	50,0	125,0	3,0	6	Weldon	☐

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

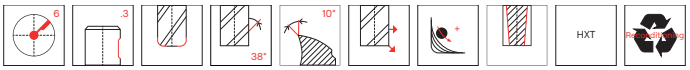
JS720

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





D



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

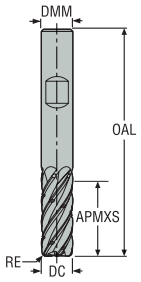
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS720080D3R050.3Z6-HXT	10228452	3	D	8,0	8,0	32,0	80,0	0,5	6	Weldon	□
JS720080D3R100.3Z6-HXT	10228453	3	D	8,0	8,0	32,0	80,0	1,0	6	Weldon	□
JS720100D3R050.3Z6-HXT	10228454	3	D	10,0	10,0	40,0	89,0	0,5	6	Weldon	□
JS720100D3R100.3Z6-HXT	10228455	3	D	10,0	10,0	40,0	89,0	1,0	6	Weldon	□
JS720100D3R200.3Z6-HXT	10228456	3	D	10,0	10,0	40,0	89,0	2,0	6	Weldon	□
JS720120D3R050.3Z6-HXT	10228457	3	D	12,0	12,0	45,0	100,0	0,5	6	Weldon	□
JS720120D3R100.3Z6-HXT	10228458	3	D	12,0	12,0	45,0	100,0	1,0	6	Weldon	□
JS720120D3R200.3Z6-HXT	10228459	3	D	12,0	12,0	45,0	100,0	2,0	6	Weldon	□
JS720160D3R050.3Z6-HXT	10228460	3	D	16,0	16,0	65,0	130,0	0,5	6	Weldon	□
JS720160D3R100.3Z6-HXT	10228461	3	D	16,0	16,0	65,0	130,0	1,0	6	Weldon	□
JS720160D3R200.3Z6-HXT	10228462	3	D	16,0	16,0	65,0	130,0	2,0	6	Weldon	□
JS720160D3R300.3Z6-HXT	10228463	3	D	16,0	16,0	65,0	130,0	3,0	6	Weldon	□
JS720200D3R050.3Z6-HXT	03060359	3	D	20,0	20,0	62,0	121,0	0,5	6	Weldon	□
JS720200D3R100.3Z6-HXT	03060361	3	D	20,0	20,0	62,0	121,0	1,0	6	Weldon	□
JS720200D3R200.3Z6-HXT	03060362	3	D	20,0	20,0	62,0	121,0	2,0	6	Weldon	□
JS720200D3R300.3Z6-HXT	03060363	3	D	20,0	20,0	62,0	121,0	3,0	6	Weldon	■
JS720200D3R400.3Z6-HXT	03060364	3	D	20,0	20,0	62,0	121,0	4,0	6	Weldon	■
JS720200D3R500.3Z6-HXT	03060365	3	D	20,0	20,0	62,0	121,0	5,0	6	Weldon	□
JS720200D3R600.3Z6-HXT	03060366	3	D	20,0	20,0	62,0	121,0	6,0	6	Weldon	□
JS720250D3R050.3Z6-HXT	03060367	3	D	25,0	25,0	78,0	146,0	0,5	6	Weldon	□
JS720250D3R100.3Z6-HXT	03060368	3	D	25,0	25,0	78,0	146,0	1,0	6	Weldon	□
JS720250D3R200.3Z6-HXT	03060369	3	D	25,0	25,0	78,0	146,0	2,0	6	Weldon	□
JS720250D3R300.3Z6-HXT	03060370	3	D	25,0	25,0	78,0	146,0	3,0	6	Weldon	□
JS720250D3R400.3Z6-HXT	03060371	3	D	25,0	25,0	78,0	146,0	4,0	6	Weldon	■
JS720250D3R600.3Z6-HXT	03060372	3	D	25,0	25,0	78,0	146,0	6,0	6	Weldon	□

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

JS720

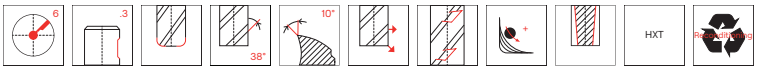
Alte prestazioni – Titanio – Spallamento – 6 Eliche – Weldon – Raggio di punta





D

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



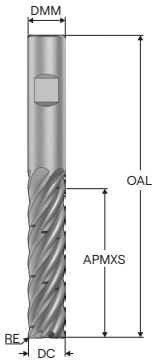
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS720080D2R050.3Z6C-HXT	10228520	2	D	■	8,0	8,0	23,0	63,0	0,5	6	Weldon	□
JS720080D2R100.3Z6C-HXT	10228521	2	D	■	8,0	8,0	23,0	63,0	1,0	6	Weldon	□
JS720100D2R050.3Z6C-HXT	03060343	2	D	■	10,0	10,0	26,0	72,0	0,5	6	Weldon	□
JS720100D2R100.3Z6C-HXT	10228522	2	D	■	10,0	10,0	26,0	72,0	1,0	6	Weldon	□
JS720120D2R050.3Z6C-HXT	03060348	2	D	■	12,0	12,0	30,0	83,0	0,5	6	Weldon	□
JS720120D2R100.3Z6C-HXT	03298308	2	D	■	12,0	12,0	30,0	83,0	1,0	6	Weldon	□
JS720120D2R200.3Z6C-HXT	03298309	2	D	■	12,0	12,0	30,0	83,0	2,0	6	Weldon	□
JS720120D2R250.3Z6C-HXT	03298310	2	D	■	12,0	12,0	30,0	83,0	2,5	6	Weldon	□
JS720120D2R300.3Z6C-HXT	03298311	2	D	■	12,0	12,0	30,0	83,0	3,0	6	Weldon	□
JS720120D2R310.3Z6C-HXT	03298312	2	D	■	12,0	12,0	30,0	83,0	3,1	6	Weldon	□
JS720160D2R050.3Z6C-HXT	03060353	2	D	■	16,0	16,0	44,0	99,0	0,5	6	Weldon	■
JS720160D2R100.3Z6C-HXT	03298313	2	D	■	16,0	16,0	44,0	99,0	1,0	6	Weldon	■
JS720160D2R200.3Z6C-HXT	03298314	2	D	■	16,0	16,0	44,0	99,0	2,0	6	Weldon	■
JS720160D2R250.3Z6C-HXT	03298315	2	D	■	16,0	16,0	44,0	99,0	2,5	6	Weldon	■
JS720160D2R300.3Z6C-HXT	03298316	2	D	■	16,0	16,0	44,0	99,0	3,0	6	Weldon	■
JS720160D2R400.3Z6C-HXT	03298318	2	D	■	16,0	16,0	44,0	99,0	4,0	6	Weldon	■
JS720160D2R600.3Z6C-HXT	03298319	2	D	■	16,0	16,0	44,0	99,0	6,0	6	Weldon	■

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

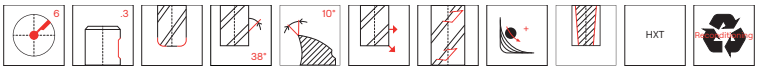
JS720

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





D



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

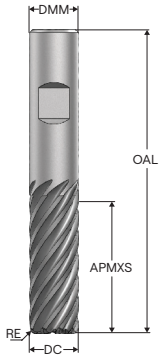
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS720160D3R050.3Z6C-HXT	10228523	3	D	■	16,0	16,0	65,0	130,0	0,5	6	Weldon	□
JS720160D3R100.3Z6C-HXT	10228524	3	D	■	16,0	16,0	65,0	130,0	1,0	6	Weldon	□
JS720160D3R200.3Z6C-HXT	10228525	3	D	■	16,0	16,0	65,0	130,0	2,0	6	Weldon	□
JS720160D3R300.3Z6C-HXT	10228526	3	D	■	16,0	16,0	65,0	130,0	3,0	6	Weldon	□
JS720200D3R050.3Z6C-HXT	03060360	3	D	■	20,0	20,0	62,0	121,0	0,5	6	Weldon	■
JS720200D3R100.3Z6C-HXT	03298320	3	D	■	20,0	20,0	62,0	121,0	1,0	6	Weldon	■
JS720200D3R200.3Z6C-HXT	03298321	3	D	■	20,0	20,0	62,0	121,0	2,0	6	Weldon	■
JS720200D3R250.3Z6C-HXT	03298322	3	D	■	20,0	20,0	62,0	121,0	2,5	6	Weldon	■
JS720200D3R300.3Z6C-HXT	03298323	3	D	■	20,0	20,0	62,0	121,0	3,0	6	Weldon	■
JS720200D3R400.3Z6C-HXT	03298325	3	D	■	20,0	20,0	62,0	121,0	4,0	6	Weldon	■
JS720200D3R500.3Z6C-HXT	03298326	3	D	■	20,0	20,0	62,0	121,0	5,0	6	Weldon	■
JS720200D3R600.3Z6C-HXT	03298327	3	D	■	20,0	20,0	62,0	121,0	6,0	6	Weldon	■
JS720250D3R050.3Z6C-HXT	03066460	3	D	■	25,0	25,0	78,0	146,0	0,5	6	Weldon	■
JS720250D3R100.3Z6C-HXT	03298328	3	D	■	25,0	25,0	78,0	146,0	1,0	6	Weldon	■
JS720250D3R300.3Z6C-HXT	03298330	3	D	■	25,0	25,0	78,0	146,0	3,0	6	Weldon	■
JS720250D3R400.3Z6C-HXT	03298331	3	D	■	25,0	25,0	78,0	146,0	4,0	6	Weldon	■
JS720250D3R600.3Z6C-HXT	03298332	3	D	■	25,0	25,0	78,0	146,0	6,0	6	Weldon	■

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

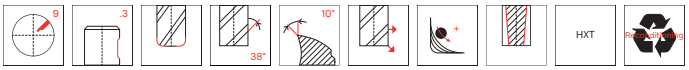
JS720

Alte prestazioni – Titanio – Spallamento – 9 Eliche – Weldon – Raggio di punta





D



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

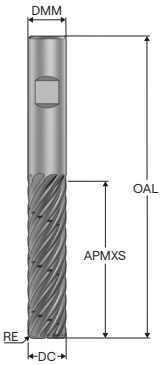
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS720100D2R050.3Z9-HXT	10067881	2	D	10,0	10,0	26,0	72,0	0,5	9	Weldon	☐
JS720100D2R100.3Z9-HXT	10067882	2	D	10,0	10,0	26,0	72,0	1,0	9	Weldon	☐
JS720100D2R200.3Z9-HXT	10067883	2	D	10,0	10,0	26,0	72,0	2,0	9	Weldon	☐
JS720120D2R050.3Z9-HXT	10067884	2	D	12,0	12,0	30,0	83,0	0,5	9	Weldon	☐
JS720120D2R100.3Z9-HXT	10067885	2	D	12,0	12,0	30,0	83,0	1,0	9	Weldon	☐
JS720120D2R200.3Z9-HXT	10067886	2	D	12,0	12,0	30,0	83,0	2,0	9	Weldon	☐
JS720160D2R100.3Z9-HXT	10008279	2	D	16,0	16,0	44,0	99,0	1,0	9	Weldon	☐
JS720160D2R200.3Z9-HXT	10008280	2	D	16,0	16,0	44,0	99,0	2,0	9	Weldon	☐
JS720160D2R300.3Z9-HXT	10008281	2	D	16,0	16,0	44,0	99,0	3,0	9	Weldon	☐
JS720200D2R100.3Z9-HXT	10228396	2	D	20,0	20,0	45,0	105,0	1,0	9	Weldon	☐
JS720200D2R200.3Z9-HXT	10228397	2	D	20,0	20,0	45,0	105,0	2,0	9	Weldon	☐
JS720200D2R300.3Z9-HXT	10228398	2	D	20,0	20,0	45,0	105,0	3,0	9	Weldon	☐
JS720250D2R100.3Z9-HXT	10008282	2	D	25,0	25,0	50,0	125,0	1,0	9	Weldon	☐
JS720250D2R200.3Z9-HXT	10008283	2	D	25,0	25,0	50,0	125,0	2,0	9	Weldon	☐
JS720250D2R300.3Z9-HXT	10008284	2	D	25,0	25,0	50,0	125,0	3,0	9	Weldon	☐
JS720100D3R050.3Z9-HXT	10067887	3	D	10,0	10,0	40,0	89,0	0,5	9	Weldon	☐
JS720100D3R100.3Z9-HXT	10067888	3	D	10,0	10,0	40,0	89,0	1,0	9	Weldon	☐
JS720100D3R200.3Z9-HXT	10067889	3	D	10,0	10,0	40,0	89,0	2,0	9	Weldon	☐
JS720120D3R050.3Z9-HXT	10067890	3	D	12,0	12,0	45,0	100,0	0,5	9	Weldon	☐
JS720120D3R100.3Z9-HXT	10067891	3	D	12,0	12,0	45,0	100,0	1,0	9	Weldon	☐
JS720120D3R200.3Z9-HXT	10067892	3	D	12,0	12,0	45,0	100,0	2,0	9	Weldon	☐
JS720160D3R100.3Z9-HXT	10008285	3	D	16,0	16,0	65,0	130,0	1,0	9	Weldon	☐
JS720160D3R200.3Z9-HXT	10008286	3	D	16,0	16,0	65,0	130,0	2,0	9	Weldon	☐
JS720160D3R300.3Z9-HXT	10008287	3	D	16,0	16,0	65,0	130,0	3,0	9	Weldon	☐
JS720200D3R100.3Z9-HXT	10008288	3	D	20,0	20,0	62,0	121,0	1,0	9	Weldon	☐
JS720200D3R200.3Z9-HXT	10008289	3	D	20,0	20,0	62,0	121,0	2,0	9	Weldon	☐
JS720200D3R300.3Z9-HXT	10008290	3	D	20,0	20,0	62,0	121,0	3,0	9	Weldon	☐
JS720250D3R100.3Z9-HXT	10008292	3	D	25,0	25,0	78,0	146,0	1,0	9	Weldon	☐
JS720250D3R200.3Z9-HXT	10008293	3	D	25,0	25,0	78,0	146,0	2,0	9	Weldon	☐
JS720250D3R300.3Z9-HXT	10008294	3	D	25,0	25,0	78,0	146,0	3,0	9	Weldon	☐

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

JS720

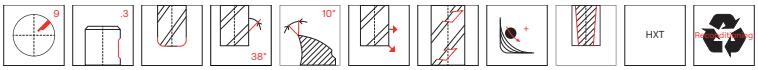
Alte prestazioni – Titanio – Spallamento – 9 Eliche – Weldon – Raggio di punta





D

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



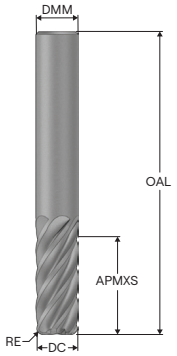
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS720100D3R050.3Z9C-HXT	10067893	3	D	■	10,0	10,0	40,0	89,0	0,5	9	Weldon	□
JS720100D3R100.3Z9C-HXT	10067894	3	D	■	10,0	10,0	40,0	89,0	1,0	9	Weldon	□
JS720100D3R200.3Z9C-HXT	10067895	3	D	■	10,0	10,0	40,0	89,0	2,0	9	Weldon	□
JS720120D3R050.3Z9C-HXT	10067897	3	D	■	12,0	12,0	45,0	100,0	0,5	9	Weldon	□
JS720120D3R100.3Z9C-HXT	10067898	3	D	■	12,0	12,0	45,0	100,0	1,0	9	Weldon	□
JS720120D3R200.3Z9C-HXT	10067899	3	D	■	12,0	12,0	45,0	100,0	2,0	9	Weldon	□
JS720160D3R100.3Z9C-HXT	10067900	3	D	■	16,0	16,0	65,0	130,0	1,0	9	Weldon	□
JS720160D3R200.3Z9C-HXT	10067901	3	D	■	16,0	16,0	65,0	130,0	2,0	9	Weldon	□
JS720160D3R300.3Z9C-HXT	10067902	3	D	■	16,0	16,0	65,0	130,0	3,0	9	Weldon	□
JS720200D3R100.3Z9C-HXT	10067903	3	D	■	20,0	20,0	62,0	121,0	1,0	9	Weldon	□
JS720200D3R200.3Z9C-HXT	10067904	3	D	■	20,0	20,0	62,0	121,0	2,0	9	Weldon	□
JS720200D3R300.3Z9C-HXT	10067905	3	D	■	20,0	20,0	62,0	121,0	3,0	9	Weldon	□
JS720250D3R100.3Z9C-HXT	10067906	3	D	■	25,0	25,0	78,0	146,0	1,0	9	Weldon	□
JS720250D3R200.3Z9C-HXT	10067907	3	D	■	25,0	25,0	78,0	146,0	2,0	9	Weldon	□
JS720250D3R300.3Z9C-HXT	10067908	3	D	■	25,0	25,0	78,0	146,0	3,0	9	Weldon	□

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

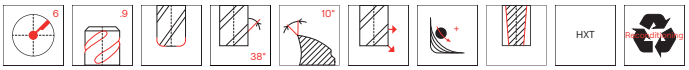
JS720

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





D



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

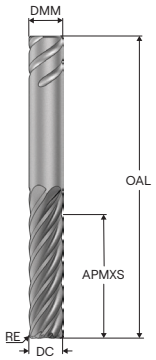
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS720060D2R050.9Z6-HXT	03060374	2	D	6,0	6,0	17,0	57,0	0,5	6	Safe-lock	☐
JS720060D2R100.9Z6-HXT	03060375	2	D	6,0	6,0	17,0	57,0	1,0	6	Safe-lock	☐
JS720080D2R050.9Z6-HXT	03060376	2	D	8,0	8,0	23,0	63,0	0,5	6	Safe-lock	☐
JS720080D2R100.9Z6-HXT	03061296	2	D	8,0	8,0	23,0	63,0	1,0	6	Safe-lock	☐
JS720100D2R050.9Z6-HXT	03060377	2	D	10,0	10,0	26,0	72,0	0,5	6	Safe-lock	☐
JS720100D2R100.9Z6-HXT	03060379	2	D	10,0	10,0	26,0	72,0	1,0	6	Safe-lock	☐
JS720100D2R200.9Z6-HXT	03060380	2	D	10,0	10,0	26,0	72,0	2,0	6	Safe-lock	☐
JS720100D2R300.9Z6-HXT	03060381	2	D	10,0	10,0	26,0	72,0	3,0	6	Safe-lock	☐
JS720120D2R050.9Z6-HXT	03060382	2	D	12,0	12,0	30,0	83,0	0,5	6	Safe-lock	☐
JS720120D2R100.9Z6-HXT	03060384	2	D	12,0	12,0	30,0	83,0	1,0	6	Safe-lock	☐
JS720120D2R200.9Z6-HXT	03060385	2	D	12,0	12,0	30,0	83,0	2,0	6	Safe-lock	☐
JS720120D2R300.9Z6-HXT	03060386	2	D	12,0	12,0	30,0	83,0	3,0	6	Safe-lock	☐
JS720160D2R050.9Z6-HXT	03060387	2	D	16,0	16,0	44,0	99,0	0,5	6	Safe-lock	☐
JS720160D2R100.9Z6-HXT	03060389	2	D	16,0	16,0	44,0	99,0	1,0	6	Safe-lock	☐
JS720160D2R200.9Z6-HXT	03060390	2	D	16,0	16,0	44,0	99,0	2,0	6	Safe-lock	☐
JS720160D2R300.9Z6-HXT	03060391	2	D	16,0	16,0	44,0	99,0	3,0	6	Safe-lock	☐
JS720160D2R400.9Z6-HXT	03060392	2	D	16,0	16,0	44,0	99,0	4,0	6	Safe-lock	☐
JS720160D2R600.9Z6-HXT	03060393	2	D	16,0	16,0	44,0	99,0	6,0	6	Safe-lock	☐
JS720200D2R050.9Z6-HXT	10228464	2	D	20,0	20,0	45,0	105,0	0,5	6	Safe-lock	☐
JS720200D2R100.9Z6-HXT	10228465	2	D	20,0	20,0	45,0	105,0	1,0	6	Safe-lock	☐
JS720200D2R200.9Z6-HXT	10228467	2	D	20,0	20,0	45,0	105,0	2,0	6	Safe-lock	☐
JS720200D2R300.9Z6-HXT	10228468	2	D	20,0	20,0	45,0	105,0	3,0	6	Safe-lock	☐
JS720250D2R050.9Z6-HXT	10228469	2	D	25,0	25,0	50,0	125,0	0,5	6	Safe-lock	☐
JS720250D2R100.9Z6-HXT	10228470	2	D	25,0	25,0	50,0	125,0	1,0	6	Safe-lock	☐
JS720250D2R200.9Z6-HXT	10228471	2	D	25,0	25,0	50,0	125,0	2,0	6	Safe-lock	☐
JS720250D2R300.9Z6-HXT	10228472	2	D	25,0	25,0	50,0	125,0	3,0	6	Safe-lock	☐

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

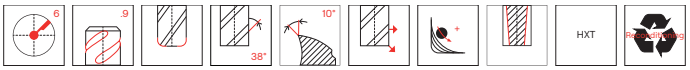
JS720

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





D



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

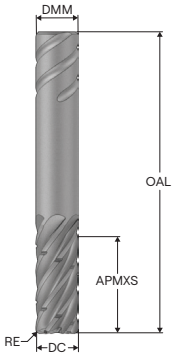
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS720080D3R050.9Z6-HXT	10228473	3	D	8,0	8,0	32,0	80,0	0,5	6	Safe-lock	☐
JS720080D3R100.9Z6-HXT	10228474	3	D	8,0	8,0	32,0	80,0	1,0	6	Safe-lock	☐
JS720100D3R050.9Z6-HXT	10228475	3	D	10,0	10,0	40,0	89,0	0,5	6	Safe-lock	☐
JS720100D3R100.9Z6-HXT	10228476	3	D	10,0	10,0	40,0	89,0	1,0	6	Safe-lock	☐
JS720100D3R200.9Z6-HXT	10228477	3	D	10,0	10,0	40,0	89,0	2,0	6	Safe-lock	☐
JS720120D3R050.9Z6-HXT	10228478	3	D	12,0	12,0	45,0	100,0	0,5	6	Safe-lock	☐
JS720120D3R100.9Z6-HXT	10228479	3	D	12,0	12,0	45,0	100,0	1,0	6	Safe-lock	☐
JS720120D3R200.9Z6-HXT	10228480	3	D	12,0	12,0	45,0	100,0	2,0	6	Safe-lock	☐
JS720160D3R050.9Z6-HXT	10228481	3	D	16,0	16,0	65,0	130,0	0,5	6	Safe-lock	☐
JS720160D3R100.9Z6-HXT	10228482	3	D	16,0	16,0	65,0	130,0	1,0	6	Safe-lock	☐
JS720160D3R200.9Z6-HXT	10228483	3	D	16,0	16,0	65,0	130,0	2,0	6	Safe-lock	☐
JS720160D3R300.9Z6-HXT	10228484	3	D	16,0	16,0	65,0	130,0	3,0	6	Safe-lock	☐
JS720200D3R050.9Z6-HXT	03060394	3	D	20,0	20,0	62,0	121,0	0,5	6	Safe-lock	☐
JS720200D3R100.9Z6-HXT	03060396	3	D	20,0	20,0	62,0	121,0	1,0	6	Safe-lock	☐
JS720200D3R200.9Z6-HXT	03060397	3	D	20,0	20,0	62,0	121,0	2,0	6	Safe-lock	☐
JS720200D3R300.9Z6-HXT	03060398	3	D	20,0	20,0	62,0	121,0	3,0	6	Safe-lock	☐
JS720200D3R400.9Z6-HXT	03060399	3	D	20,0	20,0	62,0	121,0	4,0	6	Safe-lock	☐
JS720200D3R500.9Z6-HXT	03060400	3	D	20,0	20,0	62,0	121,0	5,0	6	Safe-lock	☐
JS720200D3R600.9Z6-HXT	03060401	3	D	20,0	20,0	62,0	121,0	6,0	6	Safe-lock	☐
JS720250D3R050.9Z6-HXT	03060402	3	D	25,0	25,0	78,0	146,0	0,5	6	Safe-lock	☐
JS720250D3R100.9Z6-HXT	03060403	3	D	25,0	25,0	78,0	146,0	1,0	6	Safe-lock	☐
JS720250D3R200.9Z6-HXT	03060404	3	D	25,0	25,0	78,0	146,0	2,0	6	Safe-lock	☐
JS720250D3R300.9Z6-HXT	03060405	3	D	25,0	25,0	78,0	146,0	3,0	6	Safe-lock	☐
JS720250D3R400.9Z6-HXT	03060406	3	D	25,0	25,0	78,0	146,0	4,0	6	Safe-lock	☐
JS720250D3R600.9Z6-HXT	03060407	3	D	25,0	25,0	78,0	146,0	6,0	6	Safe-lock	☐

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

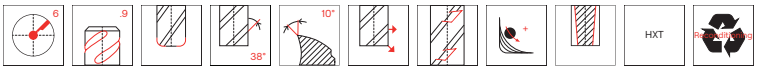
JS720

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





D



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

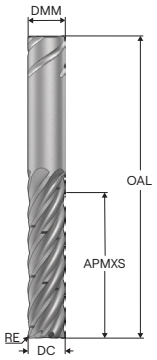
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS720080D2R050.9Z6C-HXT	10228527	2	D	■	8,0	8,0	23,0	63,0	0,5	6	Safe-lock	□
JS720080D2R100.9Z6C-HXT	10228528	2	D	■	8,0	8,0	23,0	63,0	1,0	6	Safe-lock	□
JS720100D2R050.9Z6C-HXT	03060378	2	D	■	10,0	10,0	26,0	72,0	0,5	6	Safe-lock	□
JS720100D2R100.9Z6C-HXT	10228529	2	D	■	10,0	10,0	26,0	72,0	1,0	6	Safe-lock	□
JS720120D2R050.9Z6C-HXT	03060383	2	D	■	12,0	12,0	30,0	83,0	0,5	6	Safe-lock	□
JS720120D2R100.9Z6C-HXT	03298334	2	D	■	12,0	12,0	30,0	83,0	1,0	6	Safe-lock	□
JS720120D2R200.9Z6C-HXT	03298335	2	D	■	12,0	12,0	30,0	83,0	2,0	6	Safe-lock	□
JS720120D2R250.9Z6C-HXT	03298336	2	D	■	12,0	12,0	30,0	83,0	2,5	6	Safe-lock	□
JS720120D2R300.9Z6C-HXT	03298337	2	D	■	12,0	12,0	30,0	83,0	3,0	6	Safe-lock	□
JS720120D2R310.9Z6C-HXT	03298338	2	D	■	12,0	12,0	30,0	83,0	3,1	6	Safe-lock	□
JS720160D2R050.9Z6C-HXT	03060388	2	D	■	16,0	16,0	44,0	99,0	0,5	6	Safe-lock	■
JS720160D2R100.9Z6C-HXT	03298339	2	D	■	16,0	16,0	44,0	99,0	1,0	6	Safe-lock	□
JS720160D2R200.9Z6C-HXT	03298340	2	D	■	16,0	16,0	44,0	99,0	2,0	6	Safe-lock	□
JS720160D2R250.9Z6C-HXT	03298341	2	D	■	16,0	16,0	44,0	99,0	2,5	6	Safe-lock	□
JS720160D2R300.9Z6C-HXT	03298342	2	D	■	16,0	16,0	44,0	99,0	3,0	6	Safe-lock	□
JS720160D2R310.9Z6C-HXT	03298343	2	D	■	16,0	16,0	44,0	99,0	3,1	6	Safe-lock	□
JS720160D2R400.9Z6C-HXT	03298344	2	D	■	16,0	16,0	44,0	99,0	4,0	6	Safe-lock	□
JS720160D2R600.9Z6C-HXT	03298345	2	D	■	16,0	16,0	44,0	99,0	6,0	6	Safe-lock	□

□ Safelock disponibile. Il tempo di consegna è di 6 giorni. ■ **Prodotto standard.**

JS720

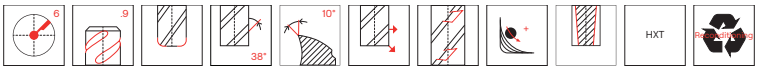
Alte prestazioni – Titanio – Spallamento – 6 Eliche – Safelock – Raggio di punta





D

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



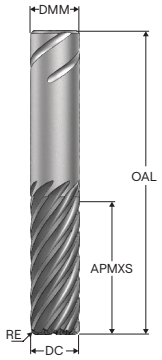
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS720160D3R050.9Z6C-HXT	10228530	3	D	■	16,0	16,0	65,0	130,0	0,5	6	Safe-lock	□
JS720160D3R100.9Z6C-HXT	10228531	3	D	■	16,0	16,0	65,0	130,0	1,0	6	Safe-lock	□
JS720160D3R200.9Z6C-HXT	10228532	3	D	■	16,0	16,0	65,0	130,0	2,0	6	Safe-lock	□
JS720160D3R300.9Z6C-HXT	10228533	3	D	■	16,0	16,0	65,0	130,0	3,0	6	Safe-lock	□
JS720200D3R050.9Z6C-HXT	03060395	3	D	■	20,0	20,0	62,0	121,0	0,5	6	Safe-lock	□
JS720200D3R100.9Z6C-HXT	03298346	3	D	■	20,0	20,0	62,0	121,0	1,0	6	Safe-lock	□
JS720200D3R200.9Z6C-HXT	03298347	3	D	■	20,0	20,0	62,0	121,0	2,0	6	Safe-lock	□
JS720200D3R250.9Z6C-HXT	03298348	3	D	■	20,0	20,0	62,0	121,0	2,5	6	Safe-lock	□
JS720200D3R300.9Z6C-HXT	03298349	3	D	■	20,0	20,0	62,0	121,0	3,0	6	Safe-lock	□
JS720200D3R310.9Z6C-HXT	03298350	3	D	■	20,0	20,0	62,0	121,0	3,1	6	Safe-lock	□
JS720200D3R400.9Z6C-HXT	03298351	3	D	■	20,0	20,0	62,0	121,0	4,0	6	Safe-lock	□
JS720200D3R500.9Z6C-HXT	03298352	3	D	■	20,0	20,0	62,0	121,0	5,0	6	Safe-lock	□
JS720200D3R600.9Z6C-HXT	03298353	3	D	■	20,0	20,0	62,0	121,0	6,0	6	Safe-lock	□
JS720250D3R050.9Z6C-HXT	03066461	3	D	■	25,0	25,0	78,0	146,0	0,5	6	Safe-lock	□
JS720250D3R100.9Z6C-HXT	03298354	3	D	■	25,0	25,0	78,0	146,0	1,0	6	Safe-lock	□
JS720250D3R200.9Z6C-HXT	03298355	3	D	■	25,0	25,0	78,0	146,0	2,0	6	Safe-lock	□
JS720250D3R300.9Z6C-HXT	03298356	3	D	■	25,0	25,0	78,0	146,0	3,0	6	Safe-lock	□
JS720250D3R400.9Z6C-HXT	03298357	3	D	■	25,0	25,0	78,0	146,0	4,0	6	Safe-lock	□
JS720250D3R600.9Z6C-HXT	03298358	3	D	■	25,0	25,0	78,0	146,0	6,0	6	Safe-lock	□

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

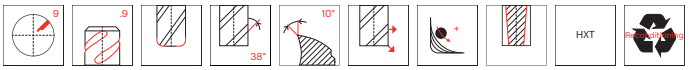
JS720

Alte prestazioni – Titanio – Spallamento – 9 Eliche – Safelock – Raggio di punta





D



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

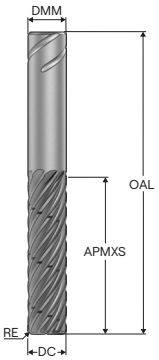
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS720100D2R050.9Z9-HXT	10067909	2	D	10,0	10,0	26,0	72,0	0,5	9	Safe-lock	☐
JS720100D2R100.9Z9-HXT	10067910	2	D	10,0	10,0	26,0	72,0	1,0	9	Safe-lock	☐
JS720100D2R200.9Z9-HXT	10067911	2	D	10,0	10,0	26,0	72,0	2,0	9	Safe-lock	☐
JS720120D2R050.9Z9-HXT	10067912	2	D	12,0	12,0	30,0	83,0	0,5	9	Safe-lock	☐
JS720120D2R100.9Z9-HXT	10067913	2	D	12,0	12,0	30,0	83,0	1,0	9	Safe-lock	☐
JS720120D2R200.9Z9-HXT	10067914	2	D	12,0	12,0	30,0	83,0	2,0	9	Safe-lock	☐
JS720160D2R100.9Z9-HXT	10008295	2	D	16,0	16,0	44,0	99,0	1,0	9	Safe-lock	☐
JS720160D2R200.9Z9-HXT	10008296	2	D	16,0	16,0	44,0	99,0	2,0	9	Safe-lock	☐
JS720160D2R300.9Z9-HXT	10008297	2	D	16,0	16,0	44,0	99,0	3,0	9	Safe-lock	☐
JS720200D2R100.9Z9-HXT	10228399	2	D	20,0	20,0	45,0	105,0	1,0	9	Safe-lock	☐
JS720200D2R200.9Z9-HXT	10228400	2	D	20,0	20,0	45,0	105,0	2,0	9	Safe-lock	☐
JS720200D2R300.9Z9-HXT	10228401	2	D	20,0	20,0	45,0	105,0	3,0	9	Safe-lock	☐
JS720250D2R100.9Z9-HXT	10008298	2	D	25,0	25,0	50,0	125,0	1,0	9	Safe-lock	☐
JS720250D2R200.9Z9-HXT	10008299	2	D	25,0	25,0	50,0	125,0	2,0	9	Safe-lock	☐
JS720250D2R300.9Z9-HXT	10008300	2	D	25,0	25,0	50,0	125,0	3,0	9	Safe-lock	☐
JS720100D3R050.9Z9-HXT	10067915	3	D	10,0	10,0	40,0	89,0	0,5	9	Safe-lock	☐
JS720100D3R100.9Z9-HXT	10067916	3	D	10,0	10,0	40,0	89,0	1,0	9	Safe-lock	☐
JS720100D3R200.9Z9-HXT	10067917	3	D	10,0	10,0	40,0	89,0	2,0	9	Safe-lock	☐
JS720120D3R050.9Z9-HXT	10067918	3	D	12,0	12,0	45,0	100,0	0,5	9	Safe-lock	☐
JS720120D3R100.9Z9-HXT	10067919	3	D	12,0	12,0	45,0	100,0	1,0	9	Safe-lock	☐
JS720120D3R200.9Z9-HXT	10067921	3	D	12,0	12,0	45,0	100,0	2,0	9	Safe-lock	☐
JS720160D3R100.9Z9-HXT	10008301	3	D	16,0	16,0	65,0	130,0	1,0	9	Safe-lock	☐
JS720160D3R200.9Z9-HXT	10008302	3	D	16,0	16,0	65,0	130,0	2,0	9	Safe-lock	☐
JS720160D3R300.9Z9-HXT	10008303	3	D	16,0	16,0	65,0	130,0	3,0	9	Safe-lock	☐
JS720200D3R100.9Z9-HXT	10008304	3	D	20,0	20,0	62,0	121,0	1,0	9	Safe-lock	☐
JS720200D3R200.9Z9-HXT	10008305	3	D	20,0	20,0	62,0	121,0	2,0	9	Safe-lock	☐
JS720200D3R300.9Z9-HXT	10008306	3	D	20,0	20,0	62,0	121,0	3,0	9	Safe-lock	☐
JS720250D3R100.9Z9-HXT	10008307	3	D	25,0	25,0	78,0	146,0	1,0	9	Safe-lock	☐
JS720250D3R200.9Z9-HXT	10008308	3	D	25,0	25,0	78,0	146,0	2,0	9	Safe-lock	☐
JS720250D3R300.9Z9-HXT	10008309	3	D	25,0	25,0	78,0	146,0	3,0	9	Safe-lock	☐

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

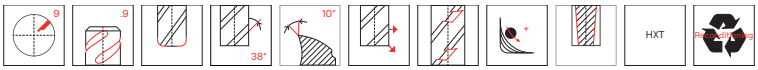
JS720

Alte prestazioni – Titanio – Spallamento – 9 Eliche – Safelock – Raggio di punta





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



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JS720100D3R050.9Z9C-HXT	10067922	3	D	■	10,0	10,0	40,0	89,0	0,5	9	Safe-lock	□
JS720100D3R100.9Z9C-HXT	10067923	3	D	■	10,0	10,0	40,0	89,0	1,0	9	Safe-lock	□
JS720100D3R200.9Z9C-HXT	10067924	3	D	■	10,0	10,0	40,0	89,0	2,0	9	Safe-lock	□
JS720120D3R050.9Z9C-HXT	10067925	3	D	■	12,0	12,0	45,0	100,0	0,5	9	Safe-lock	□
JS720120D3R100.9Z9C-HXT	10067926	3	D	■	12,0	12,0	45,0	100,0	1,0	9	Safe-lock	□
JS720120D3R200.9Z9C-HXT	10067927	3	D	■	12,0	12,0	45,0	100,0	2,0	9	Safe-lock	□
JS720160D3R100.9Z9C-HXT	10067928	3	D	■	16,0	16,0	65,0	130,0	1,0	9	Safe-lock	□
JS720160D3R200.9Z9C-HXT	10067929	3	D	■	16,0	16,0	65,0	130,0	2,0	9	Safe-lock	□
JS720160D3R300.9Z9C-HXT	10067930	3	D	■	16,0	16,0	65,0	130,0	3,0	9	Safe-lock	□
JS720200D3R100.9Z9C-HXT	10067931	3	D	■	20,0	20,0	62,0	121,0	1,0	9	Safe-lock	□
JS720200D3R200.9Z9C-HXT	10067932	3	D	■	20,0	20,0	62,0	121,0	2,0	9	Safe-lock	□
JS720200D3R300.9Z9C-HXT	10067933	3	D	■	20,0	20,0	62,0	121,0	3,0	9	Safe-lock	□
JS720250D3R100.9Z9C-HXT	10067934	3	D	■	25,0	25,0	78,0	146,0	1,0	9	Safe-lock	□
JS720250D3R200.9Z9C-HXT	10067935	3	D	■	25,0	25,0	78,0	146,0	2,0	9	Safe-lock	□
JS720250D3R300.9Z9C-HXT	10067936	3	D	■	25,0	25,0	78,0	146,0	3,0	9	Safe-lock	□

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

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

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 699 - 707

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

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)*

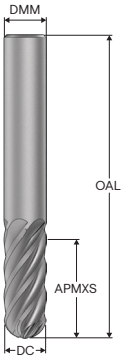
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

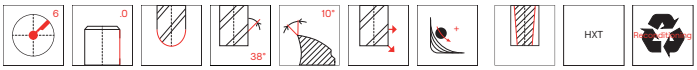
JS730

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

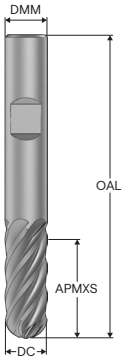
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS730060D2B.0Z6-HXT	03067605	2	D	6,0	6,0	17,0	57,0	3,0	6	Cylindrical	■
JS730080D2B.0Z6-HXT	03067606	2	D	8,0	8,0	23,0	63,0	4,0	6	Cylindrical	■
JS730100D2B.0Z6-HXT	03067607	2	D	10,0	10,0	26,0	72,0	5,0	6	Cylindrical	■
JS730120D2B.0Z6-HXT	03067608	2	D	12,0	12,0	30,0	83,0	6,0	6	Cylindrical	■
JS730160D2B.0Z6-HXT	03067609	2	D	16,0	16,0	44,0	99,0	8,0	6	Cylindrical	■
JS730200D3B.0Z6-HXT	03067610	3	D	20,0	20,0	62,0	121,0	10,0	6	Cylindrical	■
JS730250D3B.0Z6-HXT	03067611	3	D	25,0	25,0	78,0	146,0	12,5	6	Cylindrical	■

■ **Prodotto standard.**

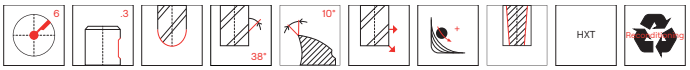
JS730

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

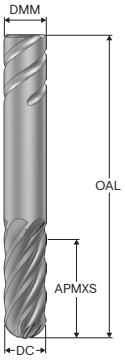
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS730060D2B.3Z6-HXT	03067778	2	D	6,0	6,0	17,0	57,0	3,0	6	Weldon	☐
JS730080D2B.3Z6-HXT	03067779	2	D	8,0	8,0	23,0	63,0	4,0	6	Weldon	■
JS730100D2B.3Z6-HXT	03067780	2	D	10,0	10,0	26,0	72,0	5,0	6	Weldon	☐
JS730120D2B.3Z6-HXT	03067781	2	D	12,0	12,0	30,0	83,0	6,0	6	Weldon	☐
JS730160D2B.3Z6-HXT	03067782	2	D	16,0	16,0	44,0	99,0	8,0	6	Weldon	☐
JS730200D3B.3Z6-HXT	03067783	3	D	20,0	20,0	62,0	121,0	10,0	6	Weldon	☐
JS730250D3B.3Z6-HXT	03067784	3	D	25,0	25,0	78,0	146,0	12,5	6	Weldon	☐

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

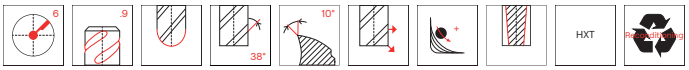
JS730

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	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JS730060D2B.9Z6-HXT	03067785	2	D	6,0	6,0	17,0	57,0	3,0	6	Safe-lock	☐
JS730080D2B.9Z6-HXT	03067786	2	D	8,0	8,0	23,0	63,0	4,0	6	Safe-lock	☐
JS730100D2B.9Z6-HXT	03067787	2	D	10,0	10,0	26,0	72,0	5,0	6	Safe-lock	☐
JS730120D2B.9Z6-HXT	03067788	2	D	12,0	12,0	30,0	83,0	6,0	6	Safe-lock	☐
JS730160D2B.9Z6-HXT	03067789	2	D	16,0	16,0	44,0	99,0	8,0	6	Safe-lock	☐
JS730200D3B.9Z6-HXT	03067790	3	D	20,0	20,0	62,0	121,0	10,0	6	Safe-lock	☐
JS730250D3B.9Z6-HXT	03067791	3	D	25,0	25,0	78,0	146,0	12,5	6	Safe-lock	☐

☐ 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)*

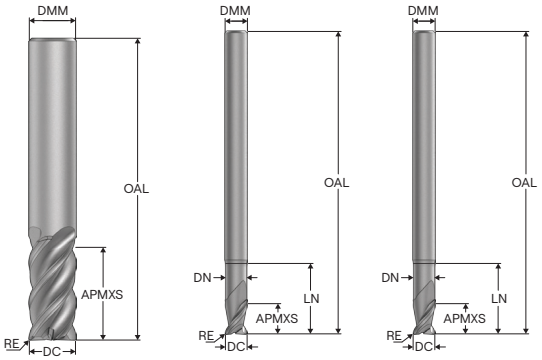
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

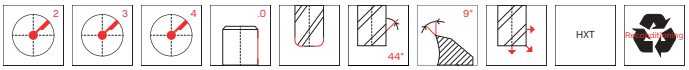
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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

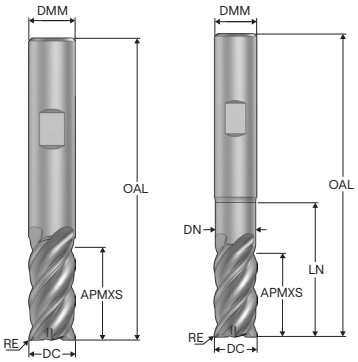
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JHP751080D1R040.0Z4	HXT	10105487	1	D	8,0	8,0	16,0	58,0	–	–	0,4	4	Cylindrical	■
JHP751100D1R040.0Z4	HXT	10105548	1	D	10,0	10,0	20,0	66,0	–	–	0,4	4	Cylindrical	■
JHP751100D1R150.0Z4	HXT	10105549	1	D	10,0	10,0	20,0	66,0	–	–	1,5	4	Cylindrical	■
JHP751120D1R040.0Z4	HXT	10105550	1	D	12,0	12,0	24,0	75,0	–	–	0,4	4	Cylindrical	■
JHP751120D1R150.0Z4	HXT	10105552	1	D	12,0	12,0	24,0	75,0	–	–	1,5	4	Cylindrical	■
JHP751160D1R040.0Z4	HXT	10105581	1	D	16,0	16,0	32,0	92,0	–	–	0,4	4	Cylindrical	■
JHP751160D1R150.0Z4	HXT	10105582	1	D	16,0	16,0	32,0	92,0	–	–	1,5	4	Cylindrical	■
JHP751200D1R080.0Z4	HXT	10105583	1	D	20,0	20,0	40,0	104,0	–	–	0,8	4	Cylindrical	■
JHP751020G2R020.0Z2	HXT	10105584	2	G	2,0	3,0	3,0	38,0	6,0	1,9	0,2	2	Cylindrical	■
JHP751030G2R020.0Z2	HXT	10105585	2	E	3,0	3,0	4,5	38,0	9,0	2,8	0,2	2	Cylindrical	■
JHP751040G2R020.0Z2	HXT	10105586	2	G	4,0	6,0	6,0	50,0	9,0	3,7	0,2	2	Cylindrical	■
JHP751050G2R030.0Z2	HXT	10105587	2	G	5,0	6,0	7,5	50,0	9,0	4,6	0,3	2	Cylindrical	■
JHP751060E2R030.0Z3	HXT	10105588	2	E	6,0	6,0	9,0	57,0	19,0	5,6	0,3	3	Cylindrical	■
JHP751080E2R040.0Z4	HXT	10105589	2	E	8,0	8,0	16,0	63,0	24,0	7,4	0,4	4	Cylindrical	■
JHP751100E2R040.0Z4	HXT	10105590	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,4	4	Cylindrical	■
JHP751100E2R080.0Z4	HXT	10105591	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,8	4	Cylindrical	■
JHP751100E2R200.0Z4	HXT	10105593	2	E	10,0	10,0	20,0	72,0	30,0	9,4	2,0	4	Cylindrical	■
JHP751120E2R040.0Z4	HXT	10105594	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,4	4	Cylindrical	■
JHP751120E2R080.0Z4	HXT	10105595	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,8	4	Cylindrical	■
JHP751120E2R310.0Z4	HXT	10105596	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,1	4	Cylindrical	■
JHP751140E2R080.0Z4	HXT	10105597	2	E	14,0	14,0	28,0	92,0	45,0	13,4	0,8	4	Cylindrical	■
JHP751160E2R040.0Z4	HXT	10105598	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,4	4	Cylindrical	■
JHP751160E2R080.0Z4	HXT	10105599	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,8	4	Cylindrical	■
JHP751160E2R200.0Z4	HXT	10105600	2	E	16,0	16,0	32,0	104,0	52,0	15,4	2,0	4	Cylindrical	■
JHP751200E2R080.0Z4	HXT	10105601	2	E	20,0	20,0	40,0	129,0	75,0	19,4	0,8	4	Cylindrical	■

■ **Prodotto standard.**

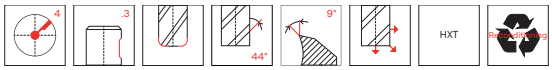
JHP751

Alte prestazioni – Titanio – Spallamento – 2-4 Eliche – Weldon – Raggio di punta





D E



– 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	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JHP751080D1R040.3Z4	HXT	10105739	1	D	8,0	8,0	16,0	58,0	–	–	0,4	4	Weldon	■
JHP751100D1R040.3Z4	HXT	10105740	1	D	10,0	10,0	20,0	66,0	–	–	0,4	4	Weldon	■
JHP751100D1R150.3Z4	HXT	10105742	1	D	10,0	10,0	20,0	66,0	–	–	1,5	4	Weldon	■
JHP751120D1R040.3Z4	HXT	10105743	1	D	12,0	12,0	24,0	75,0	–	–	0,4	4	Weldon	■
JHP751120D1R150.3Z4	HXT	10105744	1	D	12,0	12,0	24,0	75,0	–	–	1,5	4	Weldon	■
JHP751160D1R040.3Z4	HXT	10105745	1	D	16,0	16,0	32,0	92,0	–	–	0,4	4	Weldon	■
JHP751160D1R150.3Z4	HXT	10105746	1	D	16,0	16,0	32,0	92,0	–	–	1,5	4	Weldon	■
JHP751200D1R080.3Z4	HXT	10105747	1	D	20,0	20,0	40,0	104,0	–	–	0,8	4	Weldon	■
JHP751080E2R040.3Z4	HXT	10105748	2	E	8,0	8,0	16,0	63,0	24,0	7,4	0,4	4	Weldon	■
JHP751100E2R040.3Z4	HXT	10105749	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,4	4	Weldon	■
JHP751100E2R080.3Z4	HXT	10105750	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,8	4	Weldon	■
JHP751100E2R200.3Z4	HXT	10105751	2	E	10,0	10,0	20,0	72,0	30,0	9,4	2,0	4	Weldon	■
JHP751120E2R040.3Z4	HXT	10105752	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,4	4	Weldon	■
JHP751120E2R080.3Z4	HXT	10105753	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,8	4	Weldon	■
JHP751120E2R310.3Z4	HXT	10105754	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,1	4	Weldon	■
JHP751140E2R080.3Z4	HXT	10105755	2	E	14,0	14,0	28,0	92,0	45,0	13,4	0,8	4	Weldon	■
JHP751160E2R040.3Z4	HXT	10105756	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,4	4	Weldon	■
JHP751160E2R080.3Z4	HXT	10105757	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,8	4	Weldon	■
JHP751160E2R200.3Z4	HXT	10105758	2	E	16,0	16,0	32,0	104,0	52,0	15,4	2,0	4	Weldon	■
JHP751200E2R080.3Z4	HXT	10105759	2	E	20,0	20,0	40,0	129,0	75,0	19,4	0,8	4	Weldon	■

■ **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)*

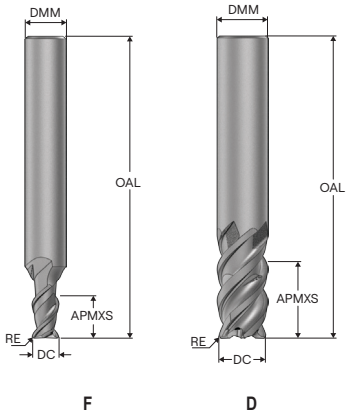
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

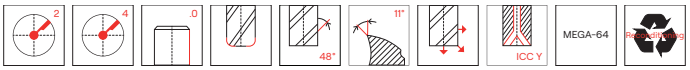
JHP760

Alte prestazioni – ISO-M – Spallamento – 2-4 Eliche – Cilindrico – Raggio di punta





—Tolleranze:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE= ±0,03 mm
—Riaffilatura possibile se DC è ≥Ø6



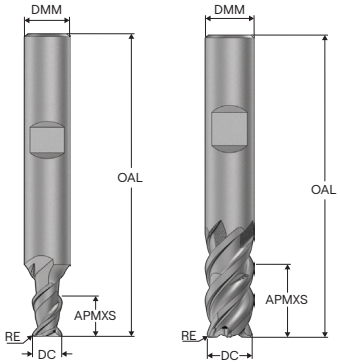
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm				
760040R020Z2.0A-MEGA-64	02734051	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0	2	Cylindrical	■
760040R040Z2.0A-MEGA-64	02623413	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0	2	Cylindrical	■
760050R020Z2.0A-MEGA-64	02734052	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0	2	Cylindrical	■
760050R040Z2.0A-MEGA-64	02623435	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0	2	Cylindrical	■
760060R020Z4.0A-MEGA-64	02734053	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	Cylindrical	■
760060R040Z4.0A-MEGA-64	02623433	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	Cylindrical	■
760080R040Z4.0A-MEGA-64	02623436	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	Cylindrical	■
760080R100Z4.0A-MEGA-64	02623437	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	Cylindrical	■
760100R040Z4.0A-MEGA-64	02623460	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	Cylindrical	■
760100R100Z4.0A-MEGA-64	02623463	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	Cylindrical	■
760100R150Z4.0A-MEGA-64	02623466	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	Cylindrical	■
760120R040Z4.0A-MEGA-64	02623819	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	Cylindrical	■
760120R100Z4.0A-MEGA-64	02623825	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	Cylindrical	■
760120R150Z4.0A-MEGA-64	02623828	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	Cylindrical	■
760120R310Z4.0A-MEGA-64	02623833	2	D	■	12,0	12,0	24,0	75,0	3,1	–	4	Cylindrical	■
760200R040Z4.0A-MEGA-64	02734055	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	Cylindrical	■
760200R080Z4.0A-MEGA-64	02623852	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	Cylindrical	■
760L080R040Z4.0A-MEGA-64	02623438	3	D	■	8,0	8,0	28,0	65,0	0,4	–	4	Cylindrical	■
760L100R040Z4.0A-MEGA-64	02623461	3	D	■	10,0	10,0	36,0	75,0	0,4	–	4	Cylindrical	■
760L100R100Z4.0A-MEGA-64	02623464	3	D	■	10,0	10,0	36,0	75,0	1,0	–	4	Cylindrical	■
760L100R150Z4.0A-MEGA-64	02623467	3	D	■	10,0	10,0	36,0	75,0	1,5	–	4	Cylindrical	■
760L100R200Z4.0A-MEGA-64	02623472	3	D	■	10,0	10,0	36,0	75,0	2,0	–	4	Cylindrical	■
760L100R310Z4.0A-MEGA-64	02623807	3	D	■	10,0	10,0	36,0	75,0	3,1	–	4	Cylindrical	■
760L120R040Z4.0A-MEGA-64	02623821	3	D	■	12,0	12,0	42,0	90,0	0,4	–	4	Cylindrical	■
760L120R100Z4.0A-MEGA-64	02623826	3	D	■	12,0	12,0	42,0	90,0	1,0	–	4	Cylindrical	■
760L120R150Z4.0A-MEGA-64	02623829	3	D	■	12,0	12,0	42,0	90,0	1,5	–	4	Cylindrical	■
760L120R400Z4.0A-MEGA-64	02623838	3	D	■	12,0	12,0	42,0	90,0	4,0	–	4	Cylindrical	■
760L160R040Z4.0A-MEGA-64	02623840	3	D	■	16,0	16,0	50,0	100,0	0,4	–	4	Cylindrical	■
760L160R100Z4.0A-MEGA-64	02623842	3	D	■	16,0	16,0	50,0	100,0	1,0	–	4	Cylindrical	■
760L160R150Z4.0A-MEGA-64	02623844	3	D	■	16,0	16,0	50,0	100,0	1,5	–	4	Cylindrical	■

■ **Prodotto standard.**

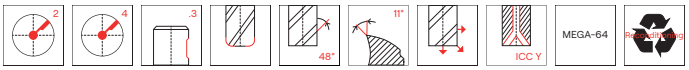
JHP760

Alte prestazioni – ISO-M – Spallamento – 2-4 Eliche – Weldon – Raggio di punta





– Tolleranze:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,03 mm
– Riaffilatura possibile se DC è ≥Ø6



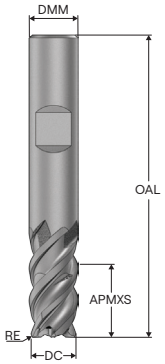
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm				
760040R020Z2.0A-MEGA-64W	02734065	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0	2	Weldon	□
760040R040Z2.0A-MEGA-64W	02669339	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0	2	Weldon	□
760050R020Z2.0A-MEGA-64W	02734068	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0	2	Weldon	□
760050R040Z2.0A-MEGA-64W	02669340	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0	2	Weldon	□
760060R020Z4.0A-MEGA-64W	02734069	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	Weldon	□
760060R040Z4.0A-MEGA-64W	02669341	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	Weldon	□
760080R040Z4.0A-MEGA-64W	02669343	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	Weldon	■
760080R100Z4.0A-MEGA-64W	02669344	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	Weldon	□
760100R040Z4A-MEGA-64	02623442	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	Weldon	■
760100R100Z4A-MEGA-64	02623462	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	Weldon	■
760100R150Z4A-MEGA-64	02623465	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	Weldon	■
760120R040Z4A-MEGA-64	02623817	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	Weldon	■
760120R100Z4A-MEGA-64	02623824	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	Weldon	■
760120R150Z4A-MEGA-64	02623827	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	Weldon	■
760120R400Z4A-MEGA-64	02623835	2	D	■	12,0	12,0	24,0	75,0	4,0	–	4	Weldon	■
760160R040Z4A-MEGA-64	02623839	2	D	■	16,0	16,0	40,0	90,0	0,4	–	4	Weldon	■
760160R100Z4A-MEGA-64	02623841	2	D	■	16,0	16,0	40,0	90,0	1,0	–	4	Weldon	■
760160R150Z4A-MEGA-64	02623843	2	D	■	16,0	16,0	40,0	90,0	1,5	–	4	Weldon	■
760160R200Z4A-MEGA-64	02623845	2	D	■	16,0	16,0	40,0	90,0	2,0	–	4	Weldon	■
760200R040Z4A-MEGA-64	02734054	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	Weldon	■
760200R080Z4A-MEGA-64	02623851	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	Weldon	■

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

JHP760

Alte prestazioni – ISO-M – Spallamento – 2-4 Eliche – Weldon – Raggio di punta





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	CSP	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
760L080R040Z4.0A-MEGA-64W	02720459	3	D	■	8,0	8,0	28,0	65,0	0,4	4	Weldon	□
760L100R040Z4.0A-MEGA-64W	02669345	3	D	■	10,0	10,0	36,0	75,0	0,4	4	Weldon	□
760L100R100Z4.0A-MEGA-64W	02669346	3	D	■	10,0	10,0	36,0	75,0	1,0	4	Weldon	□
760L100R150Z4.0A-MEGA-64W	02669347	3	D	■	10,0	10,0	36,0	75,0	1,5	4	Weldon	□
760L100R200Z4.0A-MEGA-64W	02669348	3	D	■	10,0	10,0	36,0	75,0	2,0	4	Weldon	□
760L120R040Z4.0A-MEGA-64W	02669350	3	D	■	12,0	12,0	42,0	90,0	0,4	4	Weldon	□
760L120R100Z4.0A-MEGA-64W	02669351	3	D	■	12,0	12,0	42,0	90,0	1,0	4	Weldon	□
760L120R150Z4.0A-MEGA-64W	02669352	3	D	■	12,0	12,0	42,0	90,0	1,5	4	Weldon	□
760L160R040Z4.0A-MEGA-64W	02669356	3	D	■	16,0	16,0	50,0	100,0	0,4	4	Weldon	□
760L160R100Z4.0A-MEGA-64W	02669357	3	D	■	16,0	16,0	50,0	100,0	1,0	4	Weldon	□
760L160R150Z4.0A-MEGA-64W	02669358	3	D	■	16,0	16,0	50,0	100,0	1,5	4	Weldon	□

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

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)*

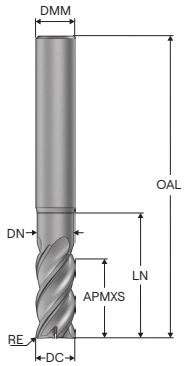
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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





E

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



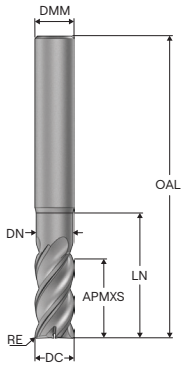
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JHP770060E2R030.0Z4A-SIRA	02760645	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Cylindrical	■
JHP770080E2R040.0Z4A-SIRA	02760653	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Cylindrical	■
JHP770080E2R050.0Z4A-SIRA	02823416	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	Cylindrical	■
JHP770100E2R040.0Z4A-SIRA	02760654	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Cylindrical	■
JHP770100E2R050.0Z4A-SIRA	02823417	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	Cylindrical	■
JHP770120E2R040.0Z4A-SIRA	02760656	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Cylindrical	■
JHP770120E2R050.0Z4A-SIRA	02823419	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	Cylindrical	■
JHP770120E2R100.0Z4A-SIRA	02823420	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	Cylindrical	■
JHP770120E2R250.0Z4A-SIRA	02760659	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Cylindrical	■
JHP770140E2R050.0Z4A-SIRA	02823421	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	Cylindrical	■
JHP770160E2R040.0Z4A-SIRA	02760661	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Cylindrical	■
JHP770160E2R050.0Z4A-SIRA	02823422	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	Cylindrical	■
JHP770160E2R080.0Z4A-SIRA	02760662	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Cylindrical	■
JHP770160E2R100.0Z4A-SIRA	02823423	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	Cylindrical	■
JHP770160E2R250.0Z4A-SIRA	02760663	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	Cylindrical	■
JHP770160E2R310.0Z4A-SIRA	02760664	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	Cylindrical	■
JHP770160E2R400.0Z4A-SIRA	02760665	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	Cylindrical	■
JHP770200E2R050.0Z4A-SIRA	02823424	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	Cylindrical	■
JHP770200E2R100.0Z4A-SIRA	02823425	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	Cylindrical	■
JHP770200E2R250.0Z4A-SIRA	02760668	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	Cylindrical	■
JHP770200E2R310.0Z4A-SIRA	02760669	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	Cylindrical	■
JHP770200E2R400.0Z4A-SIRA	02760670	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	Cylindrical	■

■ **Prodotto standard.**
Nota: Se il raggio di punta è >15% di DC → a_p=−30%, f_z= -20%

JHP770

Alte prestazioni – Titanio – Spallamento – 4-5 Eliche – Cilindrico – Raggio di punta





E



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

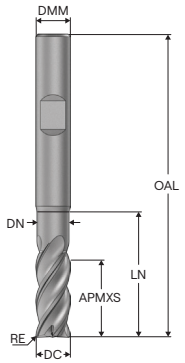
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JHP770160E2R050.0Z5A-SIRA	02810129	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	Cylindrical	■
JHP770160E2R100.0Z5A-SIRA	02810130	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	Cylindrical	■
JHP770160E2R250.0Z5A-SIRA	02810131	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	Cylindrical	■
JHP770160E2R310.0Z5A-SIRA	02810132	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	Cylindrical	■
JHP770160E2R400.0Z5A-SIRA	02810133	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	Cylindrical	■
JHP770200E2R050.0Z5A-SIRA	02810134	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	Cylindrical	■
JHP770200E2R100.0Z5A-SIRA	02810135	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	Cylindrical	■
JHP770200E2R250.0Z5A-SIRA	02810136	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	Cylindrical	■
JHP770200E2R310.0Z5A-SIRA	02810137	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	Cylindrical	■
JHP770200E2R400.0Z5A-SIRA	02810138	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	Cylindrical	■
JHP770250E2R050.0Z5A-SIRA	02810139	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	Cylindrical	■

■ **Prodotto standard.**
Nota: Se il raggio di punta è >15% di DC → a_p= -30%, f_z= -20%

JHP770

Alte prestazioni – Titanio – Spallamento – 4-5 Eliche – Weldon – Raggio di punta





E

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



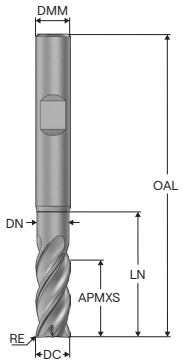
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JHP770060E2R030.3Z4A-SIRA	02760796	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Weldon	■
JHP770080E2R040.3Z4A-SIRA	02760799	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Weldon	□
JHP770080E2R050.3Z4A-SIRA	02823428	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	Weldon	■
JHP770100E2R040.3Z4A-SIRA	02760801	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Weldon	□
JHP770100E2R050.3Z4A-SIRA	02823429	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	Weldon	■
JHP770120E2R040.3Z4A-SIRA	02760803	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Weldon	□
JHP770120E2R050.3Z4A-SIRA	02823431	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	Weldon	■
JHP770120E2R100.3Z4A-SIRA	02823432	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	Weldon	■
JHP770120E2R250.3Z4A-SIRA	02760805	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Weldon	□
JHP770140E2R050.3Z4A-SIRA	02823433	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	Weldon	■
JHP770160E2R040.3Z4A-SIRA	02760807	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Weldon	□
JHP770160E2R050.3Z4A-SIRA	02823434	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	Weldon	■
JHP770160E2R080.3Z4A-SIRA	02760809	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Weldon	□
JHP770160E2R100.3Z4A-SIRA	02823435	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	Weldon	■
JHP770160E2R250.3Z4A-SIRA	02760810	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	Weldon	■
JHP770160E2R310.3Z4A-SIRA	02760811	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	Weldon	□
JHP770160E2R400.3Z4A-SIRA	02760817	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	Weldon	□
JHP770200E2R050.3Z4A-SIRA	02823436	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	Weldon	■
JHP770200E2R100.3Z4A-SIRA	02823437	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	Weldon	■
JHP770200E2R250.3Z4A-SIRA	02760823	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	Weldon	□
JHP770200E2R310.3Z4A-SIRA	02760824	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	Weldon	□
JHP770200E2R400.3Z4A-SIRA	02760825	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	Weldon	□

■ **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





E



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

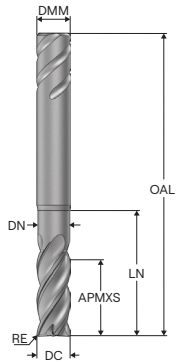
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JHP770160E2R050.3Z5A-SIRA	02810143	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	Weldon	■
JHP770160E2R100.3Z5A-SIRA	02810144	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	Weldon	■
JHP770160E2R250.3Z5A-SIRA	02810145	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	Weldon	□
JHP770160E2R310.3Z5A-SIRA	02810146	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	Weldon	■
JHP770160E2R400.3Z5A-SIRA	02810147	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	Weldon	□
JHP770200E2R050.3Z5A-SIRA	02810148	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	Weldon	■
JHP770200E2R100.3Z5A-SIRA	02810149	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	Weldon	■
JHP770200E2R250.3Z5A-SIRA	02810150	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	Weldon	□
JHP770200E2R310.3Z5A-SIRA	02810151	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	Weldon	■
JHP770200E2R400.3Z5A-SIRA	02810152	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	Weldon	■
JHP770250E2R050.3Z5A-SIRA	02810153	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	Weldon	■
JHP770250E2R100.3Z5A-SIRA	02810154	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	1,0	5	Weldon	■

■ **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





E

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



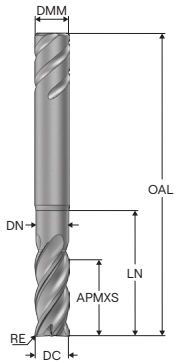
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JHP770060E2R030.9Z4A-SIRA	02927936	2	E	■	6,0	6,0	12,0	60,0	18,0	6,0	0,3	4	Safe-lock	☐
JHP770080E2R040.9Z4A-SIRA	02927937	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,4	4	Safe-lock	☐
JHP770080E2R050.9Z4A-SIRA	02927938	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,5	4	Safe-lock	☐
JHP770100E2R040.9Z4A-SIRA	02927939	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,4	4	Safe-lock	☐
JHP770100E2R050.9Z4A-SIRA	02927940	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,5	4	Safe-lock	☐
JHP770120E2R040.9Z4A-SIRA	02927943	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,4	4	Safe-lock	☐
JHP770120E2R050.9Z4A-SIRA	02927944	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,5	4	Safe-lock	☐
JHP770120E2R100.9Z4A-SIRA	02927946	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	1,0	4	Safe-lock	☐
JHP770120E2R250.9Z4A-SIRA	02927947	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	2,5	4	Safe-lock	☐
JHP770140E2R050.9Z4A-SIRA	02927950	2	E	■	14,0	14,0	28,0	95,0	42,0	13,0	0,5	4	Safe-lock	☐
JHP770160E2R040.9Z4A-SIRA	02927948	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,4	4	Safe-lock	☐
JHP770160E2R050.9Z4A-SIRA	02927978	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	4	Safe-lock	☐
JHP770160E2R080.9Z4A-SIRA	02927951	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,8	4	Safe-lock	☐
JHP770160E2R100.9Z4A-SIRA	02927952	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	4	Safe-lock	☐
JHP770160E2R250.9Z4A-SIRA	02927954	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	4	Safe-lock	☐
JHP770160E2R310.9Z4A-SIRA	02927956	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	4	Safe-lock	☐
JHP770160E2R400.9Z4A-SIRA	02927958	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	4,0	4	Safe-lock	☐
JHP770200E2R050.9Z4A-SIRA	02927960	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	4	Safe-lock	☐
JHP770200E2R100.9Z4A-SIRA	02927962	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	4	Safe-lock	☐
JHP770200E2R250.9Z4A-SIRA	02927964	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	4	Safe-lock	☐
JHP770200E2R310.9Z4A-SIRA	02927966	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	4	Safe-lock	☐
JHP770200E2R400.9Z4A-SIRA	02927968	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	4	Safe-lock	☐

☐ 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





E



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

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					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	Safe-lock	☐
JHP770160E2R100.9Z5A-SIRA	02927953	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	5	Safe-lock	☐
JHP770160E2R250.9Z5A-SIRA	02927955	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	5	Safe-lock	☐
JHP770160E2R310.9Z5A-SIRA	02927957	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	5	Safe-lock	☐
JHP770200E2R050.9Z5A-SIRA	02927961	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	5	Safe-lock	☐
JHP770200E2R100.9Z5A-SIRA	02927963	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	5	Safe-lock	☐
JHP770200E2R250.9Z5A-SIRA	02927965	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	5	Safe-lock	☐
JHP770200E2R310.9Z5A-SIRA	02927967	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	5	Safe-lock	☐
JHP770200E2R400.9Z5A-SIRA	02927969	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	5	Safe-lock	☐
JHP770250E2R050.9Z5A-SIRA	02927971	2	E	■	25,0	25,0	50,0	130,0	65,0	24,0	0,5	5	Safe-lock	☐

☐ 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)*

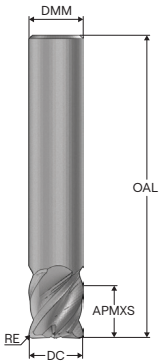
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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





D



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

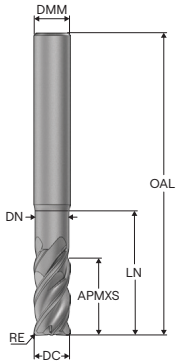
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JHP780060D1R030.0Z4A-M64	03134984	1	D	■	6,0	6,0	7,5	47,0	0,3	4	Cylindrical	■
JHP780060D1R080.0Z4A-M64	03134985	1	D	■	6,0	6,0	7,5	47,0	0,8	4	Cylindrical	■
JHP780080D1R040.0Z4A-M64	03134986	1	D	■	8,0	8,0	10,0	50,0	0,4	4	Cylindrical	■
JHP780080D1R080.0Z4A-M64	03134987	1	D	■	8,0	8,0	10,0	50,0	0,8	4	Cylindrical	■
JHP780100D1R040.0Z4A-M64	03134988	1	D	■	10,0	10,0	12,5	57,0	0,4	4	Cylindrical	■
JHP780100D1R080.0Z4A-M64	03134989	1	D	■	10,0	10,0	12,5	57,0	0,8	4	Cylindrical	■

■ **Prodotto standard.**

JHP780

Alte prestazioni – Superlega – Spallamento – 4-Eliche – Cilindrico – Raggio di punta





E



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

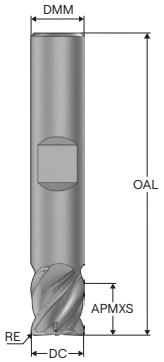
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JHP780060E2R030.0Z4A-M64	03134992	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Cylindrical	■
JHP780060E2R030.0Z4-M64	02760834	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Cylindrical	■
JHP780080E2R040.0Z4A-M64	03134993	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Cylindrical	■
JHP780080E2R040.0Z4-M64	02760842	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Cylindrical	■
JHP780100E2R040.0Z4A-M64	03134994	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Cylindrical	■
JHP780100E2R040.0Z4-M64	02760846	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Cylindrical	■
JHP780100E2R080.0Z4A-M64	03134995	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	Cylindrical	■
JHP780100E2R080.0Z4-M64	02760847	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	Cylindrical	■
JHP780120E2R040.0Z4A-M64	03134996	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Cylindrical	■
JHP780120E2R040.0Z4-M64	02760848	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Cylindrical	■
JHP780120E2R080.0Z4A-M64	03134997	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Cylindrical	■
JHP780120E2R080.0Z4-M64	02760849	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Cylindrical	■
JHP780120E2R150.0Z4-M64	02760850	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	Cylindrical	■
JHP780120E2R250.0Z4-M64	02760851	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Cylindrical	■
JHP780140E2R040.0Z4-M64	02760852	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	Cylindrical	■
JHP780160E2R040.0Z4-M64	02760853	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Cylindrical	■
JHP780160E2R080.0Z4-M64	02760861	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Cylindrical	■
JHP780200E2R040.0Z4-M64	02760865	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	Cylindrical	■
JHP780200E2R400.0Z4-M64	02760868	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	Cylindrical	■
JHP780250E2R080.0Z4-M64	02760870	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	Cylindrical	■

■ **Prodotto standard.**

JHP780

Alte prestazioni – Superlega – Spallamento – 4-Eliche – Weldon – Raggio di punta





D



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

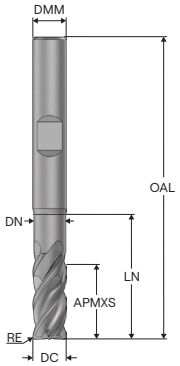
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JHP780060D1R030.3Z4A-M64	03135445	1	D	■	6,0	6,0	7,5	47,0	0,3	4	Weldon	■
JHP780060D1R080.3Z4A-M64	03135446	1	D	■	6,0	6,0	7,5	47,0	0,8	4	Weldon	■
JHP780080D1R040.3Z4A-M64	03135447	1	D	■	8,0	8,0	10,0	50,0	0,4	4	Weldon	■
JHP780080D1R080.3Z4A-M64	03135449	1	D	■	8,0	8,0	10,0	50,0	0,8	4	Weldon	■

■ **Prodotto standard.**

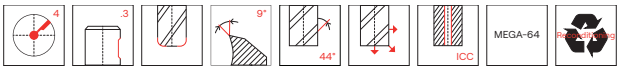
JHP780

Alte prestazioni – Superlega – Spallamento – 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	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					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	Weldon	■
JHP780080E2R040.3Z4-M64	02760879	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Weldon	■
JHP780080E2R040.3Z4A-M64	03135455	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Weldon	■
JHP780100E2R040.3Z4-M64	02760880	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Weldon	■
JHP780100E2R080.3Z4-M64	02760881	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	Weldon	■
JHP780120E2R040.3Z4-M64	02760883	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Weldon	■
JHP780120E2R040.3Z4A-M64	03134998	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Weldon	■
JHP780120E2R080.3Z4-M64	02760885	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Weldon	■
JHP780120E2R080.3Z4A-M64	03134999	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Weldon	■
JHP780120E2R150.3Z4-M64	02760887	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	Weldon	■
JHP780120E2R250.3Z4-M64	02766989	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Weldon	■
JHP780140E2R040.3Z4-M64	02760888	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	Weldon	■
JHP780160E2R040.3Z4-M64	02760889	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Weldon	■
JHP780160E2R080.3Z4-M64	02760890	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Weldon	■
JHP780160E2R400.3Z4-M64	02760893	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	Weldon	■
JHP780200E2R040.3Z4-M64	02760894	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	Weldon	■
JHP780200E2R080.3Z4-M64	02760896	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,8	4	Weldon	■
JHP780200E2R310.3Z4-M64	02760897	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	Weldon	■
JHP780250E2R080.3Z4-M64	02760901	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	Weldon	■

■ **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)*

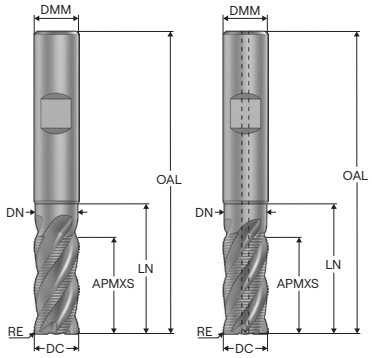
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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





– 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	profilo rompitruciolo	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
							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	Weldon	■
JHP794060E2R020.3Z4A	TAN	10072339	2	E	■	■	6,0	6,0	13,0	57,0	18,5	5,5	0,2	4	Weldon	■
JHP794080E2R020.3Z4	TAN	10072340	2	E	■	–	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	Weldon	■
JHP794080E2R020.3Z4A	TAN	10072341	2	E	■	■	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	Weldon	■
JHP794100E2R035.3Z4	TAN	10072342	2	E	■	–	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	Weldon	■
JHP794100E2R035.3Z4A	TAN	10072343	2	E	■	■	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	Weldon	■
JHP794120E2R035.3Z4	TAN	10072344	2	E	■	–	12,0	12,0	26,0	83,0	35,5	11,4	0,35	4	Weldon	■
JHP794120E2R035.3Z4A	TAN	10072345	2	E	■	■	12,0	12,0	26,0	92,0	35,5	11,4	0,35	4	Weldon	■
JHP794160E2R040.3Z4	TAN	10072346	2	E	■	–	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	Weldon	■
JHP794160E2R040.3Z4A	TAN	10072347	2	E	■	■	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	Weldon	■
JHP794200E2R040.3Z4	TAN	10072348	2	E	■	–	20,0	20,0	38,0	104,0	51,5	19,0	0,4	4	Weldon	■
JHP794250E2R040.3Z4	TAN	10072350	2	E	■	–	25,0	25,0	45,0	121,0	62,5	23,8	0,4	4	Weldon	■

■ **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

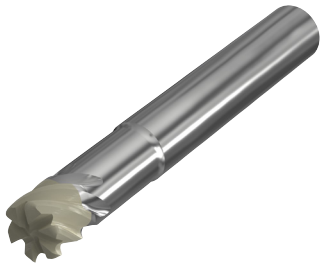
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	75 (50 — 99) *245 (170 — 320)*
M2	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *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)*

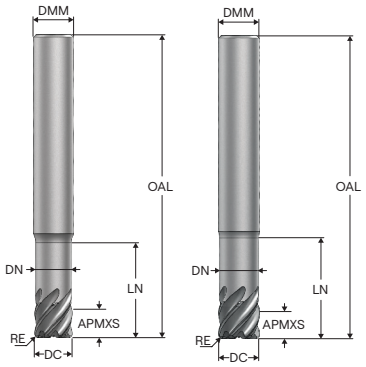
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

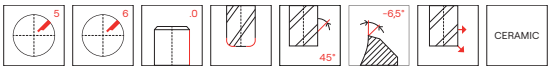
JCG790

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	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JCG790060E2R050.0Z5	10010512	2	E	6,0	6,0	6,0	59,0	15,0	5,7	0,5	5	Cylindrical	■
JCG790080E2R050.0Z5	10010513	2	E	8,0	8,0	6,0	67,0	20,0	7,6	0,5	5	Cylindrical	■
JCG790094G2R100.0Z6	10010514	2	G	9,4	10,0	6,0	75,0	23,5	9,0	1,0	6	Cylindrical	■
JCG790100E2R100.0Z6	10010515	2	E	10,0	10,0	6,0	75,0	25,0	9,5	1,0	6	Cylindrical	■
JCG790114G2R150.0Z6	10010516	2	G	11,4	12,0	6,0	82,0	28,5	10,9	1,5	6	Cylindrical	■
JCG790120E2R150.0Z6	10010517	2	E	12,0	12,0	6,0	82,0	30,0	11,4	1,5	6	Cylindrical	■
JCG790160E2R200.0Z6	10010518	2	E	16,0	16,0	8,0	93,0	40,0	15,2	2,0	6	Cylindrical	■
JCG790200E2R300.0Z6	10010519	2	E	20,0	20,0	8,0	103,0	50,0	19,0	3,0	6	Cylindrical	■
JCG790250E2R400.0Z6	10010520	2	E	25,0	25,0	8,0	108,0	50,0	23,8	4,0	6	Cylindrical	■

■ **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

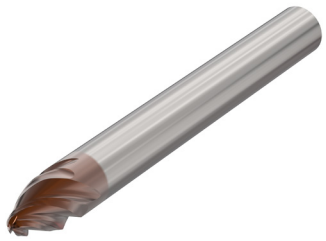
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
S1	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420 — 1300) *2725 (1400 — 4200)*
S2	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	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)*

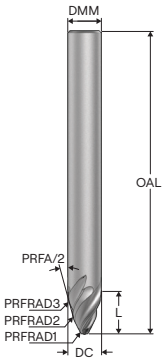
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

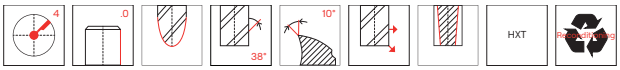
Alta velocità – ISO– M e ISO– S – Forma conica – 4 Eliche – Cilindrico





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 uten-sile	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	FCEDC	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm	mm					
	HXT	10106106	2	T	10,0	10,0	12,3	12,3	89,0	2,0	30,0	5,0	20,0	4	4	Cylindrical	■
	HXT	10106107	2	T	10,0	10,0	12,5	12,5	89,0	2,0	50,0	5,0	20,0	4	4	Cylindrical	■
	HXT	10106108	2	T	10,0	10,0	10,7	10,7	89,0	3,0	100,0	5,0	20,0	4	4	Cylindrical	■
	HXT	10106109	2	T	10,0	10,0	10,8	10,8	89,0	3,0	250,0	5,0	20,0	4	4	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – JH724 Copiatura finitura

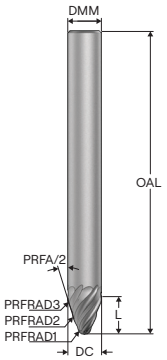
SMG		a_e/DC	f_z	v_c
			10	
P12	E	0,010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310- 460)*
S2	E	0,010 *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

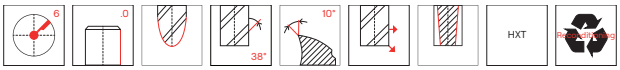
Alta velocità – ISO– M e ISO– S – Forma conica – 6 Eliche – Cilindrico





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 lunghezza	Forma utensile	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm	mm				
JH726100T2R2R030.0Z6	HXT	10106110	2	T	10,0	10,0	10,8	10,8	89,0	2,0	30,0	5,0	20,0	6	Cylindrical	■
JH726100T2R2R050.0Z6	HXT	10106111	2	T	10,0	10,0	10,7	10,7	89,0	2,0	50,0	5,0	20,0	6	Cylindrical	■
JH726100T2R3R100.0Z6	HXT	10106112	2	T	10,0	10,0	12,3	12,3	89,0	3,0	100,0	5,0	20,0	6	Cylindrical	■
JH726100T2R3R250.0Z6	HXT	10106113	2	T	10,0	10,0	12,5	12,5	89,0	3,0	250,0	5,0	20,0	6	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – JH726 Copiatura finitura

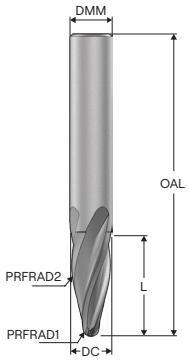
SMG		a_e/DC	f_z	v_c
			10	
P12	E	0,010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310- 460)*
S2	E	0,010 *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

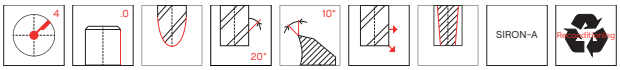
JH734

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	APMXS	OAL	PRFRAD1	PRFRAD2	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JH734060X2R1R95.0Z4	SIRA	10044783	2	X	6,0	6,0	20,8	18,39	62,0	1,0	95,0	4	Cylindrical	■
JH734080X2R1R90.0Z4	SIRA	10044784	2	X	8,0	8,0	24,5	22,05	68,0	1,0	90,0	4	Cylindrical	■
JH734100X2R2R85.0Z4	SIRA	10044785	2	X	10,0	10,0	24,7	22,29	72,0	2,0	85,0	4	Cylindrical	■
JH734120X2R2R80.0Z4	SIRA	10044786	2	X	12,0	12,0	27,3	24,87	83,0	2,0	80,0	4	Cylindrical	■
JH734160X2R3R75.0Z4	SIRA	10044787	2	X	16,0	16,0	30,1	27,61	92,0	3,0	75,0	4	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – JH734 Copiatura finitura

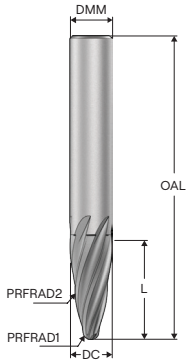
SMG		a_e/DC	f_z					v_c
			6	8	10	12	16	
P8	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	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

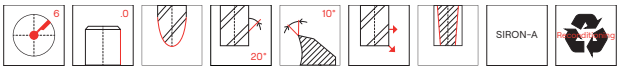
Alta velocità – ISO– M e ISO– S – Forma a goccia – 6 Eliche – Cilindrico





X

—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	APMXS	OAL	PRFRAD1	PRFRAD2	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JH736100X2R2R85.0Z6	SIRA	10044834	2	X	10,0	10,0	24,7	22,29	72,0	2,0	85,0	6	Cylindrical	■
JH736120X2R2R80.0Z6	SIRA	10044835	2	X	12,0	12,0	27,3	24,87	83,0	2,0	80,0	6	Cylindrical	■
JH736160X2R3R75.0Z6	SIRA	10044836	2	X	16,0	16,0	30,1	27,61	92,0	3,0	75,0	6	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – JH736 Copiatura finitura

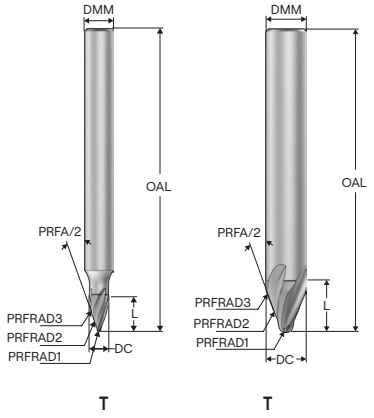
SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *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

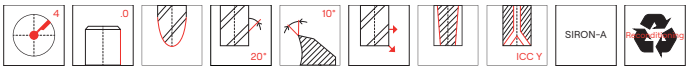
JH744

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	CSP	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Attacco	Prodotto standard
						mm	mm	mm	mm	mm	mm	mm	mm				
	SIRA	10044920	1	T	–	10,0	10,0	5,4	1,62	72,0	1,5	250,0	2,0	65,0	4	Cylindrical	■
	SIRA	10044921	1	T	–	12,0	12,0	10,5	5,33	89,0	3,0	250,0	6,0	32,5	4	Cylindrical	■
	SIRA	10044922	1	T	–	16,0	16,0	14,6	8,95	108,0	4,0	500,0	8,0	27,5	4	Cylindrical	■
	SIRA	10044923	2	T	–	4,0	6,0	7,6	4,7	62,0	0,5	250,0	3,0	17,5	4	Cylindrical	■
	SIRA	10044924	2	T	–	6,0	6,0	9,6	6,71	62,0	1,0	250,0	3,0	17,5	4	Cylindrical	■
	SIRA	10044925	2	T	–	8,0	8,0	10,7	7,42	68,0	1,5	250,0	4,0	20,0	4	Cylindrical	■
	SIRA	10044926	2	T	–	10,0	10,0	12,7	9,04	75,0	2,0	250,0	5,0	20,0	4	Cylindrical	■
	SIRA	10044927	2	T	–	12,0	12,0	13,7	9,71	89,0	3,0	250,0	6,0	20,0	4	Cylindrical	■
	SIRA	10044928	2	T	–	16,0	16,0	17,6	12,94	108,0	4,0	500,0	8,0	20,0	4	Cylindrical	■
	SIRA	10044929	2	T	–	16,0	16,0	31,3	28,27	108,0	2,0	1000,0	5,0	12,5	4	Cylindrical	■
	SIRA	10044930	2	T	–	16,0	16,0	24,1	21,02	108,0	4,0	1000,0	5,0	12,5	4	Cylindrical	■
	SIRA	10044931	4	T	■	16,0	16,0	24,1	21,02	150,0	4,0	1000,0	5,0	12,5	4	Cylindrical	■

Parametri di taglio – JH744 Copiatura finitura

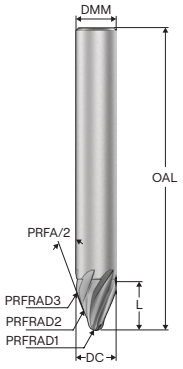
SMG		a_e/DC	f_z						v_c
			4	6	8	10	12	16	
P8	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (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

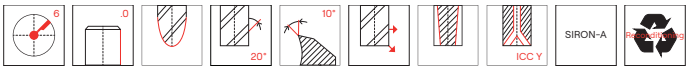
Alta velocità – ISO– M e ISO– S – Forma conica – 6 Eliche – Cilindrico





T

– Tolleranze:
– DMM= h5
– PRFRAD1= ±0.03mm
– Tolleranza di forma PRFRAD2= 0.02mm
– Riaffilatura possibile



Codice di ordinazione	Qualità	Codice prodotto	Indice di lung-hezza	Forma utensile	CSP	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	FCEDC	PCEDC	Attacco	Prodotto standard
						mm	mm	mm	mm	mm	mm	mm	mm					
JH746100T2R2R250.0Z6	SIRA	10044958	2	T	–	10,0	10,0	12,7	9,04	75,0	2,0	250,0	5,0	20,0	6	6	Cylindrical	■
JH746120T2R3R250.0Z6	SIRA	10044959	2	T	–	12,0	12,0	13,7	9,71	89,0	3,0	250,0	6,0	20,0	6	6	Cylindrical	■
JH746160T2R4R500.0Z6	SIRA	10044960	2	T	–	16,0	16,0	17,6	12,94	108,0	4,0	500,0	8,0	20,0	6	6	Cylindrical	■
	SIRA	10044961	4	T	■	16,0	16,0	17,6	12,94	150,0	4,0	500,0	8,0	20,0	6	6	Cylindrical	■

■ **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

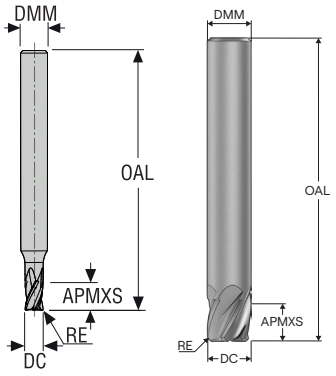
SMG		a_e/DC	f_z			v_c
			10	12	16	
P12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 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

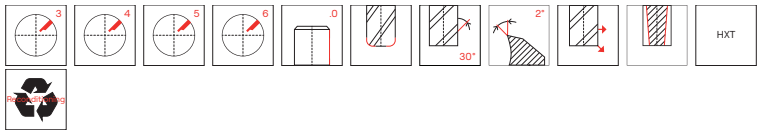
JH770

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	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JH770030F2R020.0Z3-HXT	03320783	2	F	3,0	6,0	5,0	58,0	0,2	3	Cylindrical	■
JH770040F2R020.0Z4-HXT	03320784	2	F	4,0	6,0	6,0	58,0	0,2	4	Cylindrical	■
JH770050F2R020.0Z4-HXT	10000170	2	F	5,0	6,0	7,0	58,0	0,2	4	Cylindrical	■
JH770060D2R050.0Z4-HXT	03127351	2	D	6,0	6,0	8,0	50,0	0,5	4	Cylindrical	■
JH770080D2R050.0Z4-HXT	03127352	2	D	8,0	8,0	10,0	58,0	0,5	4	Cylindrical	■
JH770080D2R050.0Z5-HXT	03127354	2	D	8,0	8,0	10,0	58,0	0,5	5	Cylindrical	■
JH770080D2R100.0Z5-HXT	03127355	2	D	8,0	8,0	10,0	58,0	1,0	5	Cylindrical	■
JH770080D2R100.0Z6-HXT	03127356	2	D	8,0	8,0	10,0	58,0	1,0	6	Cylindrical	■
JH770100D2R100.0Z5-HXT	03127357	2	D	10,0	10,0	12,0	66,0	1,0	5	Cylindrical	■
JH770100D2R100.0Z6-HXT	03127358	2	D	10,0	10,0	12,0	66,0	1,0	6	Cylindrical	■

■ **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

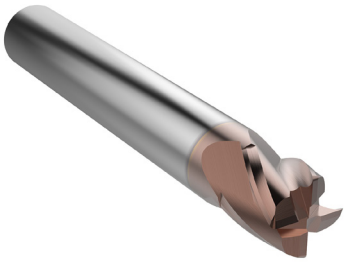
SMG		a_e/DC	a_p/DC	f_z		v_c
				8	10	
S2	E	0.750 *0,750*	0.12 *0,12*	0.050 *0,0020*	0.060 *0,0024*	55 (43 — 64) *180 (150 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	65 (54 — 93) *215 (180 — 300)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	50 (42 — 71) *165 (140 — 230)*

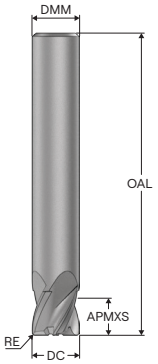
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

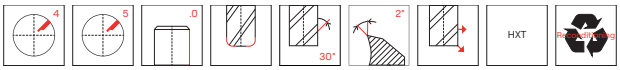
Alta velocità – CrCo/Titanio – Finitrice torica – 4-5 Eliche – Cilindrico – Raggio di punta





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	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JH740060D2R025.0Z4-HXT	03127359	2	D	6,0	6,0	6,0	50,0	0,25	4	Cylindrical	■
JH740060D2R050.0Z4-HXT	03127360	2	D	6,0	6,0	6,0	50,0	0,5	4	Cylindrical	■
JH740080D2R025.0Z4-HXT	03127361	2	D	8,0	8,0	8,0	58,0	0,25	4	Cylindrical	■
JH740080D2R050.0Z4-HXT	03127362	2	D	8,0	8,0	8,0	58,0	0,5	4	Cylindrical	■
JH740100D2R025.0Z5-HXT	03127363	2	D	10,0	10,0	10,0	66,0	0,25	5	Cylindrical	■
JH740100D2R050.0Z5-HXT	03127364	2	D	10,0	10,0	10,0	66,0	0,5	5	Cylindrical	■

■ **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)*

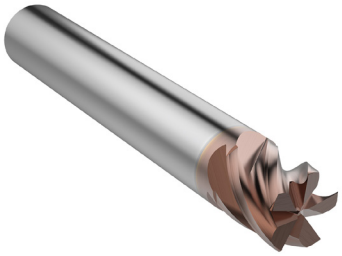
Parametri di taglio – JH740 Finitura frontale PCEDC 5

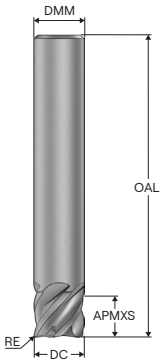
SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130 — 190)*
S11	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	65 (51 — 75) *215 (170 — 240)*
S12	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130 — 190)*

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

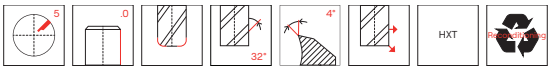
Alta velocità – CrCo/Titanio – Spallamento – 5 Eliche – Cilindrico – Raggio di punta





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	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JH710060D2R025.0Z5-HXT	03127365	2	D	6,0	6,0	6,0	57,0	0,25	5	Cylindrical	■
JH710060D2R050.0Z5-HXT	03127366	2	D	6,0	6,0	6,0	57,0	0,5	5	Cylindrical	■
JH710080D2R025.0Z5-HXT	03127367	2	D	8,0	8,0	8,0	63,0	0,25	5	Cylindrical	■
JH710080D2R050.0Z5-HXT	03127368	2	D	8,0	8,0	8,0	63,0	0,5	5	Cylindrical	■
JH710080D2R100.0Z5-HXT	03127369	2	D	8,0	8,0	8,0	63,0	1,0	5	Cylindrical	■

■ **Prodotto standard.**

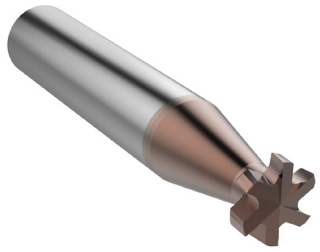
Parametri di taglio – JH710 Contornatura finitura

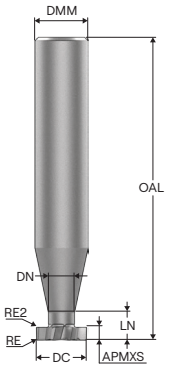
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S1	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S2	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S3	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (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

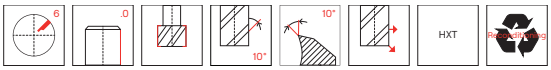
Alta velocità – CrCo/Titanio – Fresa a T – 6 Eliche – Cilindrico





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	DN	RE	RE2	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm	mm				
JH790095G2R025.0Z6-HXT	03127370	2	G	9,5	10,0	2,0	66,0	5,0	5,0	0,25	0,25	0,94	6	Cylindrical	■
JH790095G2R050.0Z6-HXT	03127371	2	G	9,5	10,0	2,0	66,0	5,0	5,0	0,5	0,5	0,96	6	Cylindrical	■
JH790095G3R025.0Z6-HXT	03127372	3	G	9,5	10,0	2,54	66,0	5,0	5,0	0,25	0,25	0,94	6	Cylindrical	■
JH790095G3R050.0Z6-HXT	03127373	3	G	9,5	10,0	2,54	66,0	5,0	5,0	0,5	0,5	0,96	6	Cylindrical	■

■ **Prodotto standard.**

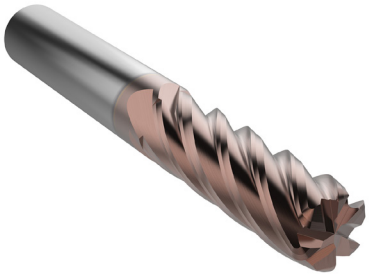
Parametri di taglio – JH790 (T) Contornatura sgrossatura

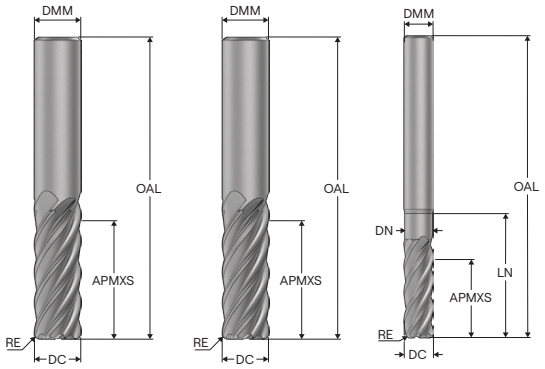
SMG		a_e/DC	a_p/DC	f_z	v_c
				9.5	
S2	E	0.189 *0,189*	0.19 *0,19*	0.030 *0,0012*	39 (31 — 50) *130 (110 — 160)*
S11	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	85 (66 — 100) *280 (220 — 320)*
S12	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	65 (51 — 80) *215 (170 — 260)*

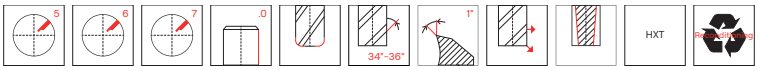
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JH730060E2R050.0Z5-HXT	10217826	2	E	6,0	6,0	19,0	65,0	25,0	5,7	0,5	5	Cylindrical	■
JH730060E2R100.0Z5-HXT	10217827	2	E	6,0	6,0	19,0	65,0	25,0	5,7	1,0	5	Cylindrical	■
JH730060E2R150.0Z5-HXT	10217828	2	E	6,0	6,0	19,0	65,0	25,0	5,7	1,5	5	Cylindrical	■
JH730075F2R050.0Z6-HXT	10217829	2	F	7,5	8,0	24,0	63,0	–	–	0,5	6	Cylindrical	■
JH730075F2R100.0Z6-HXT	10217830	2	F	7,5	8,0	24,0	63,0	–	–	1,0	6	Cylindrical	■
JH730075F2R150.0Z6-HXT	10217831	2	F	7,5	8,0	24,0	63,0	–	–	1,5	6	Cylindrical	■
JH730080D2R050.0Z6-HXT	03127375	2	D	8,0	8,0	25,0	63,0	–	–	0,5	6	Cylindrical	■
JH730080D2R100.0Z6-HXT	03127377	2	D	8,0	8,0	25,0	63,0	–	–	1,0	6	Cylindrical	■
JH730080D2R150.0Z6-HXT	03127378	2	D	8,0	8,0	25,0	63,0	–	–	1,5	6	Cylindrical	■
JH730080D2R200.0Z6-HXT	03127379	2	D	8,0	8,0	25,0	63,0	–	–	2,0	6	Cylindrical	■
JH730100D2R100.0Z7-HXT	03127380	2	D	10,0	10,0	31,0	72,0	–	–	1,0	7	Cylindrical	■
JH730100D2R250.0Z7-HXT	03127381	2	D	10,0	10,0	31,0	72,0	–	–	2,5	7	Cylindrical	■

■ **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)*

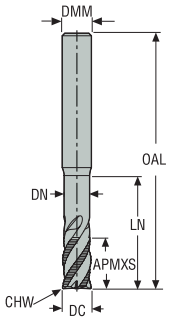
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					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	Cylindrical	■
JHP994080E3C.0Z4-HXT	03127383	3	E	■	8,0	8,0	18,0	69,0	32,0	7,4	0,2	4	Cylindrical	■
JHP994100E3C.0Z4-HXT	03127384	3	E	■	10,0	10,0	22,0	88,0	40,0	9,4	0,2	4	Cylindrical	■

■ **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)*

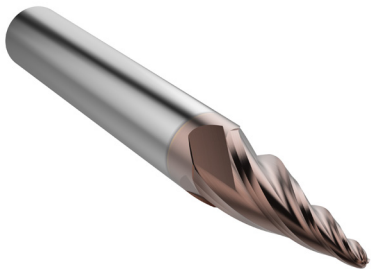
Parametri di taglio – JHP994 Scanalatura

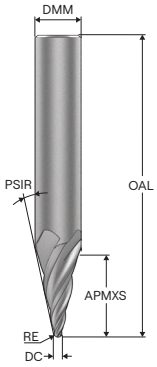
SMG		a_p/DC	f_z			v_c
			6	8	10	
S2	E	2.0 *2,0*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	33 (24 — 41) *110 (79 — 130)*
S11	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	42 (32 — 63) *140 (110 — 200)*
S12	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	33 (25 — 48) *110 (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

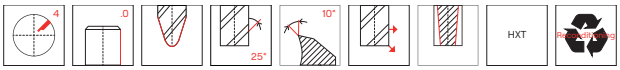
Alta velocità – CrCo/Titanio – Frese sferico-coniche – 4 Eliche – Cilindrico





N

—Tolleranze:
—DMM=h5
—DC= ±0,04 mm
—RE= ±0,01 mm
—Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	RE	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm				
JH780018N2R100.0Z4-HXT	03127386	2	N	8,0	1,827	8,0	23,5	63,0	1,0	5,1838	4	Cylindrical	■
JH780028N2R150.0Z4-HXT	03127387	2	N	8,0	2,803	8,0	23,5	63,0	1,5	3,8915	4	Cylindrical	■
JH780038N2R200.0Z4-HXT	03127388	2	N	8,0	3,823	8,0	23,5	63,0	2,0	2,5972	4	Cylindrical	■
JH780049N2R250.0Z4-HXT	03127389	2	N	8,0	4,888	8,0	23,5	63,0	2,5	1,3003	4	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – JH780 Contornatura

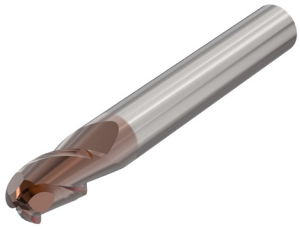
SMG		a_e/DC	a_p/DC	f_z				v_c
				1.8	2.8	3.8	4.9	
S2	E	0.0510 *0,0510*	4.2 *4,2*	0.0080 *0,00032*	0.012 *0,00048*	0.017 *0,00065*	0.022 *0,00085*	70 (54 — 86) *230 (180 — 280)*
S12	E	0.0510 *0,0510*	4.2 *4,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.013 *0,00050*	0.016 *0,00065*	95 (76 — 110) *310 (250 — 360)*

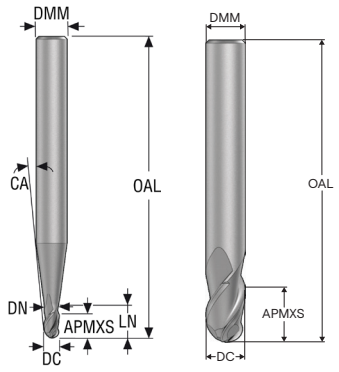
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

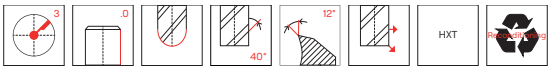
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

JHB720

Alta velocità – Titanio – A testa sferica – 3 Eliche – Cilindrico







—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	RE	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm				
JHB720020G2B.0Z3	HXT	10072323	2	G	2,0	6,0	3,0	60,0	6,0	1,9	1,0	7,0	3	Cylindrical	■
JHB720030G2B.0Z3	HXT	10072324	2	G	3,0	6,0	4,5	60,0	6,5	2,8	1,5	5,0	3	Cylindrical	■
JHB720035G2B.0Z3	HXT	10072325	2	G	3,5	6,0	5,0	65,0	7,0	3,2	1,75	3,5	3	Cylindrical	■
JHB720040G2B.0Z3	HXT	10072326	2	G	4,0	6,0	6,0	65,0	8,0	3,7	2,0	3,0	3	Cylindrical	■
JHB720060D2B.0Z3	HXT	10072327	2	D	6,0	6,0	9,0	75,0	–	–	3,0	–	3	Cylindrical	■
JHB720080D2B.0Z3	HXT	10072328	2	D	8,0	8,0	12,0	75,0	–	–	4,0	–	3	Cylindrical	■
JHB720100D2B.0Z3	HXT	10072329	2	D	10,0	10,0	15,0	80,0	–	–	5,0	–	3	Cylindrical	■
JHB720120D2B.0Z3	HXT	10072330	2	D	12,0	12,0	18,0	90,0	–	–	6,0	–	3	Cylindrical	■
JHB720160D2B.0Z3	HXT	10072331	2	D	16,0	16,0	24,0	100,0	–	–	8,0	–	3	Cylindrical	■

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

Parametri di taglio – JHB720 Contornatura

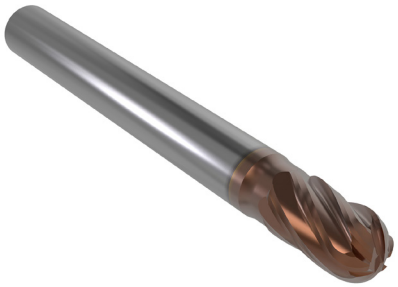
SMG		a_e/DC	a_p/DC	f_z									v_c
				2	3	3.5	4	6	8	10	12	16	
M1	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	85 (62 — 110) *280 (210 — 360)*
M2	E	0.200 *0,200*	1.2 *1,2*	0.0080 *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)*

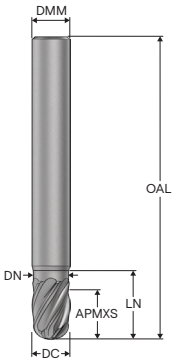
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

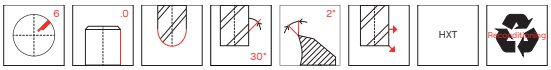
Alta velocità – CrCo/Titanio – A testa sferica – 6 Eliche – Cilindrico





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	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JH721060E2B.0Z6-HXT	03127390	2	E	6,0	6,0	10,0	57,0	12,0	5,6	2,987	6	Cylindrical	■
JH721080E2B.0Z6-HXT	03127391	2	E	8,0	8,0	13,0	58,0	16,0	7,4	3,98375	6	Cylindrical	■

■ **Prodotto standard.**

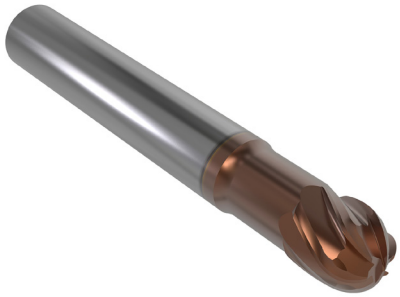
Parametri di taglio – JH721 Copiatura finitura

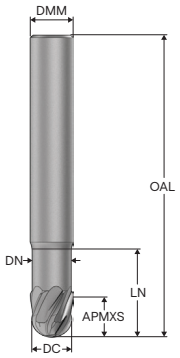
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	120 (110 — 140) *395 (370 — 450)*
S11	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	210 (140 — 230) *690 (460 — 750)*
S12	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	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

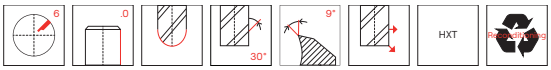
Alta velocità – CrCo/Titanio – A testa sferica – 6 Eliche – Cilindrico





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	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
JH722100E2B.0Z6-HXT	03127392	2	E	10,0	10,0	10,0	72,0	20,0	9,4	4,98375	6	Cylindrical	■

■ **Prodotto standard.**

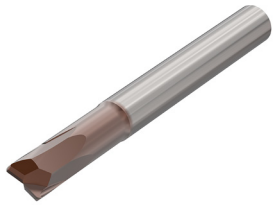
Parametri di taglio – JH722 Copiatura finitura

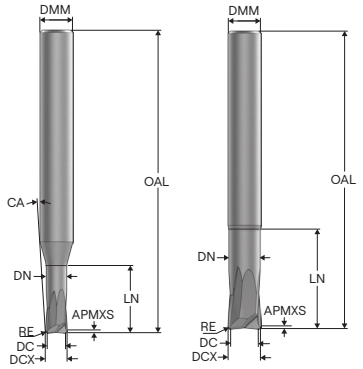
SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.0500 *0,0500*	0.15 *0,15*	0.065 *0,0026*	125 (110 — 150) *410 (370 — 490)*
S11	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	210 (190 — 230) *690 (630 — 750)*
S12	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	160 (150 — 180) *520 (500 — 590)*

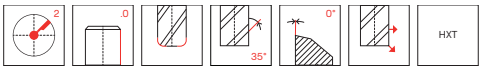
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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 lung-hezza	Forma utensile	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PSIR°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm	mm					
SHF712040G2R050.0Z2	HXT	10106493	2	G	4,0	3,0	6,0	0,5	55,0	12,0	3,8	0,5	3,9	1,5	2	Cylindrical	■
SHF712060E2R050.0Z2	HXT	10106494	2	E	6,0	5,0	6,0	0,5	55,0	18,0	5,7	0,5	–	1,5	2	Cylindrical	■
SHF712030G3R050.0Z2	HXT	10106495	3	G	3,0	2,0	6,0	0,5	55,0	12,0	2,85	0,5	5,65	1,5	2	Cylindrical	■
SHF712040G3R050.0Z2	HXT	10106496	3	G	4,0	3,0	6,0	0,5	55,0	16,0	3,8	0,5	3,07	1,5	2	Cylindrical	■
SHF712060E3R050.0Z2	HXT	10106497	3	E	6,0	5,0	6,0	0,5	55,0	25,0	5,7	0,5	–	1,5	2	Cylindrical	■
SHF712030G4R050.0Z2	HXT	10106498	4	G	3,0	2,0	6,0	0,5	55,0	16,0	2,85	0,5	4,47	1,5	2	Cylindrical	■

■ **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)*

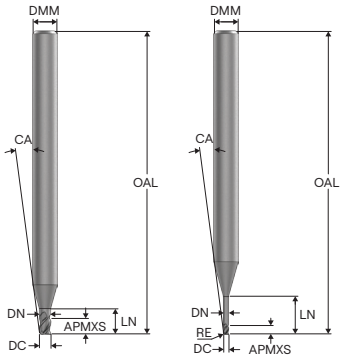
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

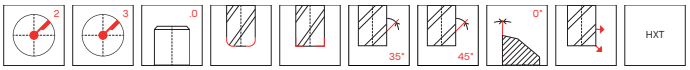
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm				
SME714020G1S.0Z3	HXT	10107349	1	G	2,0	4,0	2,0	50,0	4,0	1,9	–	6,86	3	Cylindrical	■
SME716020G1S.0Z3	HXT	10107360	1	G	2,0	6,0	2,0	50,0	4,0	1,9	–	9,42	3	Cylindrical	■
SME714020G3R010.0Z3	HXT	10107350	3	G	2,0	4,0	2,5	50,0	8,0	1,9	0,1	4,68	3	Cylindrical	■
SME716020G3R010.0Z3	HXT	10107361	3	G	2,0	6,0	2,5	50,0	8,0	1,9	0,1	7,14	3	Cylindrical	■
SME716010G4R010.0Z3	HXT	10107362	4	G	1,0	6,0	1,2	50,0	6,0	0,95	0,1	9,03	3	Cylindrical	■
SME716015G4R010.0Z3	HXT	10107363	4	G	1,5	6,0	1,8	50,0	10,0	1,4	0,1	6,79	3	Cylindrical	■
SME714010G4R010.0Z3	HXT	10107351	4	G	2,0	4,0	1,2	50,0	6,0	0,95	0,1	7,13	3	Cylindrical	■
SME714015G4R010.0Z3	HXT	10107352	4	G	2,0	4,0	1,8	50,0	10,0	1,4	0,1	4,72	3	Cylindrical	■
SME714020G4R010.0Z3	HXT	10107353	4	G	2,0	4,0	2,5	50,0	12,0	1,9	0,1	3,53	3	Cylindrical	■
SME716020G4R010.0Z3	HXT	10107364	4	G	2,0	6,0	2,5	50,0	12,0	1,9	0,1	5,72	3	Cylindrical	■
SME714015G5R010.0Z3	HXT	10107354	5	G	1,5	4,0	1,8	50,0	12,0	1,4	0,1	3,38	3	Cylindrical	■
SME716015G5R010.0Z3	HXT	10107365	5	G	1,5	6,0	1,8	50,0	12,0	1,4	0,1	6,15	3	Cylindrical	■
SME714020G5R010.0Z3	HXT	10107355	5	G	2,0	4,0	2,5	50,0	16,0	1,9	0,1	2,83	3	Cylindrical	■
SME716020G5R010.0Z3	HXT	10107366	5	G	2,0	6,0	2,5	50,0	16,0	1,9	0,1	4,77	3	Cylindrical	■
SME714005G6R005.0Z2	HXT	10107356	6	G	0,5	4,0	0,6	50,0	5,0	0,45	0,05	8,31	2	Cylindrical	■
SME716005G6R005.0Z2	HXT	10107367	6	G	0,5	6,0	0,6	50,0	5,0	0,45	0,05	9,93	2	Cylindrical	■
SME714010G6R010.0Z3	HXT	10107357	6	G	1,0	4,0	1,2	50,0	12,0	0,95	0,1	4,77	3	Cylindrical	■
SME716010G6R010.0Z3	HXT	10107368	6	G	1,0	6,0	1,6	50,0	12,0	0,95	0,1	6,56	3	Cylindrical	■
SME714015G6R010.0Z3	HXT	10107358	6	G	1,5	4,0	1,8	50,0	16,0	1,4	0,1	3,38	3	Cylindrical	■
SME716015G6R010.0Z3	HXT	10107369	6	G	1,5	6,0	1,8	50,0	16,0	1,4	0,1	5,16	3	Cylindrical	■
SME714010G7R010.0Z3	HXT	10107359	7	G	1,0	4,0	1,2	50,0	16,0	0,95	0,1	3,9	3	Cylindrical	■
SME716010G7R010.0Z3	HXT	10107370	7	G	1,0	6,0	1,2	50,0	16,0	0,95	0,1	5,55	3	Cylindrical	■

■ **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 699 - 707

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)*

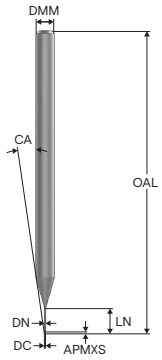
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

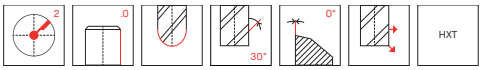
Miniaturizzato – ISO– S – A testa sferica – 2 Eliche – Cilindrico





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	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm				
SMB714020G2B.0Z2	HXT	10109582	2	G	2,0	4,0	2,0	50,0	6,0	1,9	1,0	6,13	2	Cylindrical	■
SMB716020G2B.0Z2	HXT	10109596	2	G	2,0	6,0	2,0	50,0	6,0	1,9	1,0	8,72	2	Cylindrical	■
SMB714030G2B.0Z2	HXT	10109583	2	G	3,0	4,0	3,0	50,0	9,0	2,85	1,5	2,85	2	Cylindrical	■
SMB716030G2B.0Z2	HXT	10109597	2	G	3,0	6,0	3,0	50,0	9,0	2,85	1,5	6,22	2	Cylindrical	■
SMB714030G3B.0Z2	HXT	10109584	3	G	3,0	4,0	3,0	50,0	12,0	2,85	1,5	2,2	2	Cylindrical	■
SMB716030G3B.0Z2	HXT	10109598	3	G	3,0	6,0	3,0	50,0	12,0	2,85	1,5	5,11	2	Cylindrical	■
SMB714015G4B.0Z2	HXT	10109585	4	G	1,5	4,0	1,5	50,0	9,0	1,4	0,75	5,29	2	Cylindrical	■
SMB716015G4B.0Z2	HXT	10109599	4	G	1,5	6,0	1,5	50,0	9,0	1,4	0,75	7,44	2	Cylindrical	■
SMB714020G4B.0Z2	HXT	10109586	4	G	2,0	4,0	2,0	50,0	10,0	1,9	1,0	4,3	2	Cylindrical	■
SMB716020G4B.0Z2	HXT	10109600	4	G	2,0	6,0	2,0	50,0	10,0	1,9	1,0	6,69	2	Cylindrical	■
SMB714005G5B.0Z2	HXT	10109587	5	G	0,5	4,0	0,5	50,0	4,0	0,45	0,25	9,23	2	Cylindrical	■
SMB716005G5B.0Z2	HXT	10109601	5	G	0,5	6,0	0,5	50,0	4,0	0,45	0,25	10,73	2	Cylindrical	■
SMB714010G5B.0Z2	HXT	10109588	5	G	1,0	4,0	1,0	50,0	10,0	0,95	0,5	5,5	2	Cylindrical	■
SMB716010G5B.0Z2	HXT	10109602	5	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	7,37	2	Cylindrical	■
SMB714015G5B.0Z2	HXT	10109589	5	G	1,5	4,0	1,5	50,0	12,0	1,4	0,75	4,41	2	Cylindrical	■
SMB716015G5B.0Z2	HXT	10109603	5	G	1,5	6,0	1,5	50,0	12,0	1,4	0,75	6,35	2	Cylindrical	■
SMB714020G5B.0Z2	HXT	10109590	5	G	2,0	4,0	2,0	50,0	16,0	1,9	1,0	2,96	2	Cylindrical	■
SMB716020G5B.0Z2	HXT	10109604	5	G	2,0	6,0	2,0	50,0	16,0	1,9	1,0	4,96	2	Cylindrical	■
SMB713003G6B.0Z2	HXT	10109581	6	G	0,3	3,0	0,3	50,0	4,0	0,28	0,15	8,24	2	Cylindrical	■
SMB714005G6B.0Z2	HXT	10109591	6	G	0,5	4,0	0,5	50,0	6,0	0,45	0,25	7,8	2	Cylindrical	■
SMB716005G6B.0Z2	HXT	10109605	6	G	0,5	6,0	0,5	50,0	6,0	0,45	0,25	9,46	2	Cylindrical	■
SMB714010G6B.0Z2	HXT	10109592	6	G	1,0	4,0	1,0	50,0	12,0	0,95	0,5	4,97	2	Cylindrical	■
SMB716010G6B.0Z2	HXT	10109606	6	G	1,0	6,0	1,0	50,0	12,0	0,95	0,5	6,69	2	Cylindrical	■
SMB714015G6B.0Z2	HXT	10109593	6	G	1,5	4,0	1,5	50,0	16,0	1,4	0,75	3,49	2	Cylindrical	■
SMB716015G6B.0Z2	HXT	10109607	6	G	1,5	6,0	1,5	55,0	16,0	1,4	0,75	5,31	2	Cylindrical	■
SMB714005G7B.0Z2	HXT	10109594	7	G	0,5	4,0	0,5	50,0	9,0	0,45	0,25	6,33	2	Cylindrical	■
SMB716005G7B.0Z2	HXT	10109608	7	G	0,5	6,0	0,5	50,0	9,0	0,45	0,25	8,03	2	Cylindrical	■
SMB714010G7B.0Z2	HXT	10109595	7	G	1,0	4,0	1,0	50,0	16,0	0,95	0,5	3,98	2	Cylindrical	■
SMB716010G7B.0Z2	HXT	10109609	7	G	1,0	6,0	1,0	55,0	16,0	0,95	0,5	5,64	2	Cylindrical	■

■ **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 699 - 707

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, S4521, S4531, S4651, JHP490, HP4931, S4931, JH40, JH421, JM403, JM404, JM406, JH410 e JH440 per tipo con raggio.
- S4321, JH450, JH460, SMB413, SMB414, SMB416, JM413 e JM416 per tipo a testa sferica.

Selezione utensile non ferrosi

						
Nome		JS412	JS413	S4521	S4531	S4651
Pag.		443	446	449	454	463
Famiglia		SOLID²	SOLID²	SOLID²	SOLID²	SOLID²
Tipo di fresa						
Attacco	Cilindrico	■	■	■	■	■
	Weldon	■	■	□	□	□
	Safelock					
Numero di eliche		2	3	2	3	5
CSP						■
	Metrico	2-20	2-20	2-20	2-20	6-20
	Pollici					
Lunghezze disponibili		2	2,3	2,3	2,3	2,4
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		HP4931	S4931	JH40	JH421	JH410	JH440
Pag.		466	470	474	477	481	483
Famiglia		HPM	Solid²	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Tipo di fresa							
Attacco	Cilindrico	■	■	■	■	■	■
	Weldon						
	Safelock						
Numero di eliche		3	3	2	2-3	1	2
CSP		■	■		■		
	Metrico			2-20	2-25	2-17	6-8
	Pollici	1/4-1/2	1/4-1/2				
Lunghezze disponibili		2,3,4	3,4,5	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

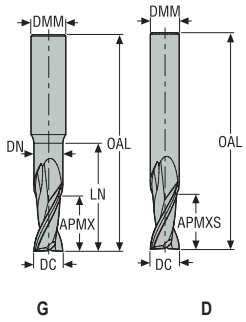
							
Nome		S4321	JH450	JH460	SMB413/414/416	JM403/404/406	JM413/416
Pag.		485	488	490	496	494	496
Famiglia		SOLID²	HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Tipo di fresa							
Attacco	Cilindrico	■	■	■	■	■	■
	Weldon	□					
	Safelock						
Numero di eliche		2	2	2	2	1	2
CSP							
	Metrico	2-20	2-20	3-12	1-3	0,5-2	0,5-2
	Pollici						
Lunghezze disponibili		2	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

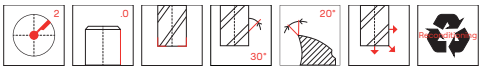
JS412

Uso generico – Alluminio – Spallamento – 2 Eliche – Cilindrico – Spigolo vivo





—Tolleranze:
—DMM= h5
—DC= e8
—Riaffilatura possibile se DC è ≥Ø6



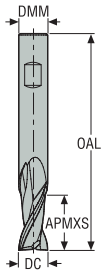
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm			
JS412020G2SZ2.0	02881760	2	G	2,0	6,0	4,0	57,0	7,0	1,9	2	Cylindrical	■
JS412030G2SZ2.0	02881761	2	G	3,0	6,0	6,0	57,0	10,0	2,8	2	Cylindrical	■
JS412040G2SZ2.0	02881762	2	G	4,0	6,0	8,0	57,0	14,0	3,8	2	Cylindrical	■
JS412050G2SZ2.0	02881763	2	G	5,0	6,0	10,0	57,0	17,0	4,7	2	Cylindrical	■
JS412060D2SZ2.0	02881764	2	D	6,0	6,0	12,0	57,0	–	–	2	Cylindrical	■
JS412080D2SZ2.0	02881765	2	D	8,0	8,0	16,0	63,0	–	–	2	Cylindrical	■
JS412100D2SZ2.0	02881766	2	D	10,0	10,0	20,0	75,0	–	–	2	Cylindrical	■
JS412120D2SZ2.0	02881767	2	D	12,0	12,0	24,0	88,0	–	–	2	Cylindrical	■
JS412160D2SZ2.0	02881769	2	D	16,0	16,0	32,0	100,0	–	–	2	Cylindrical	■
JS412200D2SZ2.0	02881770	2	D	20,0	20,0	40,0	124,0	–	–	2	Cylindrical	■

■ **Prodotto standard.**

JS412

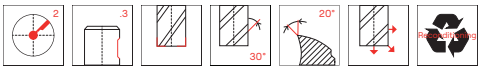
Uso generico – Alluminio – Spallamento – 2 Eliche – Weldon – Spigolo vivo





D

—Tolleranze:
—DMM= h5
—DC= e8
—Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm			
JS412060D2SZ2.3	02881771	2	D	6,0	6,0	12,0	57,0	2	Weldon	■
JS412080D2SZ2.3	02881772	2	D	8,0	8,0	16,0	63,0	2	Weldon	■
JS412100D2SZ2.3	02881773	2	D	10,0	10,0	20,0	75,0	2	Weldon	■
JS412120D2SZ2.3	02881774	2	D	12,0	12,0	24,0	88,0	2	Weldon	■
JS412160D2SZ2.3	02881776	2	D	16,0	16,0	32,0	100,0	2	Weldon	■
JS412200D2SZ2.3	02881777	2	D	20,0	20,0	40,0	124,0	2	Weldon	■

■ **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)*

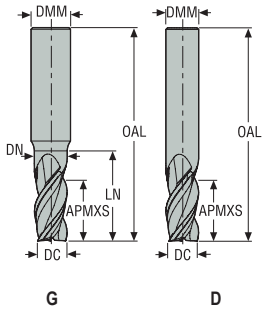
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

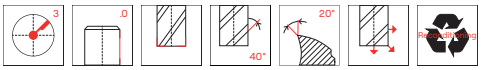
JS413

Uso generico – Alluminio – Spallamento – 3 Eliche – Cilindrico – Spigolo vivo





– Tolleranze:
– DMM= h5
– DC= e8
– Riaffilatura possibile se DC è ≥Ø6



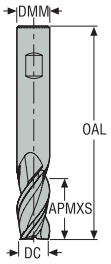
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm			
JS413020G2SZ3.0	02881797	2	G	2,0	6,0	4,0	57,0	7,0	1,9	3	Cylindrical	■
JS413030G2SZ3.0	02881798	2	G	3,0	6,0	6,0	57,0	10,0	2,8	3	Cylindrical	■
JS413040G2SZ3.0	02881799	2	G	4,0	6,0	8,0	57,0	14,0	3,8	3	Cylindrical	■
JS413050G2SZ3.0	02881800	2	G	5,0	6,0	10,0	57,0	17,0	4,7	3	Cylindrical	■
JS413060D2SZ3.0	02881801	2	D	6,0	6,0	12,0	57,0	–	–	3	Cylindrical	■
JS413080D2SZ3.0	02881802	2	D	8,0	8,0	16,0	63,0	–	–	3	Cylindrical	■
JS413100D2SZ3.0	02881803	2	D	10,0	10,0	20,0	72,0	–	–	3	Cylindrical	■
JS413120D2SZ3.0	02881804	2	D	12,0	12,0	24,0	88,0	–	–	3	Cylindrical	■
JS413160D2SZ3.0	02881806	2	D	16,0	16,0	32,0	100,0	–	–	3	Cylindrical	■
JS413200D2SZ3.0	02881807	2	D	20,0	20,0	40,0	124,0	–	–	3	Cylindrical	■
JS413060D3SZ3.0	02881815	3	D	6,0	6,0	24,0	70,0	–	–	3	Cylindrical	■
JS413080D3SZ3.0	02881816	3	D	8,0	8,0	32,0	85,0	–	–	3	Cylindrical	■
JS413100D3SZ3.0	02881817	3	D	10,0	10,0	40,0	100,0	–	–	3	Cylindrical	■
JS413120D3SZ3.0	02881818	3	D	12,0	12,0	50,0	115,0	–	–	3	Cylindrical	■
JS413160D3SZ3.0	02881820	3	D	16,0	16,0	55,0	125,0	–	–	3	Cylindrical	■
JS413200D3SZ3.0	02881821	3	D	20,0	20,0	75,0	150,0	–	–	3	Cylindrical	■

■ **Prodotto standard.**

JS413

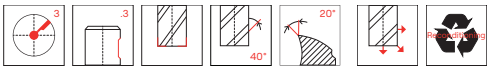
Uso generico – Alluminio – Spallamento – 3 Eliche – Weldon – Spigolo vivo





D

—Tolleranze:
—DMM= h5
—DC= e8
—Riaffilatura possibile



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm			
JS413060D2SZ3.3	02881808	2	D	6,0	6,0	12,0	57,0	3	Weldon	■
JS413080D2SZ3.3	02881809	2	D	8,0	8,0	16,0	63,0	3	Weldon	■
JS413100D2SZ3.3	02881810	2	D	10,0	10,0	20,0	72,0	3	Weldon	■
JS413120D2SZ3.3	02881811	2	D	12,0	12,0	24,0	88,0	3	Weldon	■
JS413160D2SZ3.3	02881813	2	D	16,0	16,0	32,0	100,0	3	Weldon	■
JS413200D2SZ3.3	02881814	2	D	20,0	20,0	40,0	124,0	3	Weldon	■
JS413060D3SZ3.3	02881955	3	D	6,0	6,0	24,0	70,0	3	Weldon	□
JS413080D3SZ3.3	02881956	3	D	8,0	8,0	32,0	85,0	3	Weldon	□
JS413100D3SZ3.3	02881957	3	D	10,0	10,0	40,0	100,0	3	Weldon	□
JS413120D3SZ3.3	02881958	3	D	12,0	12,0	50,0	115,0	3	Weldon	□
JS413160D3SZ3.3	02881960	3	D	16,0	16,0	55,0	125,0	3	Weldon	■
JS413200D3SZ3.3	02881961	3	D	20,0	20,0	75,0	150,0	3	Weldon	■

. □ 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

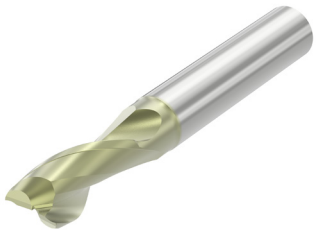
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (400 — 600) *1650 (1400 — 1900)*
N2	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	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)*

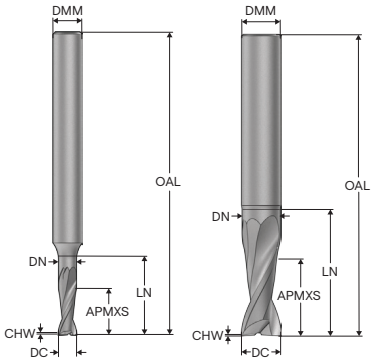
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

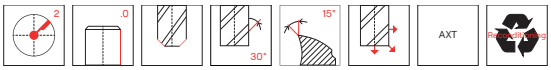
S4521

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Smusso





—Tolleranze:
—DMM=h5
—DC= e7
—CHW= +0,04 mm
—Riaffilatura possibile se DC è ≥Ø6

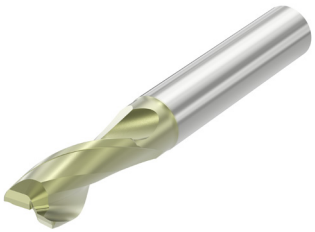


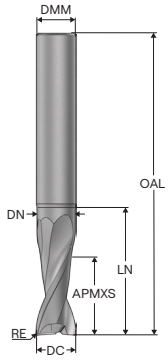
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4521-020G2C.0Z2	AXT	10228022	2	G	2,0	6,0	4,0	57,0	8,0	1,9	0,1	2	Cylindrical	■
S4521-030G2C.0Z2	AXT	10228023	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,1	2	Cylindrical	■
S4521-040G2C.0Z2	AXT	10228024	2	G	4,0	6,0	8,0	57,0	14,0	3,8	0,1	2	Cylindrical	■
S4521-050G2C.0Z2	AXT	10228025	2	G	5,0	6,0	10,0	57,0	17,0	4,75	0,1	2	Cylindrical	■
S4521-060E2C.0Z2	AXT	10228026	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	2	Cylindrical	■
S4521-080E2C.0Z2	AXT	10228029	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	2	Cylindrical	■
S4521-100E2C.0Z2	AXT	10228033	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	2	Cylindrical	■
S4521-120E2C.0Z2	AXT	10228037	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	2	Cylindrical	■
S4521-140E2C.0Z2	AXT	10228043	2	E	14,0	14,0	28,0	89,0	41,0	13,3	0,1	2	Cylindrical	■
S4521-160E2C.0Z2	AXT	10228044	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	2	Cylindrical	■
S4521-200E2C.0Z2	AXT	10228051	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	2	Cylindrical	■

■ **Prodotto standard.**

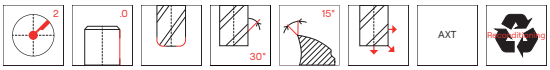
S4521

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta





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

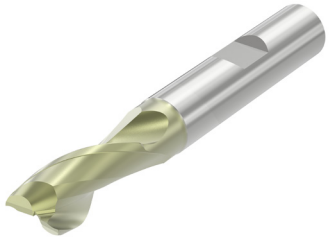


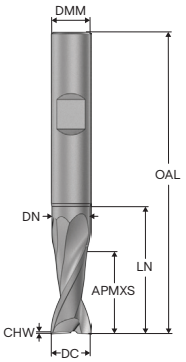
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4521-060E2R050.0Z2	AXT	10228027	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	2	Cylindrical	■
S4521-060E2R100.0Z2	AXT	10228028	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	2	Cylindrical	■
S4521-080E2R050.0Z2	AXT	10228030	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,5	2	Cylindrical	■
S4521-080E2R100.0Z2	AXT	10228031	2	E	8,0	8,0	16,0	63,0	24,0	7,6	1,0	2	Cylindrical	■
S4521-100E2R050.0Z2	AXT	10228034	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	2	Cylindrical	■
S4521-100E2R100.0Z2	AXT	10228035	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	2	Cylindrical	■
S4521-120E2R050.0Z2	AXT	10228038	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	2	Cylindrical	■
S4521-120E2R100.0Z2	AXT	10228039	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	2	Cylindrical	■
S4521-120E2R200.0Z2	AXT	10228040	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	2	Cylindrical	■
S4521-120E2R300.0Z2	AXT	10228041	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	2	Cylindrical	■
S4521-160E2R050.0Z2	AXT	10228045	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,5	2	Cylindrical	■
S4521-160E2R100.0Z2	AXT	10228046	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	2	Cylindrical	■
S4521-160E2R200.0Z2	AXT	10228047	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	2	Cylindrical	■
S4521-160E2R300.0Z2	AXT	10228048	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	2	Cylindrical	■
S4521-160E2R400.0Z2	AXT	10228049	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	2	Cylindrical	■
S4521-200E2R050.0Z2	AXT	10228052	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	2	Cylindrical	■
S4521-200E2R100.0Z2	AXT	10228053	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	2	Cylindrical	■
S4521-200E2R200.0Z2	AXT	10228054	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	2	Cylindrical	■
S4521-200E2R300.0Z2	AXT	10228055	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	2	Cylindrical	■
S4521-200E2R400.0Z2	AXT	10228056	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	2	Cylindrical	■
S4521-080E3R020.0Z2	AXT	10228032	3	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	Cylindrical	■
S4521-100E3R050.0Z2	AXT	10228036	3	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	Cylindrical	■
S4521-120E3R050.0Z2	AXT	10228042	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	Cylindrical	■
S4521-160E3R050.0Z2	AXT	10228050	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	Cylindrical	■
S4521-200E3R050.0Z2	AXT	10228057	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	Cylindrical	■

■ **Prodotto standard.**

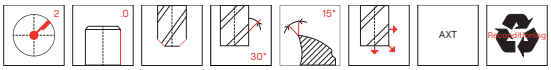
S4521

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Weldon – Smusso





—Tolleranze:
—DMM=h5
—DC= e7
—CHW= +0,04 mm
—Riaffilatura possibile se DC è ≥Ø6

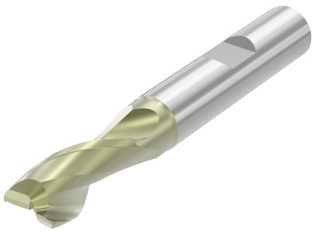


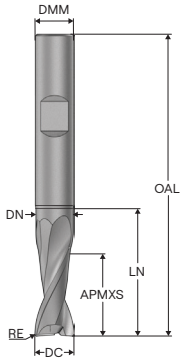
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4521-060E2C.3Z2	AXT	10286908	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	2	Weldon	☐
S4521-080E2C.3Z2	AXT	10286911	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	2	Weldon	☐
S4521-100E2C.3Z2	AXT	10286915	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	2	Weldon	☐
S4521-120E2C.3Z2	AXT	10286919	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	2	Weldon	☐
S4521-140E2C.3Z2	AXT	10286925	2	E	14,0	14,0	28,0	89,0	41,0	13,3	0,1	2	Weldon	☐
S4521-160E2C.3Z2	AXT	10286926	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	2	Weldon	☐
S4521-200E2C.3Z2	AXT	10286933	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	2	Weldon	☐

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

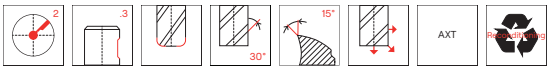
S4521

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Weldon – Raggio di punta





- 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	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4521-060E2R050.3Z2	AXT	10286909	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	2	Weldon	☐
S4521-060E2R100.3Z2	AXT	10286910	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	2	Weldon	☐
S4521-080E3R020.3Z2	AXT	10286914	2	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	Weldon	☐
S4521-080E2R050.3Z2	AXT	10286912	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,5	2	Weldon	☐
S4521-080E2R100.3Z2	AXT	10286913	2	E	8,0	8,0	16,0	63,0	24,0	7,6	1,0	2	Weldon	☐
S4521-100E2R050.3Z2	AXT	10286916	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	2	Weldon	☐
S4521-100E3R050.3Z2	AXT	10286918	2	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	Weldon	☐
S4521-100E2R100.3Z2	AXT	10286917	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	2	Weldon	☐
S4521-120E2R050.3Z2	AXT	10286920	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	2	Weldon	☐
S4521-120E2R100.3Z2	AXT	10286921	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	2	Weldon	☐
S4521-120E2R200.3Z2	AXT	10286922	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	2	Weldon	☐
S4521-120E2R300.3Z2	AXT	10286923	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	2	Weldon	☐
S4521-160E2R050.3Z2	AXT	10286927	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,5	2	Weldon	☐
S4521-160E2R100.3Z2	AXT	10286928	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	2	Weldon	☐
S4521-160E2R200.3Z2	AXT	10286929	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	2	Weldon	☐
S4521-160E2R300.3Z2	AXT	10286930	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	2	Weldon	☐
S4521-160E2R400.3Z2	AXT	10286931	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	2	Weldon	☐
S4521-200E2R050.3Z2	AXT	10286934	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	2	Weldon	☐
S4521-200E2R100.3Z2	AXT	10286935	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	2	Weldon	☐
S4521-200E2R200.3Z2	AXT	10286936	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	2	Weldon	☐
S4521-200E2R300.3Z2	AXT	10286937	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	2	Weldon	☐
S4521-200E2R400.3Z2	AXT	10286938	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	2	Weldon	☐
S4521-120E3R050.3Z2	AXT	10286924	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	Weldon	☐
S4521-160E3R050.3Z2	AXT	10286932	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	Weldon	☐
S4521-200E3R050.3Z2	AXT	10286939	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	Weldon	☐

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

Parametri di taglio – S4521 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	0,40 *0.40*	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	0,30 *0.30*	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	0,30 *0.30*	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	0,40 *0.40*	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	0,40 *0.40*	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)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – S4521 Scanalatura

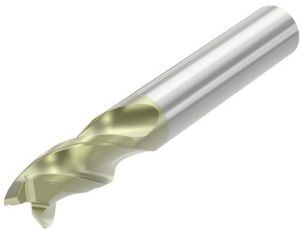
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	495 (400 — 590) *1625 (1400 — 1900)*
N2	E	1,2 *1.2*	0,016 *0.00065*	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*	395 (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 — 320) *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*	495 (400 — 590) *1625 (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*	395 (300 — 490) *1300 (990 — 1600)*

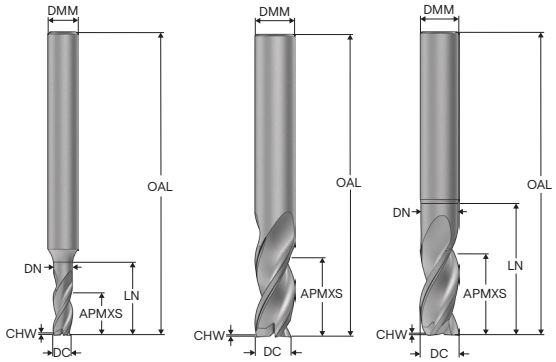
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

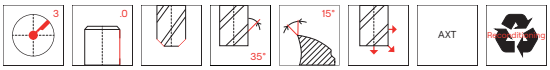
S4531

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





– Tolleranze:
– DMM=h5
– DC= e7
– CHW= +0,04 mm
– Riaffilatura possibile se DC è ≥Ø6

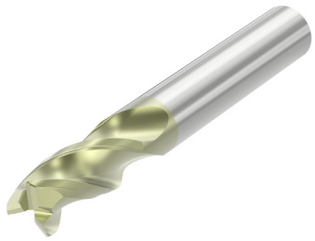


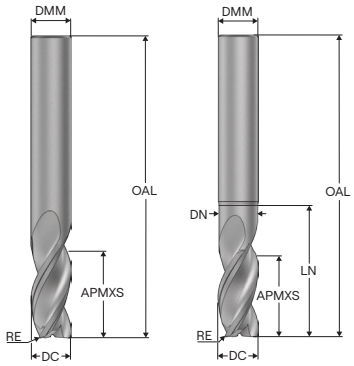
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-020G2C.0Z3	AXT	10228067	2	G	2,0	6,0	4,0	57,0	7,0	1,9	0,1	3	Cylindrical	■
S4531-030G2C.0Z3	AXT	10228068	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,1	3	Cylindrical	■
S4531-040G2C.0Z3	AXT	10228069	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,1	3	Cylindrical	■
S4531-050G2C.0Z3	AXT	10228070	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,1	3	Cylindrical	■
S4531-060D2C.0Z3	AXT	10228071	2	D	6,0	6,0	12,0	57,0	–	–	0,1	3	Cylindrical	■
S4531-060E2C.0Z3	AXT	10228074	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	3	Cylindrical	■
S4531-080D2C.0Z3	AXT	10228077	2	D	8,0	8,0	16,0	63,0	–	–	0,1	3	Cylindrical	■
S4531-080E2C.0Z3	AXT	10228080	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	3	Cylindrical	■
S4531-100D2C.0Z3	AXT	10228083	2	D	10,0	10,0	20,0	72,0	–	–	0,1	3	Cylindrical	■
S4531-100E2C.0Z3	AXT	10228087	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	3	Cylindrical	■
S4531-120D2C.0Z3	AXT	10228091	2	D	12,0	12,0	24,0	88,0	–	–	0,1	3	Cylindrical	■
S4531-120E2C.0Z3	AXT	10228096	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	3	Cylindrical	■
S4531-140D2C.0Z3	AXT	10228102	2	D	14,0	14,0	28,0	89,0	–	–	0,1	3	Cylindrical	■
S4531-160D2C.0Z3	AXT	10228103	2	D	16,0	16,0	32,0	100,0	–	–	0,1	3	Cylindrical	■
S4531-200E2C.0Z3	AXT	10228114	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	3	Cylindrical	■
S4531-030G3C.0Z3	AXT	10228058	3	G	3,0	6,0	10,0	63,0	14,0	2,85	0,1	3	Cylindrical	■
S4531-040G3C.0Z3	AXT	10228059	3	G	4,0	6,0	13,0	63,0	18,0	3,8	0,1	3	Cylindrical	■
S4531-050G3C.0Z3	AXT	10228060	3	G	5,0	6,0	16,0	63,0	20,0	4,75	0,1	3	Cylindrical	■
S4531-060D3C.0Z3	AXT	10228061	3	D	6,0	6,0	19,0	63,0	–	–	0,1	3	Cylindrical	■
S4531-080D3C.0Z3	AXT	10228062	3	D	8,0	8,0	26,0	74,0	–	–	0,1	3	Cylindrical	■
S4531-100D3C.0Z3	AXT	10228063	3	D	10,0	10,0	32,0	84,0	–	–	0,1	3	Cylindrical	■
S4531-120D3C.0Z3	AXT	10228064	3	D	12,0	12,0	38,0	99,0	–	–	0,1	3	Cylindrical	■
S4531-160D3C.0Z3	AXT	10228065	3	D	16,0	16,0	50,0	114,0	–	–	0,1	3	Cylindrical	■
S4531-200D3C.0Z3	AXT	10228066	3	D	20,0	20,0	62,0	150,0	–	–	0,1	3	Cylindrical	■
S4531-200E3C.0Z3	AXT	10228120	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,1	3	Cylindrical	■

■ **Prodotto standard.**

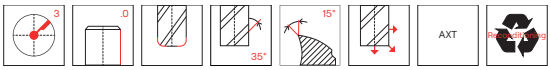
S4531

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





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

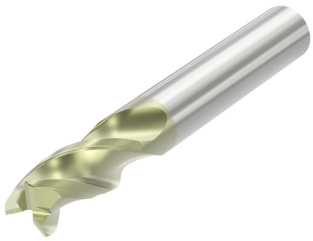


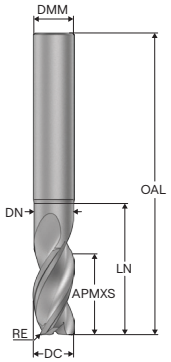
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-060D2R050.0Z3	AXT	10228072	2	D	6,0	6,0	12,0	57,0	–	–	0,5	3	Cylindrical	■
S4531-060E2R050.0Z3	AXT	10228075	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	3	Cylindrical	■
S4531-060D2R100.0Z3	AXT	10228073	2	D	6,0	6,0	12,0	57,0	–	–	1,0	3	Cylindrical	■
S4531-060E2R100.0Z3	AXT	10228076	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	3	Cylindrical	■
S4531-080D2R050.0Z3	AXT	10228078	2	D	8,0	8,0	16,0	63,0	–	–	0,5	3	Cylindrical	■
S4531-080E2R050.0Z3	AXT	10228081	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	Cylindrical	■
S4531-080D2R100.0Z3	AXT	10228079	2	D	8,0	8,0	16,0	63,0	–	–	1,0	3	Cylindrical	■
S4531-080E2R100.0Z3	AXT	10228082	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	Cylindrical	■
S4531-100D2R050.0Z3	AXT	10228084	2	D	10,0	10,0	20,0	72,0	–	–	0,5	3	Cylindrical	■
S4531-100E2R050.0Z3	AXT	10228088	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	3	Cylindrical	■
S4531-100D2R100.0Z3	AXT	10228085	2	D	10,0	10,0	20,0	72,0	–	–	1,0	3	Cylindrical	■
S4531-100E2R100.0Z3	AXT	10228089	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	3	Cylindrical	■
S4531-100D2R200.0Z3	AXT	10228086	2	D	10,0	10,0	20,0	72,0	–	–	2,0	3	Cylindrical	■
S4531-100E2R200.0Z3	AXT	10228090	2	E	10,0	10,0	20,0	72,0	31,0	9,5	2,0	3	Cylindrical	■
S4531-120D2R050.0Z3	AXT	10228092	2	D	12,0	12,0	24,0	88,0	–	–	0,5	3	Cylindrical	■
S4531-120E2R050.0Z3	AXT	10228097	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	3	Cylindrical	■
S4531-120D2R100.0Z3	AXT	10228093	2	D	12,0	12,0	24,0	88,0	–	–	1,0	3	Cylindrical	■
S4531-120E2R100.0Z3	AXT	10228098	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	3	Cylindrical	■
S4531-120D2R200.0Z3	AXT	10228094	2	D	12,0	12,0	24,0	88,0	–	–	2,0	3	Cylindrical	■
S4531-120E2R200.0Z3	AXT	10228099	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	3	Cylindrical	■
S4531-120D2R300.0Z3	AXT	10228095	2	D	12,0	12,0	24,0	88,0	–	–	3,0	3	Cylindrical	■
S4531-120E2R300.0Z3	AXT	10228100	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	3	Cylindrical	■
S4531-160D2R050.0Z3	AXT	10228104	2	D	16,0	16,0	32,0	100,0	–	–	0,5	3	Cylindrical	■
S4531-160E2R100.0Z3	AXT	10228105	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	3	Cylindrical	■
S4531-160E2R200.0Z3	AXT	10228106	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	3	Cylindrical	■
S4531-160E2R250.0Z3	AXT	10228107	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,5	3	Cylindrical	■
S4531-160E2R300.0Z3	AXT	10228108	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	3	Cylindrical	■
S4531-160E2R400.0Z3	AXT	10228109	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	3	Cylindrical	■
S4531-200E2R050.0Z3	AXT	10228115	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	3	Cylindrical	■
S4531-200E2R100.0Z3	AXT	10228116	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	3	Cylindrical	■
S4531-200E2R200.0Z3	AXT	10228117	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	3	Cylindrical	■
S4531-200E2R300.0Z3	AXT	10228118	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	3	Cylindrical	■
S4531-200E2R400.0Z3	AXT	10228119	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	3	Cylindrical	■

■ **Prodotto standard.**

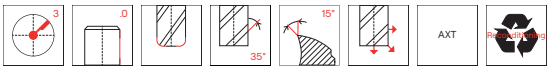
S4531

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





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

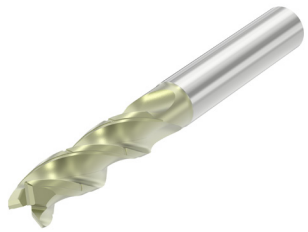


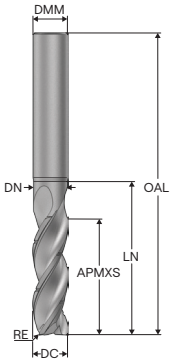
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-120E3R300.0Z3	AXT	10228101	3	E	12,0	12,0	24,0	110,0	54,0	11,4	3,0	3	Cylindrical	■
S4531-160E3R100.0Z3	AXT	10228110	3	E	16,0	16,0	32,0	129,0	77,0	15,2	1,0	3	Cylindrical	■
S4531-160E3R200.0Z3	AXT	10228111	3	E	16,0	16,0	32,0	129,0	77,0	15,2	2,0	3	Cylindrical	■
S4531-160E3R300.0Z3	AXT	10228112	3	E	16,0	16,0	32,0	129,0	77,0	15,2	3,0	3	Cylindrical	■
S4531-160E3R400.0Z3	AXT	10228113	3	E	16,0	16,0	32,0	129,0	77,0	15,2	4,0	3	Cylindrical	■
S4531-200E3R050.0Z3	AXT	10228121	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,5	3	Cylindrical	■
S4531-200E3R100.0Z3	AXT	10228122	3	E	20,0	20,0	40,0	150,0	90,0	19,0	1,0	3	Cylindrical	■
S4531-200E3R200.0Z3	AXT	10228123	3	E	20,0	20,0	40,0	150,0	90,0	19,0	2,0	3	Cylindrical	■
S4531-200E3R300.0Z3	AXT	10228124	3	E	20,0	20,0	40,0	150,0	90,0	19,0	3,0	3	Cylindrical	■
S4531-200E3R400.0Z3	AXT	10228125	3	E	20,0	20,0	40,0	150,0	90,0	19,0	4,0	3	Cylindrical	■

■ **Prodotto standard.**

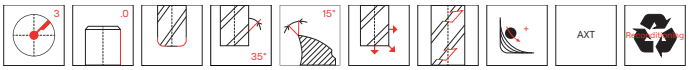
S4531

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





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

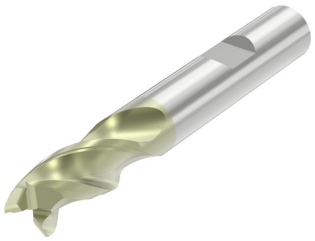


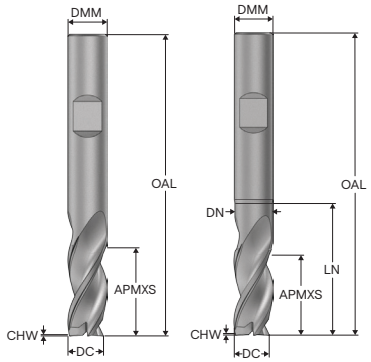
Codice di ordinazione	Qualità	Codice prodotto	Indice di lung-hezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
						mm	mm	mm	mm	mm	mm	mm			
S4531-060E3R050.0Z3C	AXT	10228126	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	0,5	3	Cylindrical	■
S4531-060E3R100.0Z3C	AXT	10228127	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	1,0	3	Cylindrical	■
S4531-080E3R050.0Z3C	AXT	10228128	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	0,5	3	Cylindrical	■
S4531-080E3R100.0Z3C	AXT	10228129	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	1,0	3	Cylindrical	■
S4531-080E3R200.0Z3C	AXT	10228130	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	2,0	3	Cylindrical	■
S4531-100E3R050.0Z3C	AXT	10228131	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	0,5	3	Cylindrical	■
S4531-100E3R100.0Z3C	AXT	10228132	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	1,0	3	Cylindrical	■
S4531-100E3R200.0Z3C	AXT	10228133	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	2,0	3	Cylindrical	■
S4531-120E3R050.0Z3C	AXT	10228134	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	0,5	3	Cylindrical	■
S4531-120E3R100.0Z3C	AXT	10228135	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	1,0	3	Cylindrical	■
S4531-120E3R200.0Z3C	AXT	10228136	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	2,0	3	Cylindrical	■
S4531-120E3R300.0Z3C	AXT	10228137	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	3,0	3	Cylindrical	■
S4531-160E3R050.0Z3C	AXT	10228138	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	0,5	3	Cylindrical	■
S4531-160E3R100.0Z3C	AXT	10228139	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	1,0	3	Cylindrical	■
S4531-160E3R200.0Z3C	AXT	10228140	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	2,0	3	Cylindrical	■
S4531-160E3R300.0Z3C	AXT	10228141	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	3,0	3	Cylindrical	■
S4531-200E3R050.0Z3C	AXT	10228142	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	0,5	3	Cylindrical	■
S4531-200E3R100.0Z3C	AXT	10228143	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	1,0	3	Cylindrical	■
S4531-200E3R200.0Z3C	AXT	10228144	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	2,0	3	Cylindrical	■
S4531-200E3R300.0Z3C	AXT	10228145	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	3,0	3	Cylindrical	■

■ **Prodotto standard.**

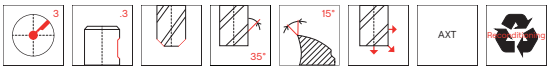
S4531

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





– Tolleranze:
– DMM=h5
– DC= e7
– CHW= +0,04 mm
– Riaffilatura possibile se DC è ≥Ø6

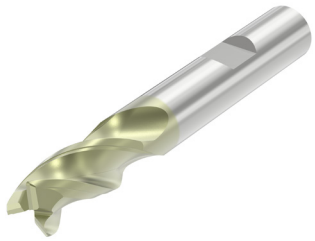


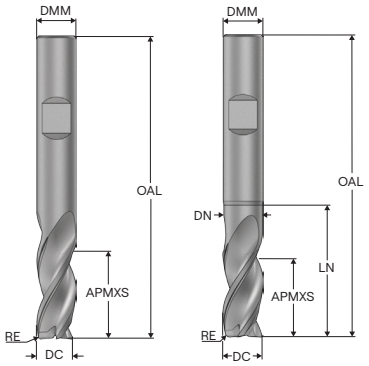
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-060D2C.3Z3	AXT	10286946	2	D	6,0	6,0	12,0	57,0	–	–	0,1	3	Weldon	☐
S4531-060E2C.3Z3	AXT	10286949	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	3	Weldon	☐
S4531-080D2C.3Z3	AXT	10286952	2	D	8,0	8,0	16,0	63,0	–	–	0,1	3	Weldon	☐
S4531-080E2C.3Z3	AXT	10286955	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	3	Weldon	☐
S4531-100D2C.3Z3	AXT	10286958	2	D	10,0	10,0	20,0	72,0	–	–	0,1	3	Weldon	☐
S4531-100E2C.3Z3	AXT	10286962	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	3	Weldon	☐
S4531-120D2C.3Z3	AXT	10286966	2	D	12,0	12,0	24,0	88,0	–	–	0,1	3	Weldon	☐
S4531-120E2C.3Z3	AXT	10286971	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	3	Weldon	☐
S4531-140D2C.3Z3	AXT	10286977	2	D	14,0	14,0	28,0	89,0	–	–	0,1	3	Weldon	☐
S4531-160D2C.3Z3	AXT	10286978	2	D	16,0	16,0	32,0	100,0	–	–	0,1	3	Weldon	☐
S4531-200E2C.3Z3	AXT	10286989	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	3	Weldon	☐
S4531-060D3C.3Z3	AXT	10286940	3	D	6,0	6,0	19,0	63,0	–	–	0,1	3	Weldon	☐
S4531-080D3C.3Z3	AXT	10286941	3	D	8,0	8,0	26,0	74,0	–	–	0,1	3	Weldon	☐
S4531-100D3C.3Z3	AXT	10286942	3	D	10,0	10,0	32,0	84,0	–	–	0,1	3	Weldon	☐
S4531-120D3C.3Z3	AXT	10286943	3	D	12,0	12,0	38,0	99,0	–	–	0,1	3	Weldon	☐
S4531-160D3C.3Z3	AXT	10286944	3	D	16,0	16,0	50,0	114,0	–	–	0,1	3	Weldon	☐
S4531-200D3C.3Z3	AXT	10286945	3	D	20,0	20,0	62,0	150,0	–	–	0,1	3	Weldon	☐
S4531-200E3C.3Z3	AXT	10286995	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,1	3	Weldon	☐

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

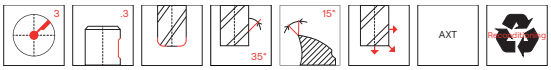
S4531

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





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

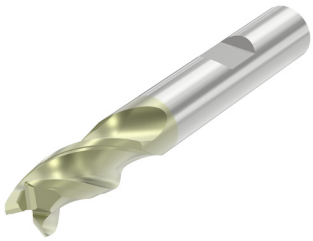


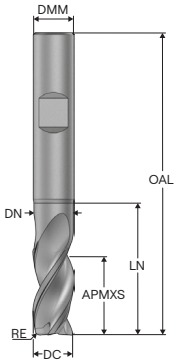
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-060D2R050.3Z3	AXT	10286947	2	D	6,0	6,0	12,0	57,0	–	–	0,5	3	Weldon	☐
S4531-060E2R050.3Z3	AXT	10286950	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	3	Weldon	☐
S4531-060D2R100.3Z3	AXT	10286948	2	D	6,0	6,0	12,0	57,0	–	–	1,0	3	Weldon	☐
S4531-060E2R100.3Z3	AXT	10286951	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	3	Weldon	☐
S4531-080D2R050.3Z3	AXT	10286953	2	D	8,0	8,0	16,0	63,0	–	–	0,5	3	Weldon	☐
S4531-080E2R050.3Z3	AXT	10286956	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	Weldon	☐
S4531-080D2R100.3Z3	AXT	10286954	2	D	8,0	8,0	16,0	63,0	–	–	1,0	3	Weldon	☐
S4531-080E2R100.3Z3	AXT	10286957	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	Weldon	☐
S4531-100D2R050.3Z3	AXT	10286959	2	D	10,0	10,0	20,0	72,0	–	–	0,5	3	Weldon	☐
S4531-100E2R050.3Z3	AXT	10286963	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	3	Weldon	☐
S4531-100D2R100.3Z3	AXT	10286960	2	D	10,0	10,0	20,0	72,0	–	–	1,0	3	Weldon	☐
S4531-100E2R100.3Z3	AXT	10286964	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	3	Weldon	☐
S4531-100D2R200.3Z3	AXT	10286961	2	D	10,0	10,0	20,0	72,0	–	–	2,0	3	Weldon	☐
S4531-100E2R200.3Z3	AXT	10286965	2	E	10,0	10,0	20,0	72,0	31,0	9,5	2,0	3	Weldon	☐
S4531-120D2R050.3Z3	AXT	10286967	2	D	12,0	12,0	24,0	88,0	–	–	0,5	3	Weldon	☐
S4531-120E2R050.3Z3	AXT	10286972	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	3	Weldon	☐
S4531-120D2R100.3Z3	AXT	10286968	2	D	12,0	12,0	24,0	88,0	–	–	1,0	3	Weldon	☐
S4531-120E2R100.3Z3	AXT	10286973	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	3	Weldon	☐
S4531-120D2R200.3Z3	AXT	10286969	2	D	12,0	12,0	24,0	88,0	–	–	2,0	3	Weldon	☐
S4531-120E2R200.3Z3	AXT	10286974	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	3	Weldon	☐
S4531-120D2R300.3Z3	AXT	10286970	2	D	12,0	12,0	24,0	88,0	–	–	3,0	3	Weldon	☐
S4531-120E2R300.3Z3	AXT	10286975	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	3	Weldon	☐
S4531-160D2R050.3Z3	AXT	10286979	2	D	16,0	16,0	32,0	100,0	–	–	0,5	3	Weldon	☐
S4531-160E2R100.3Z3	AXT	10286980	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	3	Weldon	☐
S4531-160E2R200.3Z3	AXT	10286981	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	3	Weldon	☐
S4531-160E2R250.3Z3	AXT	10286982	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,5	3	Weldon	☐
S4531-160E2R300.3Z3	AXT	10286983	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	3	Weldon	☐
S4531-160E2R400.3Z3	AXT	10286984	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	3	Weldon	☐

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

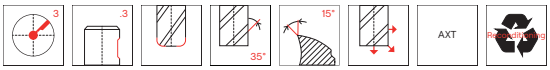
S4531

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





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

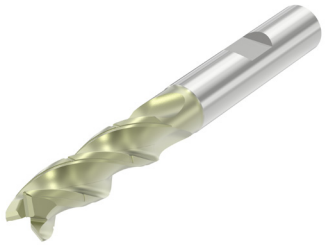


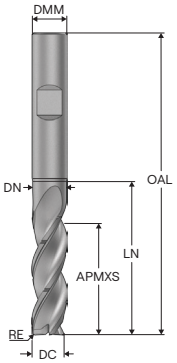
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-200E2R050.3Z3	AXT	10286990	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	3	Weldon	☐
S4531-200E2R100.3Z3	AXT	10286991	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	3	Weldon	☐
S4531-200E2R200.3Z3	AXT	10286992	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	3	Weldon	☐
S4531-200E2R300.3Z3	AXT	10286993	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	3	Weldon	☐
S4531-200E2R400.3Z3	AXT	10286994	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	3	Weldon	☐
S4531-120E3R300.3Z3	AXT	10286976	3	E	12,0	12,0	24,0	110,0	54,0	11,4	3,0	3	Weldon	☐
S4531-160E3R100.3Z3	AXT	10286985	3	E	16,0	16,0	32,0	129,0	77,0	15,2	1,0	3	Weldon	☐
S4531-160E3R200.3Z3	AXT	10286986	3	E	16,0	16,0	32,0	129,0	77,0	15,2	2,0	3	Weldon	☐
S4531-160E3R300.3Z3	AXT	10286987	3	E	16,0	16,0	32,0	129,0	77,0	15,2	3,0	3	Weldon	☐
S4531-160E3R400.3Z3	AXT	10286988	3	E	16,0	16,0	32,0	129,0	77,0	15,2	4,0	3	Weldon	☐
S4531-200E3R050.3Z3	AXT	10286996	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,5	3	Weldon	☐
S4531-200E3R100.3Z3	AXT	10286997	3	E	20,0	20,0	40,0	150,0	90,0	19,0	1,0	3	Weldon	☐
S4531-200E3R200.3Z3	AXT	10286998	3	E	20,0	20,0	40,0	150,0	90,0	19,0	2,0	3	Weldon	☐
S4531-200E3R300.3Z3	AXT	10286999	3	E	20,0	20,0	40,0	150,0	90,0	19,0	3,0	3	Weldon	☐
S4531-200E3R400.3Z3	AXT	10287000	3	E	20,0	20,0	40,0	150,0	90,0	19,0	4,0	3	Weldon	☐

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

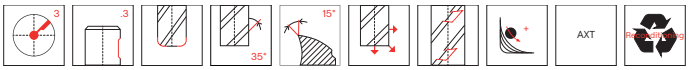
S4531

Alte prestazioni – Alluminio – 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	Qualità	Codice prodotto	Indice di lung-hezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
						mm	mm	mm	mm	mm	mm	mm			
S4531-060E3R050.3Z3C	AXT	10287001	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	0,5	3	Weldon	□
S4531-060E3R100.3Z3C	AXT	10287002	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	1,0	3	Weldon	□
S4531-080E3R050.3Z3C	AXT	10287004	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	0,5	3	Weldon	□
S4531-080E3R100.3Z3C	AXT	10287005	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	1,0	3	Weldon	□
S4531-080E3R200.3Z3C	AXT	10287006	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	2,0	3	Weldon	□
S4531-100E3R050.3Z3C	AXT	10287007	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	0,5	3	Weldon	□
S4531-100E3R100.3Z3C	AXT	10287008	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	1,0	3	Weldon	□
S4531-100E3R200.3Z3C	AXT	10287009	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	2,0	3	Weldon	□
S4531-120E3R050.3Z3C	AXT	10287010	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	0,5	3	Weldon	□
S4531-120E3R100.3Z3C	AXT	10287011	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	1,0	3	Weldon	□
S4531-120E3R200.3Z3C	AXT	10287012	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	2,0	3	Weldon	□
S4531-120E3R300.3Z3C	AXT	10287013	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	3,0	3	Weldon	□
S4531-160E3R050.3Z3C	AXT	10287014	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	0,5	3	Weldon	□
S4531-160E3R100.3Z3C	AXT	10287015	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	1,0	3	Weldon	□
S4531-160E3R200.3Z3C	AXT	10287016	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	2,0	3	Weldon	□
S4531-160E3R300.3Z3C	AXT	10287017	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	3,0	3	Weldon	□
S4531-200E3R050.3Z3C	AXT	10287018	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	0,5	3	Weldon	□
S4531-200E3R100.3Z3C	AXT	10287019	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	1,0	3	Weldon	□
S4531-200E3R200.3Z3C	AXT	10287020	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	2,0	3	Weldon	□
S4531-200E3R300.3Z3C	AXT	10287021	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	3,0	3	Weldon	□

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

Parametri di taglio – S4531 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	0,40 *0.40*	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	0,30 *0.30*	1,7 *1.7*	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	0,30 *0.30*	1,7 *1.7*	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	0,40 *0.40*	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	0,40 *0.40*	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)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – S4531 Scanalatura

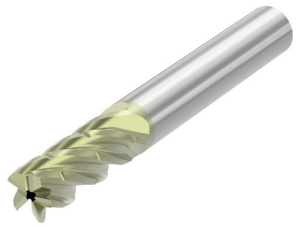
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	495 (400 — 590) *1625 (1400 — 1900)*
N2	E	1,2 *1.2*	0,016 *0.00065*	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*	395 (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 — 320) *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*	495 (400 — 590) *1625 (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*	395 (300 — 490) *1300 (990 — 1600)*

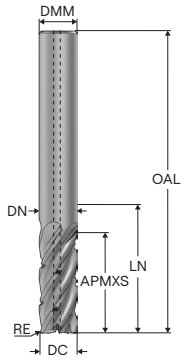
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

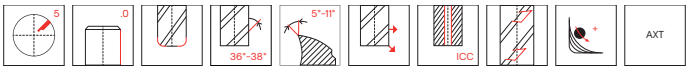
S4651

Alte prestazioni – Alluminio – Spallamento – 5 Eliche – Cilindrico





– Tolleranze:
– DMM=h5
– DC= e7
– RE= ±0,02 mm

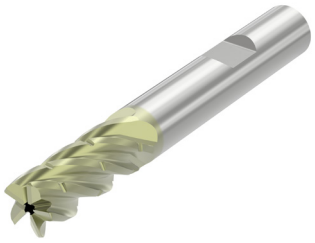


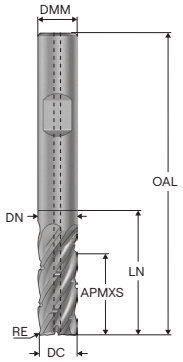
Codice di ordinazione	Qualità	Codice prodotto	Indice di lung-hezza	Forma utensile	profilo rompitru-ciolo	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
							mm	mm	mm	mm	mm	mm	mm			
S4651-060E2R050.0Z5AC	AXT	10228163	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	0,5	5	Cylindrical	■
S4651-060E2R100.0Z5AC	AXT	10228164	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	1,0	5	Cylindrical	■
S4651-080E2R050.0Z5AC	AXT	10228167	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	0,5	5	Cylindrical	■
S4651-080E2R100.0Z5AC	AXT	10228168	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	1,0	5	Cylindrical	■
S4651-100E2R050.0Z5AC	AXT	10228171	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	0,5	5	Cylindrical	■
S4651-100E2R100.0Z5AC	AXT	10228172	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	1,0	5	Cylindrical	■
S4651-120E2R050.0Z5AC	AXT	10228175	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	0,5	5	Cylindrical	■
S4651-120E2R100.0Z5AC	AXT	10228176	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	1,0	5	Cylindrical	■
S4651-120E2R200.0Z5AC	AXT	10228177	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	2,0	5	Cylindrical	■
S4651-120E2R300.0Z5AC	AXT	10228178	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	3,0	5	Cylindrical	■
S4651-160E2R050.0Z5AC	AXT	10228183	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	0,5	5	Cylindrical	■
S4651-160E2R100.0Z5AC	AXT	10228184	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	1,0	5	Cylindrical	■
S4651-160E2R200.0Z5AC	AXT	10228185	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	2,0	5	Cylindrical	■
S4651-160E2R300.0Z5AC	AXT	10228186	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	3,0	5	Cylindrical	■
S4651-200E2R050.0Z5AC	AXT	10228191	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	0,5	5	Cylindrical	■
S4651-200E2R100.0Z5AC	AXT	10228193	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	1,0	5	Cylindrical	■
S4651-200E2R200.0Z5AC	AXT	10228194	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	2,0	5	Cylindrical	■
S4651-200E2R300.0Z5AC	AXT	10228195	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	3,0	5	Cylindrical	■
S4651-060E4R050.0Z5AC	AXT	10228165	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	0,5	5	Cylindrical	■
S4651-060E4R100.0Z5AC	AXT	10228166	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	1,0	5	Cylindrical	■
S4651-080E4R050.0Z5AC	AXT	10228169	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	0,5	5	Cylindrical	■
S4651-080E4R100.0Z5AC	AXT	10228170	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	1,0	5	Cylindrical	■
S4651-100E4R050.0Z5AC	AXT	10228173	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	0,5	5	Cylindrical	■
S4651-100E4R100.0Z5AC	AXT	10228174	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	1,0	5	Cylindrical	■
S4651-120E4R050.0Z5AC	AXT	10228179	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	0,5	5	Cylindrical	■
S4651-120E4R100.0Z5AC	AXT	10228180	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	1,0	5	Cylindrical	■
S4651-120E4R200.0Z5AC	AXT	10228181	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	2,0	5	Cylindrical	■
S4651-120E4R300.0Z5AC	AXT	10228182	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	3,0	5	Cylindrical	■
S4651-160E4R050.0Z5AC	AXT	10228187	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	0,5	5	Cylindrical	■
S4651-160E4R100.0Z5AC	AXT	10228188	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	1,0	5	Cylindrical	■
S4651-160E4R200.0Z5AC	AXT	10228189	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	2,0	5	Cylindrical	■
S4651-160E4R300.0Z5AC	AXT	10228190	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,8	3,0	5	Cylindrical	■
S4651-200E4R050.0Z5AC	AXT	10228196	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	0,5	5	Cylindrical	■
S4651-200E4R100.0Z5AC	AXT	10228197	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	1,0	5	Cylindrical	■
S4651-200E4R200.0Z5AC	AXT	10228198	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	2,0	5	Cylindrical	■
S4651-200E4R300.0Z5AC	AXT	10228199	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	3,0	5	Cylindrical	■

■ **Prodotto standard.**

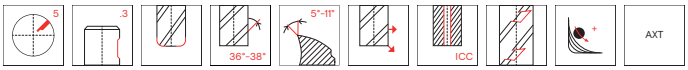
S4651

Alte prestazioni – Alluminio – Spallamento – 5 Eliche – Weldon





—Tolleranze:
—DMM=h5
—DC= e7
—RE= ±0,02 mm



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
							mm	mm	mm	mm	mm	mm	mm			
S4651-060E2R050.3Z5AC	AXT	10287053	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	0,5	5	Weldon	□
S4651-060E2R100.3Z5AC	AXT	10287054	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	1,0	5	Weldon	□
S4651-080E2R050.3Z5AC	AXT	10287057	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	0,5	5	Weldon	□
S4651-080E2R100.3Z5AC	AXT	10287058	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	1,0	5	Weldon	□
S4651-100E2R050.3Z5AC	AXT	10287061	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	0,5	5	Weldon	□
S4651-100E2R100.3Z5AC	AXT	10287062	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	1,0	5	Weldon	□
S4651-120E2R050.3Z5AC	AXT	10287065	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	0,5	5	Weldon	□
S4651-120E2R100.3Z5AC	AXT	10287066	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	1,0	5	Weldon	□
S4651-120E2R200.3Z5AC	AXT	10287067	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	2,0	5	Weldon	□
S4651-120E2R300.3Z5AC	AXT	10287068	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	3,0	5	Weldon	□
S4651-160E2R050.3Z5AC	AXT	10287073	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	0,5	5	Weldon	□
S4651-160E2R100.3Z5AC	AXT	10287074	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	1,0	5	Weldon	□
S4651-160E2R200.3Z5AC	AXT	10287075	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	2,0	5	Weldon	□
S4651-160E2R300.3Z5AC	AXT	10287076	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	3,0	5	Weldon	□
S4651-200E2R050.3Z5AC	AXT	10287081	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	0,5	5	Weldon	□
S4651-200E2R100.3Z5AC	AXT	10287082	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	1,0	5	Weldon	□
S4651-200E2R200.3Z5AC	AXT	10287083	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	2,0	5	Weldon	□
S4651-200E2R300.3Z5AC	AXT	10287084	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	3,0	5	Weldon	□
S4651-060E4R050.3Z5AC	AXT	10287055	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	0,5	5	Weldon	□
S4651-060E4R100.3Z5AC	AXT	10287056	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	1,0	5	Weldon	□
S4651-080E4R050.3Z5AC	AXT	10287059	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	0,5	5	Weldon	□
S4651-080E4R100.3Z5AC	AXT	10287060	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	1,0	5	Weldon	□
S4651-100E4R050.3Z5AC	AXT	10287063	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	0,5	5	Weldon	□
S4651-100E4R100.3Z5AC	AXT	10287064	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	1,0	5	Weldon	□
S4651-120E4R050.3Z5AC	AXT	10287069	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	0,5	5	Weldon	□
S4651-120E4R100.3Z5AC	AXT	10287070	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	1,0	5	Weldon	□
S4651-120E4R200.3Z5AC	AXT	10287071	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	2,0	5	Weldon	□
S4651-120E4R300.3Z5AC	AXT	10287072	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	3,0	5	Weldon	□
S4651-160E4R050.3Z5AC	AXT	10287077	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	0,5	5	Weldon	□
S4651-160E4R100.3Z5AC	AXT	10287078	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	1,0	5	Weldon	□
S4651-160E4R200.3Z5AC	AXT	10287079	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	2,0	5	Weldon	□
S4651-160E4R300.3Z5AC	AXT	10287080	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	3,0	5	Weldon	□
S4651-200E4R050.3Z5AC	AXT	10287085	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	0,5	5	Weldon	□
S4651-200E4R100.3Z5AC	AXT	10287086	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	1,0	5	Weldon	□
S4651-200E4R200.3Z5AC	AXT	10287087	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	2,0	5	Weldon	□
S4651-200E4R300.3Z5AC	AXT	10287088	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	3,0	5	Weldon	□

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

Parametri di taglio – S4651 Contornatura

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
N1	E	0,40 *0.40*	2,2 *2.2*	0,055 *0.0022*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	330 (260 — 410) *1075 (860 — 1300)*
N2	E	0,40 *0.40*	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*	280 (220 — 350) *920 (730 — 1100)*
N3	E	0,40 *0.40*	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*	185 (150 — 230) *610 (500 — 750)*

Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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 – S4651 Contornatura sgrossatura avanzata a_e/DC=0,07

SMG		a_p/DC	f_z						v_c
			6	8	10	12	16	20	
N1	E	2,2 *2.2*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,24 *0.0095*	475 (370 — 600) *1550 (1300 — 1900)*
N2	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	410 (320 — 520) *1350 (1100 — 1700)*
N3	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	275 (210 — 350) *900 (690 — 1100)*

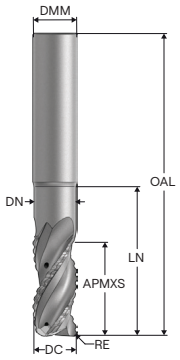
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

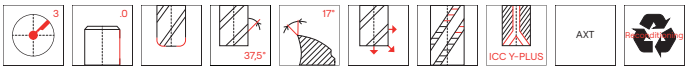
HP4931

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





E



– Tolleranze:
– DMM=h5
– DC -0,02/-0,1 mm
– RE=+/-0,05 mm
– Riaffilatura possibile

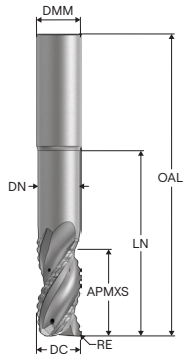
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Attacco	Prodotto standard
							mm	mm	mm	mm	mm	mm	mm		
HP4931-200E2R050.0Z3A	AXT	10318812	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	0,5	Cylindrical	■
HP4931-200E2R100.0Z3A	AXT	10318813	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	1,0	Cylindrical	■
HP4931-200E2R200.0Z3A	AXT	10318814	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	2,0	Cylindrical	■
HP4931-200E2R300.0Z3A	AXT	10318815	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	3,0	Cylindrical	■
HP4931-200E2R400.0Z3A	AXT	10318816	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	4,0	Cylindrical	■
HP4931-200E2R500.0Z3A	AXT	10318817	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	5,0	Cylindrical	□
HP4931-250E2R050.0Z3A	AXT	10318824	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	0,5	Cylindrical	■
HP4931-250E2R100.0Z3A	AXT	10318825	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	1,0	Cylindrical	■
HP4931-250E2R200.0Z3A	AXT	10318826	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	2,0	Cylindrical	■
HP4931-250E2R300.0Z3A	AXT	10318827	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	3,0	Cylindrical	■
HP4931-250E2R400.0Z3A	AXT	10318828	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	4,0	Cylindrical	■
HP4931-250E2R500.0Z3A	AXT	10318829	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	5,0	Cylindrical	□
HP4931-120E3R050.0Z3A	AXT	10318795	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	0,5	Cylindrical	■
HP4931-120E3R100.0Z3A	AXT	10318796	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	1,0	Cylindrical	■
HP4931-120E3R200.0Z3A	AXT	10318797	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	2,0	Cylindrical	■
HP4931-120E3R300.0Z3A	AXT	10318798	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	3,0	Cylindrical	■
HP4931-120E3R400.0Z3A	AXT	10318799	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	4,0	Cylindrical	□
HP4931-160E3R050.0Z3A	AXT	10318800	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	0,5	Cylindrical	■
HP4931-160E3R100.0Z3A	AXT	10318801	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	1,0	Cylindrical	■
HP4931-160E3R200.0Z3A	AXT	10318802	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	2,0	Cylindrical	■
HP4931-160E3R300.0Z3A	AXT	10318803	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	3,0	Cylindrical	■
HP4931-160E3R400.0Z3A	AXT	10318804	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	4,0	Cylindrical	■
HP4931-160E3R500.0Z3A	AXT	10318805	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	5,0	Cylindrical	□
HP4931-200E3R050.0Z3A	AXT	10318818	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	0,5	Cylindrical	■
HP4931-200E3R100.0Z3A	AXT	10318819	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	1,0	Cylindrical	■
HP4931-200E3R200.0Z3A	AXT	10318820	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	2,0	Cylindrical	■
HP4931-200E3R300.0Z3A	AXT	10318821	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	3,0	Cylindrical	■
HP4931-200E3R400.0Z3A	AXT	10318822	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	4,0	Cylindrical	■
HP4931-200E3R500.0Z3A	AXT	10318823	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	5,0	Cylindrical	□
HP4931-250E3R050.0Z3A	AXT	10318830	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	0,5	Cylindrical	■
HP4931-250E3R100.0Z3A	AXT	10318831	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	1,0	Cylindrical	■
HP4931-250E3R200.0Z3A	AXT	10318832	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	2,0	Cylindrical	■
HP4931-250E3R300.0Z3A	AXT	10318833	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	3,0	Cylindrical	■
HP4931-250E3R400.0Z3A	AXT	10318834	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	4,0	Cylindrical	■
HP4931-250E3R500.0Z3A	AXT	10318835	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	5,0	Cylindrical	□

■ **Prodotto standard.**

HP4931

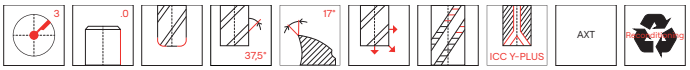
Alte prestazioni – Alluminio – Spallamento – 3 Eliche – Cilindrico – Raggio di punta





E

- Tolleranze:
- DMM=h5
- DC -0,02/-0,1 mm
- RE=+/-0,05 mm
- Riaffilatura possibile



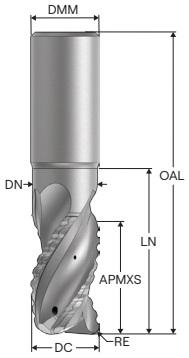
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Attacco	Prodotto standard
							mm	mm	mm	mm	mm	mm	mm		
HP4931-160E4R050.0Z3A	AXT	10318806	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	0,5	Cylindrical	■
HP4931-160E4R100.0Z3A	AXT	10318807	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	1,0	Cylindrical	■
HP4931-160E4R200.0Z3A	AXT	10318808	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	2,0	Cylindrical	■
HP4931-160E4R300.0Z3A	AXT	10318809	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	3,0	Cylindrical	■
HP4931-160E4R400.0Z3A	AXT	10318810	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	4,0	Cylindrical	■
HP4931-160E4R500.0Z3A	AXT	10318811	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	5,0	Cylindrical	□

■ **Prodotto standard.**

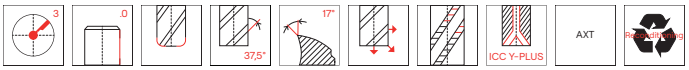
HP4931

Alte prestazioni – Alluminio – Spallamento – 3 Eliche – Cilindrico – Raggio di punta – Pollici





– Tolleranze:
– DMM=h5
– DC -0.001"/-0.004"
– RE=+/-0.002"
– Riaffilatura possibile



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Attacco	Prodotto standard
							inch	inch	inch	inch	inch	inch	inch		
HP4931-.750E2R020.0Z3A	AXT	10318851	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.020	Cylindrical	■
HP4931-.750E2R030.0Z3A	AXT	10318852	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.030	Cylindrical	■
HP4931-.750E2R060.0Z3A	AXT	10318853	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.060	Cylindrical	■
HP4931-.750E2R090.0Z3A	AXT	10318854	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.090	Cylindrical	■
HP4931-.750E2R120.0Z3A	AXT	10318855	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.120	Cylindrical	■
HP4931-1.000E2R020.0Z3A	AXT	10318861	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.020	Cylindrical	■
HP4931-1.000E2R030.0Z3A	AXT	10318862	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.030	Cylindrical	■
HP4931-1.000E2R060.0Z3A	AXT	10318863	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.060	Cylindrical	■
HP4931-1.000E2R090.0Z3A	AXT	10318864	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.090	Cylindrical	■
HP4931-1.000E2R120.0Z3A	AXT	10318865	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.120	Cylindrical	■
HP4931-.500E3R020.0Z3A	AXT	10318836	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.020	Cylindrical	■
HP4931-.500E3R030.0Z3A	AXT	10318837	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.030	Cylindrical	■
HP4931-.500E3R060.0Z3A	AXT	10318838	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.060	Cylindrical	■
HP4931-.500E3R090.0Z3A	AXT	10318839	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.090	Cylindrical	■
HP4931-.500E3R120.0Z3A	AXT	10318840	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.120	Cylindrical	■
HP4931-.625E3R020.0Z3A	AXT	10318841	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.020	Cylindrical	■
HP4931-.625E3R030.0Z3A	AXT	10318842	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.030	Cylindrical	■
HP4931-.625E3R060.0Z3A	AXT	10318843	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.060	Cylindrical	■
HP4931-.625E3R090.0Z3A	AXT	10318844	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.090	Cylindrical	■
HP4931-.625E3R120.0Z3A	AXT	10318845	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.120	Cylindrical	■
HP4931-.750E3R020.0Z3A	AXT	10318856	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.020	Cylindrical	■
HP4931-.750E3R030.0Z3A	AXT	10318857	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.030	Cylindrical	■
HP4931-.750E3R060.0Z3A	AXT	10318858	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.060	Cylindrical	■
HP4931-.750E3R090.0Z3A	AXT	10318859	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.090	Cylindrical	■
HP4931-.750E3R120.0Z3A	AXT	10318860	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.120	Cylindrical	■
HP4931-1.000E3R020.0Z3A	AXT	10318866	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.020	Cylindrical	■
HP4931-1.000E3R030.0Z3A	AXT	10318867	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.030	Cylindrical	■
HP4931-1.000E3R060.0Z3A	AXT	10318868	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.060	Cylindrical	■
HP4931-1.000E3R090.0Z3A	AXT	10318869	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.090	Cylindrical	■
HP4931-1.000E3R120.0Z3A	AXT	10318870	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.120	Cylindrical	■
HP4931-.625E4R020.0Z3A	AXT	10318846	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.020	Cylindrical	■
HP4931-.625E4R030.0Z3A	AXT	10318847	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.030	Cylindrical	■
HP4931-.625E4R060.0Z3A	AXT	10318848	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.060	Cylindrical	■
HP4931-.625E4R090.0Z3A	AXT	10318849	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.090	Cylindrical	■
HP4931-.625E4R120.0Z3A	AXT	10318850	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.120	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – HP4931 Scanalatura

SMG		a_p/DC	f_z				v_c
			12	16	20	25	
N1	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	1500 (800 — 2400) *4925 (2700 — 7800)*
N2	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	960 (520 — 1600) *3150 (1800 — 5200)*
N3	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	1400 (750 — 2300) *4600 (2500 — 7500)*

Parametri di taglio – HP4931 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z				v_c
				12	16	20	25	
N1	E/M/A	0,40 *0.40*	1,5 *1.5*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	1825 (980 — 3000) *6000 (3300 — 9800)*
N2	E/M/A	0,40 *0.40*	1,5 *1.5*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	1175 (630 — 1900) *3850 (2100 — 6200)*
N3	E/M/A	0,40 *0.40*	1,5 *1.5*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	1700 (910 — 2800) *5575 (3000 — 9100)*

Parametri di taglio – HP4931 Contornatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z				v_c
				1/2	5/8	3/4	1	
N1	E/M/A	0,40 *0.40*	1,5 *1.5*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*	1850 (990 — 3000) *6075 (3300 — 9800)*
N2	E/M/A	0,40 *0.40*	1,5 *1.5*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*	1200 (640 — 1900) *3925 (2100 — 6200)*
N3	E/M/A	0,40 *0.40*	1,5 *1.5*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*	1725 (930 — 2800) *5650 (3100 — 9100)*

Parametri di taglio – HP4931 Scanalatura – Pollici

SMG		a_p/DC	f_z				v_c
			1/2	5/8	3/4	1	
N1	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	1525 (810 — 2500) *5000 (2700 — 8200)*
N2	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	980 (530 — 1600) *3225 (1800 — 5200)*
N3	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	1425 (760 — 2300) *4675 (2500 — 7500)*

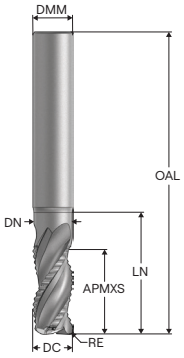
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

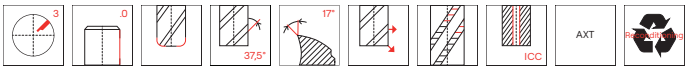
S4931

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





– Tolleranze:
– DMM=-.0001"/-.0004"
– SIG= ±1°
– Riaffilatura possibile se DMM è ≥Ø.375"

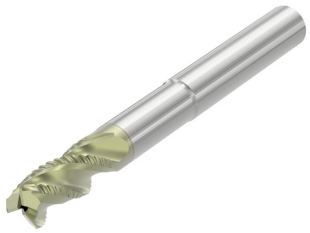


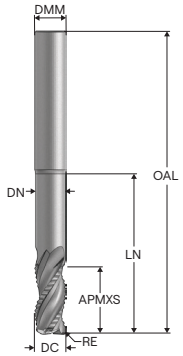
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Attacco	Prodotto standard
							mm	mm	mm	mm	mm	mm	mm		
S4931-060E3R050.0Z3A	AXT	10318871	3	E	■	■	6,0	6,0	13,0	60,0	19,5	5,7	0,5	Cylindrical	■
S4931-080E3R050.0Z3A	AXT	10318873	3	E	■	■	8,0	8,0	18,0	65,0	26,0	7,6	0,5	Cylindrical	■
S4931-100E3R050.0Z3A	AXT	10318876	3	E	■	■	10,0	10,0	22,0	75,0	32,5	9,5	0,5	Cylindrical	■
S4931-100E3R100.0Z3A	AXT	10318879	3	E	■	■	10,0	10,0	22,0	75,0	32,5	9,5	1,0	Cylindrical	■
S4931-120E3R050.0Z3A	AXT	10318882	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	0,5	Cylindrical	■
S4931-120E3R100.0Z3A	AXT	10318885	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	1,0	Cylindrical	■
S4931-120E3R200.0Z3A	AXT	10318888	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	2,0	Cylindrical	■
S4931-120E3R300.0Z3A	AXT	10318891	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	3,0	Cylindrical	■
S4931-160E3R050.0Z3A	AXT	10318894	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	0,5	Cylindrical	■
S4931-160E3R100.0Z3A	AXT	10318897	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	1,0	Cylindrical	■
S4931-160E3R200.0Z3A	AXT	10318900	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	2,0	Cylindrical	■
S4931-160E3R300.0Z3A	AXT	10318903	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	3,0	Cylindrical	■
S4931-060E4R050.0Z3A	AXT	10318872	4	E	■	■	6,0	6,0	13,0	70,0	25,5	5,7	0,5	Cylindrical	■
S4931-080E4R050.0Z3A	AXT	10318874	4	E	■	■	8,0	8,0	18,0	80,0	34,0	7,6	0,5	Cylindrical	■
S4931-100E4R050.0Z3A	AXT	10318877	4	E	■	■	10,0	10,0	22,0	95,0	42,5	9,5	0,5	Cylindrical	■
S4931-100E4R100.0Z3A	AXT	10318880	4	E	■	■	10,0	10,0	22,0	95,0	42,5	9,5	1,0	Cylindrical	■
S4931-120E4R050.0Z3A	AXT	10318883	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	0,5	Cylindrical	■
S4931-120E4R100.0Z3A	AXT	10318886	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	1,0	Cylindrical	■
S4931-120E4R200.0Z3A	AXT	10318889	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	2,0	Cylindrical	■
S4931-120E4R300.0Z3A	AXT	10318892	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	3,0	Cylindrical	■
S4931-160E4R050.0Z3A	AXT	10318895	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	0,5	Cylindrical	■
S4931-160E4R100.0Z3A	AXT	10318898	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	1,0	Cylindrical	■
S4931-160E4R200.0Z3A	AXT	10318901	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	2,0	Cylindrical	■
S4931-160E4R300.0Z3A	AXT	10318904	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	3,0	Cylindrical	■
S4931-200E4R200.0Z3A	AXT	10336122	4	E	■	■	20,0	20,0	42,0	135,0	81,0	19,0	2,0	Cylindrical	■
S4931-200E4R300.0Z3A	AXT	10336123	4	E	■	■	20,0	20,0	42,0	135,0	81,0	19,0	3,0	Cylindrical	■
S4931-250E4R200.0Z3A	AXT	10336124	4	E	■	■	25,0	25,0	52,0	160,0	101,0	23,8	2,0	Cylindrical	■
S4931-250E4R300.0Z3A	AXT	10336125	4	E	■	■	25,0	25,0	52,0	160,0	101,0	23,8	3,0	Cylindrical	■

■ **Prodotto standard.**

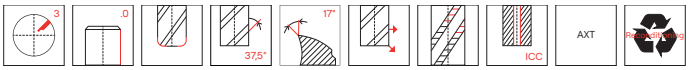
S4931

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





—Tolleranze:
—DMM=-.0001"/-.0004"
—SIG= ±1°
—Riaffilatura possibile se DMM è ≥Ø.375"

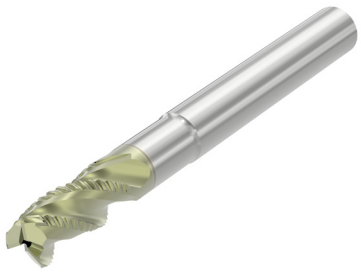


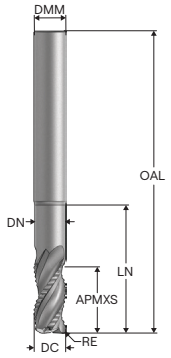
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Attacco	Prodotto standard
							mm	mm	mm	mm	mm	mm	mm		
S4931-080E5R050.0Z3A	AXT	10318875	5	E	■	■	8,0	8,0	18,0	80,0	42,0	7,6	0,5	Cylindrical	■
S4931-100E5R050.0Z3A	AXT	10318878	5	E	■	■	10,0	10,0	22,0	95,0	52,5	9,5	0,5	Cylindrical	■
S4931-100E5R100.0Z3A	AXT	10318881	5	E	■	■	10,0	10,0	22,0	95,0	52,5	9,5	1,0	Cylindrical	■
S4931-120E5R050.0Z3A	AXT	10318884	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	0,5	Cylindrical	■
S4931-120E5R100.0Z3A	AXT	10318887	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	1,0	Cylindrical	■
S4931-120E5R200.0Z3A	AXT	10318890	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	2,0	Cylindrical	■
S4931-120E5R300.0Z3A	AXT	10318893	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	3,0	Cylindrical	■
S4931-160E5R050.0Z3A	AXT	10318896	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	0,5	Cylindrical	■
S4931-160E5R100.0Z3A	AXT	10318899	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	1,0	Cylindrical	■
S4931-160E5R200.0Z3A	AXT	10318902	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	2,0	Cylindrical	■
S4931-160E5R300.0Z3A	AXT	10318905	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	3,0	Cylindrical	■

■ **Prodotto standard.**

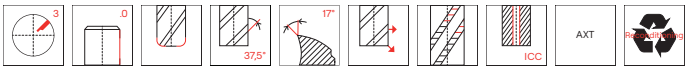
S4931

Uso generico – Alluminio – Spallamento – 3 Eliche – Cilindrico – Raggio di punta – Pollici





- Tolleranze:
- DMM=h5
- DC -0.001"/-0.004"
- RE=+/-0.002"
- Riaffilatura possibile se DC è ≥Ø.500



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Attacco	Prodotto standard
							inch	inch	inch	inch	inch	inch	inch		
S4931-.250E3R030.0Z3A	AXT	10318906	3	E	■	■	0.250	0.250	0.500	2.250	0.750	0.234	0.030	Cylindrical	■
S4931-.313E3R030.0Z3A	AXT	10318908	3	E	■	■	0.313	0.313	0.625	2.500	1.000	0.297	0.030	Cylindrical	■
S4931-.375E3R030.0Z3A	AXT	10318910	3	E	■	■	0.375	0.375	0.750	3.000	1.250	0.355	0.030	Cylindrical	■
S4931-.375E3R060.0Z3A	AXT	10318912	3	E	■	■	0.375	0.375	0.750	3.000	1.250	0.355	0.060	Cylindrical	■
S4931-.500E3R030.0Z3A	AXT	10318914	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.030	Cylindrical	■
S4931-.500E3R060.0Z3A	AXT	10318917	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.060	Cylindrical	■
S4931-.500E3R090.0Z3A	AXT	10318920	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.090	Cylindrical	■
S4931-.500E3R120.0Z3A	AXT	10318923	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.120	Cylindrical	■
S4931-.625E3R030.0Z3A	AXT	10318926	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.030	Cylindrical	■
S4931-.625E3R060.0Z3A	AXT	10318928	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.060	Cylindrical	■
S4931-.625E3R090.0Z3A	AXT	10318930	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.090	Cylindrical	■
S4931-.625E3R120.0Z3A	AXT	10318932	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.120	Cylindrical	■
S4931-.250E4R030.0Z3A	AXT	10318907	4	E	■	■	0.250	0.250	0.500	2.500	1.000	0.234	0.030	Cylindrical	■
S4931-.313E4R030.0Z3A	AXT	10318909	4	E	■	■	0.313	0.313	0.625	3.000	1.250	0.297	0.030	Cylindrical	■
S4931-.375E4R030.0Z3A	AXT	10318911	4	E	■	■	0.375	0.375	0.750	3.250	1.625	0.355	0.030	Cylindrical	■
S4931-.375E4R060.0Z3A	AXT	10318913	4	E	■	■	0.375	0.375	0.750	3.250	1.625	0.355	0.060	Cylindrical	■
S4931-.500E4R030.0Z3A	AXT	10318915	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.030	Cylindrical	■
S4931-.500E4R060.0Z3A	AXT	10318918	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.060	Cylindrical	■
S4931-.500E4R090.0Z3A	AXT	10318921	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.090	Cylindrical	■
S4931-.500E4R120.0Z3A	AXT	10318924	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.120	Cylindrical	■
S4931-.625E4R030.0Z3A	AXT	10318927	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.030	Cylindrical	■
S4931-.625E4R060.0Z3A	AXT	10318929	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.060	Cylindrical	■
S4931-.625E4R090.0Z3A	AXT	10318931	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.090	Cylindrical	■
S4931-.625E4R120.0Z3A	AXT	10318933	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.120	Cylindrical	■
S4931-.500E5R030.0Z3A	AXT	10318916	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.030	Cylindrical	■
S4931-.500E5R060.0Z3A	AXT	10318919	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.060	Cylindrical	■
S4931-.500E5R090.0Z3A	AXT	10318922	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.090	Cylindrical	■
S4931-.500E5R120.0Z3A	AXT	10318925	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.120	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – S4931 Contornatura sgrossatura

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0,40 *0.40*	1,5 *1.5*	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*	940 (360 — 1700) *3075 (1200 — 5500)*
N2	E	0,40 *0.40*	1,5 *1.5*	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*	610 (230 — 1100) *2000 (760 — 3600)*
N3	E	0,40 *0.40*	1,5 *1.5*	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*	940 (360 — 1700) *3075 (1200 — 5500)*

Parametri di taglio – S4931 Scanalatura

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
N1	E	1,0 *1.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	800 (300 — 1400) *2625 (990 — 4500)*
N2	E	1,0 *1.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	510 (200 — 960) *1675 (660 — 3100)*
N3	E	1,0 *1.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	800 (300 — 1400) *2625 (990 — 4500)*

Parametri di taglio – S4931 Contornatura sgrossatura – Pollici

SMG		a_e/DC	a_p/DC	f_z					v_c
				1/4	5/16	3/8	1/2	5/8	
N1	E	0,40 *0.40*	1,4 *1.4*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	950 (360 — 1700) *3125 (1200 — 5500)*
N2	E	0,40 *0.40*	1,4 *1.4*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	610 (240 — 1100) *2000 (790 — 3600)*
N3	E	0,40 *0.40*	1,4 *1.4*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	950 (360 — 1700) *3125 (1200 — 5500)*

Parametri di taglio – S4931 Scanalatura – Pollici

SMG		a_p/DC	f_z					v_c
			1/4	5/16	3/8	1/2	5/8	
N1	E	1,0 *1.0*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	810 (310 — 1500) *2650 (1100 — 4900)*
N2	E	1,0 *1.0*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	520 (200 — 970) *1700 (660 — 3100)*
N3	E	1,0 *1.0*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	810 (310 — 1500) *2650 (1100 — 4900)*

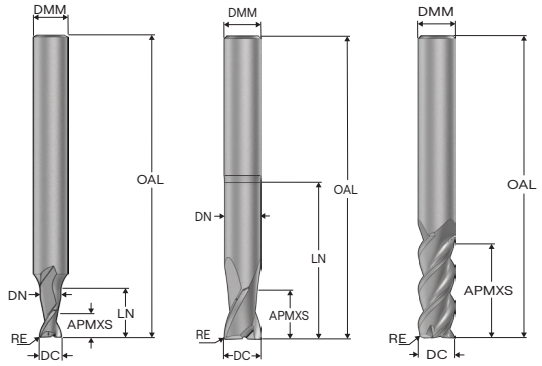
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

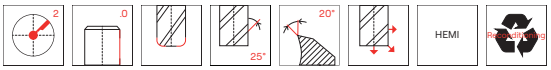
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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

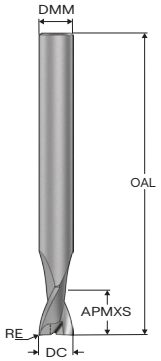
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
40K060-HEMI	00022089	1	D	6,0	6,0	13,0	50,0	–	–	0,1	–	2	Cylindrical	■
40K080-HEMI	00022090	1	D	8,0	8,0	13,0	50,0	–	–	0,1	–	2	Cylindrical	■
40K100-HEMI	00022091	1	D	10,0	10,0	16,0	50,0	–	–	0,1	–	2	Cylindrical	■
40K120-HEMI	00022092	1	D	12,0	12,0	16,0	65,0	–	–	0,1	–	2	Cylindrical	■
40020-HEMI	00022093	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,1	3,5	2	Cylindrical	■
40030-HEMI	00022094	2	E	3,0	3,0	4,0	40,0	8,0	2,9	0,1	–	2	Cylindrical	■
40040-HEMI	00022095	2	E	4,0	4,0	5,0	50,0	12,0	3,8	0,1	–	2	Cylindrical	■
40050-HEMI	00022120	2	E	5,0	5,0	8,0	50,0	14,0	4,8	0,1	–	2	Cylindrical	■
40060-HEMI	00022250	2	E	6,0	6,0	8,0	65,0	18,0	5,7	0,1	–	2	Cylindrical	■
40080-HEMI	00022580	2	E	8,0	8,0	10,0	70,0	22,0	7,7	0,1	–	2	Cylindrical	■
40100-HEMI	00022663	2	E	10,0	10,0	14,0	80,0	28,0	9,7	0,1	–	2	Cylindrical	■
40120-HEMI	00022667	2	E	12,0	12,0	16,0	90,0	35,0	11,5	0,1	–	2	Cylindrical	■
40160-HEMI	00022668	2	E	16,0	16,0	20,0	90,0	40,0	15,5	0,1	–	2	Cylindrical	■
40200-HEMI	00022701	2	E	20,0	20,0	25,0	100,0	50,0	19,5	0,1	–	2	Cylindrical	■

■ **Prodotto standard.**

JH40

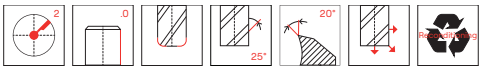
Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta





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	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
40020-RS	02479642	2	P	2,0	1,9	3,0	40,0	0,1	2	Cylindrical	■
40030-RS	02479643	2	P	3,0	2,9	4,0	60,0	0,1	2	Cylindrical	■
40040-RS	02479644	2	P	4,0	3,8	5,0	60,0	0,1	2	Cylindrical	■
40050-RS	02479645	2	P	5,0	4,8	8,0	70,0	0,1	2	Cylindrical	■
40060-RS	02479646	2	P	6,0	5,8	8,0	65,0	0,1	2	Cylindrical	■
40080-RS	02479647	2	P	8,0	7,8	10,0	70,0	0,1	2	Cylindrical	■
40100-RS	02479648	2	P	10,0	9,7	14,0	100,0	0,1	2	Cylindrical	■
40120-RS	02479649	2	P	12,0	11,7	16,0	90,0	0,1	2	Cylindrical	■
40L060-RS	02479650	3	P	6,0	5,8	8,0	100,0	0,1	2	Cylindrical	■
40L080-RS	02479651	3	P	8,0	7,8	10,0	100,0	0,1	2	Cylindrical	■
40L120-RS	02479652	3	P	12,0	11,7	16,0	125,0	0,1	2	Cylindrical	■
40L160-RS	02479653	3	P	16,0	15,7	20,0	125,0	0,1	2	Cylindrical	■
40L200-RS	02479654	3	P	20,0	19,7	25,0	125,0	0,1	2	Cylindrical	■

■ **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)*

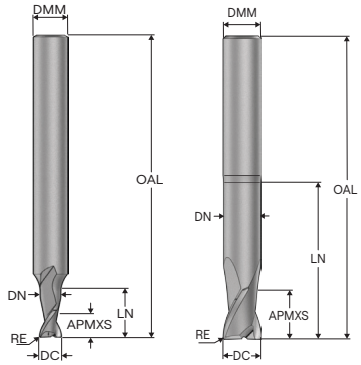
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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







– Tolleranze:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,05 mm
– Riaffilatura possibile se DC è ≥Ø6

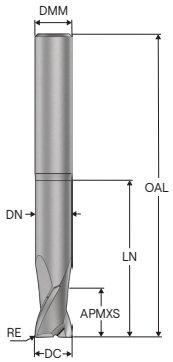
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm				
421020R020Z2-MEGA-T	02434927	2	G	–	2,0	3,0	3,0	40,0	8,0	1,8	0,2	3,0	2	Cylindrical	■
421030R020Z2-MEGA-T	02434939	2	E	–	3,0	3,0	4,0	40,0	12,0	2,7	0,2	–	2	Cylindrical	■
421040R020Z2-MEGA-T	02434940	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,2	3,0	2	Cylindrical	■
421040R030Z2-MEGA-T	02434941	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,3	3,0	2	Cylindrical	■
421050R100Z2-MEGA-T	02434942	2	G	–	5,0	6,0	6,0	50,0	18,0	4,5	1,0	1,5	2	Cylindrical	■
421060R025Z2-MEGA-T	02434946	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,25	–	2	Cylindrical	■
421060R050Z2-MEGA-T	02434947	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,5	–	2	Cylindrical	■
421060R100Z2-MEGA-T	02434958	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	1,0	–	2	Cylindrical	■
421080R030Z2-MEGA-T	02434960	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,3	–	2	Cylindrical	■
421080R060Z2-MEGA-T	02434964	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,6	–	2	Cylindrical	■
421080R100Z2-MEGA-T	02434967	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	1,0	–	2	Cylindrical	■
421100R030Z2-MEGA-T	02434968	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,3	–	2	Cylindrical	■
421100R080Z2-MEGA-T	02434970	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,8	–	2	Cylindrical	■
421100R150Z2-MEGA-T	02434971	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	1,5	–	2	Cylindrical	■
421100R250Z2-MEGA-T	02438614	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	2,5	–	2	Cylindrical	■
421100R310Z2-MEGA-T	02438683	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	3,1	–	2	Cylindrical	■
421120R030Z2-MEGA-T	02434983	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,3	–	2	Cylindrical	■
421120R050Z2-MEGA-T	02434986	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,5	–	2	Cylindrical	■
421120R100Z2-MEGA-T	02434988	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,0	–	2	Cylindrical	■
421120R150Z2-MEGA-T	02434989	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,5	–	2	Cylindrical	■
421120R200Z2-MEGA-T	02434990	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,0	–	2	Cylindrical	■
421120R250Z2AMEGA-T	02435008	2	E	■	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	Cylindrical	■
421120R250Z2-MEGA-T	02435007	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	Cylindrical	■
421120R310Z2-MEGA-T	02435009	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	3,1	–	2	Cylindrical	■

■ **Prodotto standard.**
ICC = Canale adduzione refrigerante interna

JH421

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta





E



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

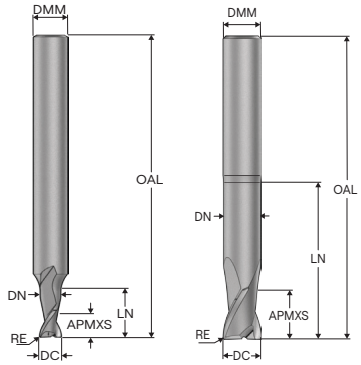
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
421160R050Z2-MEGA-T	02435010	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	0,5	2	Cylindrical	■
421160R200Z2-MEGA-T	02435014	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,0	2	Cylindrical	■
421160R250Z2AMEGA-T	02435020	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	Cylindrical	■
421160R250Z2-MEGA-T	02435012	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	Cylindrical	■
421160R310Z2-MEGA-T	02435036	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	3,1	2	Cylindrical	■
421160R400Z2AMEGA-T	02438684	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	Cylindrical	■
421160R400Z2-MEGA-T	02435039	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	Cylindrical	■
421200R160Z2-MEGA-T	02435042	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	1,6	2	Cylindrical	■
421200R200Z2-MEGA-T	02435044	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,0	2	Cylindrical	■
421200R250Z2AMEGA-T	02438685	2	E	■	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	Cylindrical	■
421200R250Z2-MEGA-T	02435046	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	Cylindrical	■
421200R310Z2-MEGA-T	02435049	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	3,1	2	Cylindrical	■
421200R400Z2-MEGA-T	02435051	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	4,0	2	Cylindrical	■
421200R500Z2-MEGA-T	02435055	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	5,0	2	Cylindrical	■

■ **Prodotto standard.**
ICC = Canale adduzione refrigerante interna

JH421

Alte prestazioni – Alluminio – Spallamento – 2 Eliche – Cilindrico – Raggio di punta





– 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	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					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	Cylindrical	■
421L100R050Z2-MEGA-T	02435070	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	0,5	2	Cylindrical	■
421L100R250Z2-MEGA-T	02435074	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	2,5	2	Cylindrical	■
421L100R310Z2-MEGA-T	02438690	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	3,1	2	Cylindrical	■
421L120R050Z2-MEGA-T	02435340	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	0,5	2	Cylindrical	■
421L120R100Z2-MEGA-T	02435343	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	1,0	2	Cylindrical	■
421L120R200Z2-MEGA-T	02435373	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,0	2	Cylindrical	■
421L120R250Z2-MEGA-T	02435374	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,5	2	Cylindrical	■
421L120R310Z2-MEGA-T	02438692	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	3,1	2	Cylindrical	■
421L160R050Z2-MEGA-T	02435375	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	0,5	2	Cylindrical	■
421L160R100Z2-MEGA-T	02435380	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	1,0	2	Cylindrical	■
421L160R200Z2-MEGA-T	02435381	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,0	2	Cylindrical	■
421L160R250Z2AMEGA-T	02435383	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	2,5	2	Cylindrical	■
421L160R250Z2-MEGA-T	02435382	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,5	2	Cylindrical	■
421L160R310Z2-MEGA-T	02435384	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	3,1	2	Cylindrical	■
421L160R400Z2AMEGA-T	02435386	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	4,0	2	Cylindrical	■
421L200R050Z2-MEGA-T	02435387	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	0,5	2	Cylindrical	■
421L200R200Z2-MEGA-T	02435391	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	2,0	2	Cylindrical	■
421L200R310Z2-MEGA-T	02435398	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	3,1	2	Cylindrical	■
421L200R500Z2-MEGA-T	02435401	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	5,0	2	Cylindrical	■

■ **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 *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*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	0.28 *0,011*	620 (520 — 720) *2025 (1800 — 2300)*
N11	E/M/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*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	410 (310 — 510) *1350 (1100 — 1600)*
TS1	A	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*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	0.28 *0,011*	620 (520 — 720) *2025 (1800 — 2300)*
TP1	M	0.400 *0,400*	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	0.24 *0,0095*	410 (310 — 500) *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 *0,50*	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*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	610 (510 — 700) *2000 (1700 — 2200)*
N11	E/M/A	0.50 *0,50*	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*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	405 (310 — 500) *1325 (1100 — 1600)*
TS1	A	0.50 *0,50*	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*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	610 (510 — 700) *2000 (1700 — 2200)*
TP1	M	0.50 *0,50*	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*	405 (310 — 500) *1325 (1100 — 1600)*

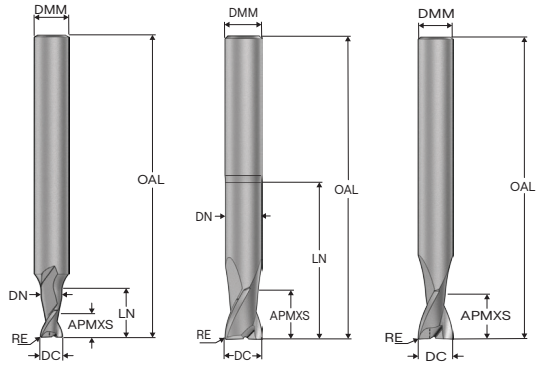
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

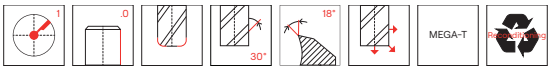
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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	DN	RE	RE2	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm	mm				
410020R050-MEGA-T	02451548	2	G	2,0	6,0	3,0	50,0	6,0	1,7	0,5	2,0	12,0	1	Cylindrical	■
410030R050-MEGA-T	02451578	2	G	3,0	6,0	4,0	50,0	8,0	2,7	0,5	2,0	7,5	1	Cylindrical	■
410ML030R050-MEGA-T	02451580	2	G	3,0	6,0	4,0	60,0	15,0	2,7	0,5	2,0	5,0	1	Cylindrical	■
410040R050-MEGA-T	02451581	2	G	4,0	6,0	5,0	60,0	8,0	3,6	0,5	2,0	5,5	1	Cylindrical	■
410ML040R050-MEGA-T	02451585	2	G	4,0	6,0	5,0	60,0	15,0	3,6	0,5	2,0	3,5	1	Cylindrical	■
410050R050-MEGA-T	02451586	2	G	5,0	6,0	7,0	65,0	11,0	4,5	0,5	2,0	2,5	1	Cylindrical	■
410ML050R050-MEGA-T	02451589	2	G	5,0	6,0	7,0	65,0	18,0	4,5	0,5	2,0	1,5	1	Cylindrical	■
410TL050R050-MEGA-T	02451587	2	G	5,0	6,0	7,0	65,0	26,0	4,5	0,5	2,0	1,5	1	Cylindrical	■
410060R050-MEGA-T	02451591	2	E	6,0	6,0	8,0	70,0	11,0	5,3	0,5	2,0	–	1	Cylindrical	■
410ML060R050-MEGA-T	02451593	2	E	6,0	6,0	8,0	70,0	18,0	5,3	0,5	2,0	–	1	Cylindrical	■
410TL060R050-MEGA-T	02451592	2	E	6,0	6,0	8,0	70,0	31,0	5,3	0,5	2,0	–	1	Cylindrical	■
410070RSR050-MEGA-T	02451594	2	P	7,0	6,0	9,0	65,0	–	–	0,5	3,0	–	1	Cylindrical	■
410090RSR050-MEGA-T	02451596	2	P	9,0	8,0	11,0	65,0	–	–	0,5	3,0	–	1	Cylindrical	■
410110RSR050-MEGA-T	02451598	2	P	11,0	10,0	13,0	70,0	–	–	0,5	3,0	–	1	Cylindrical	■
410130RSR100-MEGA-T	02451600	2	P	13,0	12,0	15,0	70,0	–	–	1,0	3,0	–	1	Cylindrical	■
410150RSR100-MEGA-T	02451603	2	P	15,0	14,0	17,0	80,0	–	–	1,0	3,0	–	1	Cylindrical	■
410170RSR100-MEGA-T	02451605	2	P	17,0	16,0	19,0	80,0	–	–	1,0	3,0	–	1	Cylindrical	■
410L070RSR200-MEGA-T	02451595	3	P	7,0	6,0	9,0	85,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L090RSR200-MEGA-T	02451597	3	P	9,0	8,0	11,0	85,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L110RSR200-MEGA-T	02451599	3	P	11,0	10,0	13,0	90,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L130RSR200-MEGA-T	02451601	3	P	13,0	12,0	15,0	90,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L150RSR200-MEGA-T	02451604	3	P	15,0	14,0	17,0	110,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L170RSR200-MEGA-T	02451606	3	P	17,0	16,0	19,0	110,0	–	–	2,0	3,0	–	1	Cylindrical	■

■ **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)*

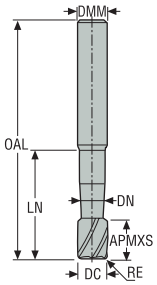
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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	NA°	PCEDC	Attacco	Prodotto standard
				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	2,09	2	Cylindrical	■
440080-MEGA-T	00022865	2	E	8,0	8,0	10,0	60,0	30,0	7,2	2,0	3,12	2	Cylindrical	■

Parametri di taglio – JH440 Copiatura sgrossatura

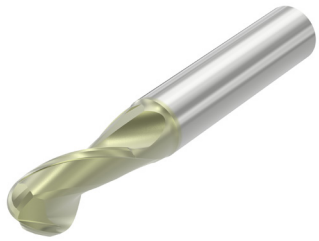
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
N1	E/M/A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
N2	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	510 (390 — 640) *1675 (1300 — 2000)*
N3	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	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)*

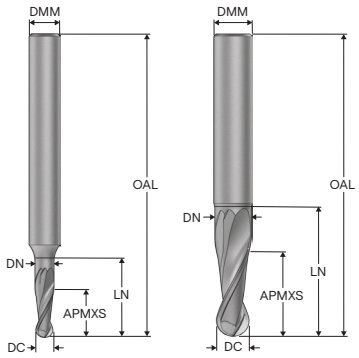
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

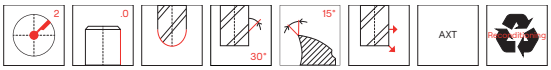
S4321

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





—Tolleranze:
—DMM=h5
—DC= e7
—RE= ±0,01 mm
—Riaffilatura possibile se DC è ≥Ø6

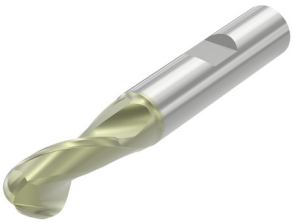


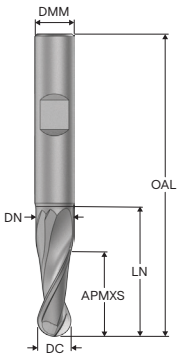
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4321-020G2B.0Z2	AXT	10228152	2	G	2,0	6,0	4,0	57,0	8,0	1,9	1,0	2	Cylindrical	■
S4321-030G2B.0Z2	AXT	10228153	2	G	3,0	6,0	6,0	57,0	10,0	2,85	1,5	2	Cylindrical	■
S4321-040G2B.0Z2	AXT	10228154	2	G	4,0	6,0	8,0	57,0	14,0	3,8	2,0	2	Cylindrical	■
S4321-050G2B.0Z2	AXT	10228155	2	G	5,0	6,0	10,0	57,0	17,0	4,75	2,5	2	Cylindrical	■
S4321-060E2B.0Z2	AXT	10228156	2	E	6,0	6,0	12,0	57,0	19,0	5,7	3,0	2	Cylindrical	■
S4321-080E2B.0Z2	AXT	10228157	2	E	8,0	8,0	16,0	63,0	24,0	7,6	4,0	2	Cylindrical	■
S4321-100E2B.0Z2	AXT	10228158	2	E	10,0	10,0	20,0	72,0	31,0	9,5	5,0	2	Cylindrical	■
S4321-120E2B.0Z2	AXT	10228159	2	E	12,0	12,0	24,0	88,0	37,0	11,4	6,0	2	Cylindrical	■
S4321-160E2B.0Z2	AXT	10228160	2	E	16,0	16,0	32,0	100,0	48,0	15,2	8,0	2	Cylindrical	■
S4321-200E2B.0Z2	AXT	10228161	2	E	20,0	20,0	40,0	114,0	60,0	19,0	10,0	2	Cylindrical	■

■ **Prodotto standard.**

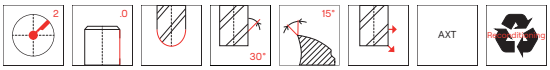
S4321

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





- Tolleranze:
- DMM=h5
- DC= e7
- 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	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
S4321-060E2B.3Z2	AXT	10287043	2	E	6,0	6,0	12,0	57,0	19,0	5,7	3,0	2	Weldon	☐
S4321-080E2B.3Z2	AXT	10287044	2	E	8,0	8,0	16,0	63,0	24,0	7,6	4,0	2	Weldon	☐
S4321-100E2B.3Z2	AXT	10287045	2	E	10,0	10,0	20,0	72,0	31,0	9,5	5,0	2	Weldon	☐
S4321-120E2B.3Z2	AXT	10287046	2	E	12,0	12,0	24,0	88,0	37,0	11,4	6,0	2	Weldon	☐
S4321-160E2B.3Z2	AXT	10287047	2	E	16,0	16,0	32,0	100,0	48,0	15,2	8,0	2	Weldon	☐
S4321-200E2B.3Z2	AXT	10287048	2	E	20,0	20,0	40,0	114,0	60,0	19,0	10,0	2	Weldon	☐

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

Parametri di taglio – S4321 Contornatura 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	0,30 *0.30*	1,5 *1.5*	0,020 *0.00080*	0,032 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	560 (510 — 680) *1825 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	1,5 *1.5*	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*	0,13 *0.0050*	0,15 *0.0060*	355 (270 — 440) *1175 (890 — 1400)*
N3	E/M/A	0,30 *0.30*	1,5 *1.5*	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*	0,13 *0.0050*	0,15 *0.0060*	235 (180 — 290) *770 (600 — 950)*
TS1	A/D	0,30 *0.30*	1,5 *1.5*	0,022 *0.00085*	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*	0,17 *0.0065*	0,19 *0.0075*	670 (560 — 770) *2200 (1900 — 2500)*
TP1	A/D	0,30 *0.30*	1,5 *1.5*	0,0036 *0.00014*	0,0050 *0.00020*	0,0070 *0.00028*	0,0090 *0.00036*	0,010 *0.00040*	0,014 *0.00055*	0,018 *0.00070*	0,020 *0.00080*	0,028 *0.0011*	0,036 *0.0014*	460 (350 — 570) *1500 (1200 — 1800)*

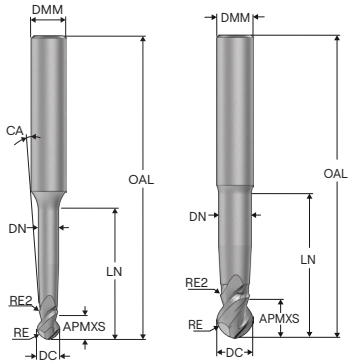
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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	RE	RE2	CA°	NA°	PCEDC	Attacco	Prodotto standard
				mm	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	1,0	3,0	2,24	2	Cylindrical	■
450030-MEGA-T	00022978	2	E	3,0	3,0	2,5	40,0	12,0	2,7	1,5	2,0	–	2,497	2	Cylindrical	■
450040-MEGA-T	00022979	2	G	4,0	6,0	3,5	50,0	21,0	3,6	2,0	2,0	3,0	5,053	2	Cylindrical	■
450050-MEGA-T	00022980	2	G	5,0	6,0	4,5	50,0	22,5	4,5	2,5	2,0	2,0	3,576	2	Cylindrical	■
450060-MEGA-T	00023020	2	E	6,0	6,0	5,5	55,0	25,0	5,4	3,0	2,0	–	2,465	2	Cylindrical	■
450080-MEGA-T	00023032	2	E	8,0	8,0	7,0	65,0	30,0	7,2	4,0	2,0	–	2,491	2	Cylindrical	■
450100-MEGA-T	00023040	2	E	10,0	10,0	8,5	75,0	35,0	9,0	5,0	3,0	–	3,086	2	Cylindrical	■
450120-MEGA-T	00029842	2	E	12,0	12,0	10,5	75,0	40,0	11,0	6,0	3,0	–	2,735	2	Cylindrical	■
450160-MEGA-T	00023050	2	E	16,0	16,0	14,0	90,0	50,0	14,5	8,0	4,0	–	3,45	2	Cylindrical	■
450200-MEGA-T	00023053	2	E	20,0	20,0	17,0	100,0	50,0	18,0	10,0	4,0	–	5,321	2	Cylindrical	■
450L100-MEGA-T	00023056	3	G	10,0	12,0	8,5	125,0	50,0	9,0	5,0	3,0	1,5	3,16	2	Cylindrical	■
450L120-MEGA-T	00023091	3	E	12,0	12,0	10,5	150,0	60,0	11,0	6,0	3,0	–	2,79	2	Cylindrical	■
450L160-MEGA-T	00023095	3	E	16,0	16,0	14,0	150,0	70,0	14,5	8,0	4,0	–	3,51	2	Cylindrical	■

■ **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)*

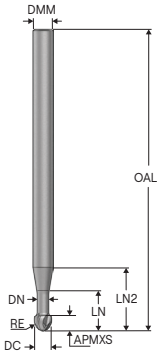
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

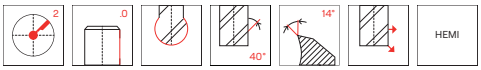
JH460

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	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
460030-HEMI	00040372	2	E	3,0	3,0	2,3	60,0	4,8	1,5	1,5	2	Cylindrical	■
460040-HEMI	00040373	2	E	4,0	4,0	3,1	60,0	5,6	2,0	2,0	2	Cylindrical	■
460050-HEMI	00040376	2	E	5,0	5,0	3,9	70,0	6,4	2,5	2,5	2	Cylindrical	■
460060-HEMI	00040377	2	E	6,0	6,0	4,7	80,0	9,7	3,0	3,0	2	Cylindrical	■
460080-HEMI	00040378	2	E	8,0	8,0	6,2	85,0	11,2	4,0	4,0	2	Cylindrical	■
460100-HEMI	00040379	2	E	10,0	10,0	7,8	100,0	15,6	5,0	5,0	2	Cylindrical	■
460120-HEMI	00040380	2	E	12,0	12,0	9,4	125,0	17,2	6,0	6,0	2	Cylindrical	■

■ **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)*

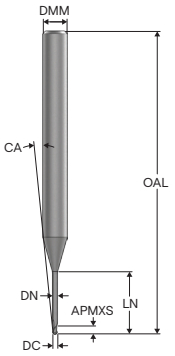
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

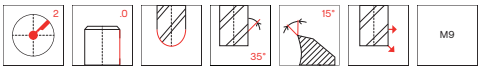
SMB413/414/416

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	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm				
SMB414020G4B.0Z2	M9	10109139	4	G	2,0	4,0	2,0	50,0	12,0	1,9	1,0	3,75	2	Cylindrical	■
SMB414030G4B.0Z2	M9	10109140	4	G	3,0	4,0	3,0	50,0	16,0	2,85	1,5	1,68	2	Cylindrical	■
SMB413025G5B.0Z2	M9	10109136	5	G	2,5	3,0	2,5	50,0	20,0	2,4	1,25	0,71	2	Cylindrical	■
SMB414025G5B.0Z2	M9	10109141	5	G	2,5	4,0	2,5	50,0	20,0	2,4	1,25	1,94	2	Cylindrical	■
SMB416025G5B.0Z2	M9	10109145	5	G	2,5	6,0	1,0	55,0	20,0	0,95	1,25	3,87	2	Cylindrical	■
SMB414010G6B.0Z2	M9	10109142	6	G	1,0	4,0	1,0	50,0	10,0	0,95	0,5	5,5	2	Cylindrical	■
SMB413015G6B.0Z2	M9	10109137	6	G	1,5	3,0	1,5	50,0	20,0	1,4	0,75	1,9	2	Cylindrical	■
SMB414015G6B.0Z2	–	10109388	6	G	1,5	4,0	2,5	55,0	20,0	2,4	0,75	2,92	2	Cylindrical	■
SMB414015G6B.0Z2	M9	10109143	6	G	1,5	4,0	1,5	55,0	20,0	1,4	0,75	2,92	2	Cylindrical	■
SMB416015G6B.0Z2	M9	10109146	6	G	1,5	6,0	1,5	55,0	20,0	1,4	0,75	4,56	2	Cylindrical	■
SMB413010G7B.0Z2	M9	10109138	7	G	1,0	3,0	1,0	50,0	18,0	0,95	0,5	2,63	2	Cylindrical	■
SMB414010G7B.0Z2	M9	10109144	7	G	1,0	4,0	1,0	50,0	18,0	0,95	0,5	3,64	2	Cylindrical	■
SMB416010G7B.0Z2	M9	10109147	7	G	1,0	6,0	1,0	55,0	18,0	0,95	0,5	5,23	2	Cylindrical	■

■ **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)*

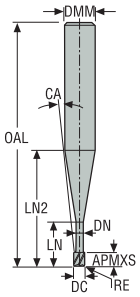
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

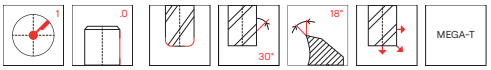
Miniaturizzato – Alluminio – Spallamento – 1 Elica – Cilindrico – Raggio di punta





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	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
403ML005R005-MEGA-T	02568434	2	G	0,5	3,0	0,5	40,0	1,5	0,45	0,05	11,0	1	Cylindrical	■
403ML008R005-MEGA-T	02568450	2	G	0,8	3,0	0,8	40,0	2,5	0,75	0,05	9,0	1	Cylindrical	■
403ML010R010-MEGA-T	02568456	2	G	1,0	3,0	1,0	40,0	4,0	0,95	0,1	7,5	1	Cylindrical	■
406ML015R010-MEGA-T	02568478	5	G	1,5	6,0	1,5	50,0	5,0	1,4	0,1	9,5	1	Cylindrical	■
404ML020R010-MEGA-T	02577246	5	G	2,0	4,0	2,0	40,0	6,0	1,9	0,1	6,0	1	Cylindrical	■

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

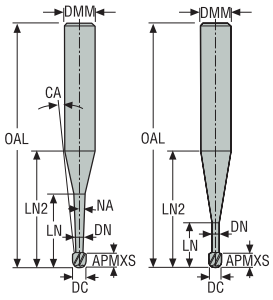
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

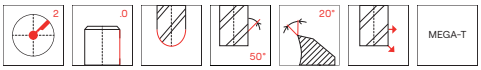
JM413/JM416

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	DN	RE	CA°	NA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm					
413ML005TN-MEGA-T	02568709	2	J	0,5	3,0	0,375	40,0	1,5	0,45	0,25	11,5	0,9	2	Cylindrical	■
413L005-MEGA-T	02568711	3	G	0,5	3,0	0,375	40,0	2,5	0,45	0,25	10,0	–	2	Cylindrical	■
413L008-MEGA-T	02568727	3	G	0,8	3,0	0,6	40,0	4,0	0,75	0,4	8,0	–	2	Cylindrical	■
413L010-MEGA-T	02568736	3	G	1,0	3,0	0,75	40,0	5,0	0,95	0,5	7,0	–	2	Cylindrical	■
416L015-MEGA-T	02568772	3	G	1,5	6,0	1,125	50,0	7,5	1,4	0,75	8,5	–	2	Cylindrical	■
416L020-MEGA-T	02568779	3	G	2,0	6,0	1,5	50,0	10,0	1,9	1,0	7,0	–	2	Cylindrical	■

■ **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 699 - 707

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.		501	504	507	509	226, 511	303, 514
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
CSP			■				
	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

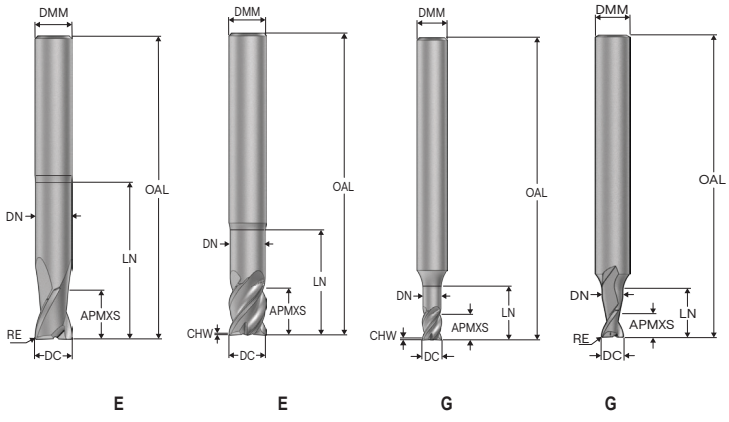
							
Nome		JH112	JH150	JH160	JME142	JME144	JMB112
Pag.		313, 517	520	522	524	529	531
Famiglia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Tipo di fresa							
Attacco	Cilindrico	■	■	■	■	■	■
	Weldon						
Numero di eliche		2	4	4	2	4	2
CSP							
	Metrico	2-12	6-12	3-12	0,2-3,0	1,0-3,0	0,2-3,0
	Pollici						
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		●	●	●	●	●	●

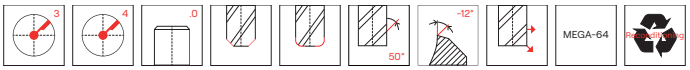
■ Prodotto standard □ Weldon disponibile, tempo di consegna 3 giorni.
● Prima scelta ○ Scelta alternativa

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

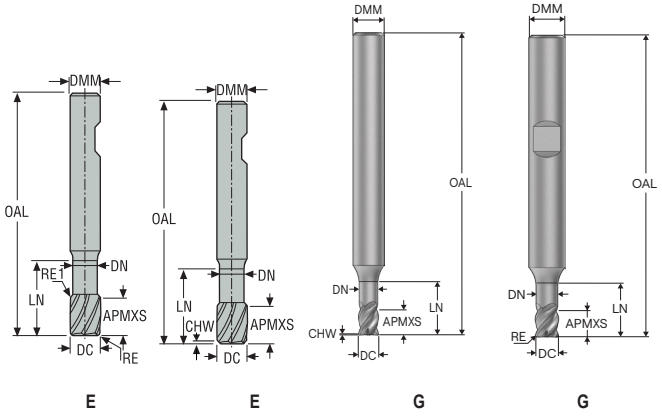
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm	mm				
170020.0-MEGA-64	02462685	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	Cylindrical	■
170020R020.0-MEGA-64	02587615	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	14,5	3	Cylindrical	■
170020R050.0-MEGA-64	02587617	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	15,0	3	Cylindrical	■
170030.0-MEGA-64	02462686	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	Cylindrical	■
170030R020.0-MEGA-64	02587618	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	9,5	3	Cylindrical	■
170030R050.0-MEGA-64	02587619	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	9,5	3	Cylindrical	■
170040.0-MEGA-64	02462687	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	Cylindrical	■
170040R020.0-MEGA-64	02587620	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	5,5	4	Cylindrical	■
170040R050.0-MEGA-64	02587621	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	5,5	4	Cylindrical	■
170050.0-MEGA-64	02462688	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	Cylindrical	■
170050R020.0-MEGA-64	02587622	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	2,5	4	Cylindrical	■
170050R050.0-MEGA-64	02587623	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	2,5	4	Cylindrical	■
170060.0-MEGA-64	02462689	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	Cylindrical	■
170060R020.0-MEGA-64	02587624	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	Cylindrical	■
170060R050.0-MEGA-64	02587625	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	Cylindrical	■
170080.0-MEGA-64	02462690	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	Cylindrical	■
170080R020.0-MEGA-64	02587626	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	Cylindrical	■
170080R050.0-MEGA-64	02587627	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	Cylindrical	■
170080R100.0-MEGA-64	02587628	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	Cylindrical	■
170100.0-MEGA-64	02462691	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	Cylindrical	■
170100R050.0-MEGA-64	02587629	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	Cylindrical	■
170100R100.0-MEGA-64	02587630	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	Cylindrical	■
170120.0-MEGA-64	02462692	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	Cylindrical	■
170120R050.0-MEGA-64	02587631	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	Cylindrical	■
170120R100.0-MEGA-64	02587632	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	Cylindrical	■
170160.0-MEGA-64	02462693	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	Cylindrical	■
170160R050.0-MEGA-64	02587633	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	Cylindrical	■

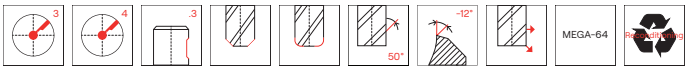
■ **Prodotto standard.**

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	Attacco	Prodotto standard
				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	Weldon	■
170020R020.0-MEGA-64W	02669319	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	–	3	Weldon	□
170020R050.0-MEGA-64W	02669320	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	–	3	Weldon	□
170030-MEGA-64	02452925	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	Weldon	■
170030R020.0-MEGA-64W	02669321	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	–	3	Weldon	□
170030R050.0-MEGA-64W	02669322	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	–	3	Weldon	□
170040-MEGA-64	02452927	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	Weldon	■
170040R020.0-MEGA-64W	02669323	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	–	4	Weldon	□
170040R050.0-MEGA-64W	02669324	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	–	4	Weldon	□
170050-MEGA-64	02452928	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	Weldon	■
170050R020.0-MEGA-64W	02669325	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	–	4	Weldon	□
170050R050.0-MEGA-64W	02669326	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	–	4	Weldon	□
170060-MEGA-64	02452929	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	Weldon	■
170060R020.0-MEGA-64W	02669327	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	Weldon	□
170060R050.0-MEGA-64W	02669328	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	Weldon	□
170080-MEGA-64	02452930	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	Weldon	■
170080R020.0-MEGA-64W	02669329	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	Weldon	□
170080R050.0-MEGA-64W	02669331	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	Weldon	□
170080R100.0-MEGA-64W	02669332	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	Weldon	□
170100-MEGA-64	02452931	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	Weldon	■
170100R050.0-MEGA-64W	02669333	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	Weldon	□
170100R100.0-MEGA-64W	02669334	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	Weldon	□
170120-MEGA-64	02452932	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	Weldon	■
170120R050.0-MEGA-64W	02669335	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	Weldon	□
170120R100.0-MEGA-64W	02669336	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	Weldon	□
170160-MEGA-64	02452933	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	Weldon	■
170160R050.0-MEGA-64W	02669337	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	Weldon	□
170200R050-MEGA-64	02611637	2	E	20,0	20,0	20,0	100,0	40,0	19,2	–	0,5	–	4	Weldon	■

■ **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)*

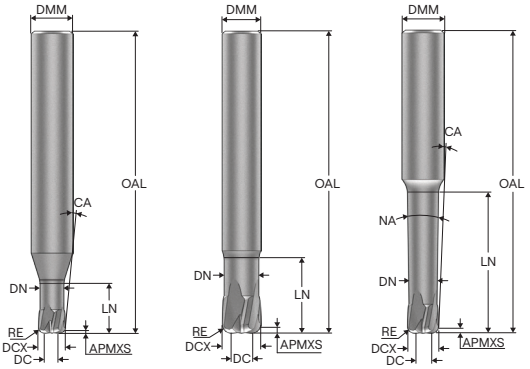
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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





– 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	CSP	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Attacco	Prodotto standard
					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	0,5	10,0	–	4	Cylindrical	■
JHF181030G1R075.0Z4-HXT	03067298	1	G	–	3,0	1,5	6,0	0,75	50,0	6,0	2,7	0,75	7,5	–	4	Cylindrical	■
JHF181040G1R100.0Z4-HXT	03067299	1	G	–	4,0	2,0	6,0	1,0	50,0	8,0	3,6	1,0	5,0	–	4	Cylindrical	■
JHF181060E1R150.0Z4-HXT	03067300	1	E	–	6,0	3,0	6,0	1,5	50,0	12,0	5,4	1,5	–	–	4	Cylindrical	■
JHF181080E1R200.0Z4-HXT	03067301	1	E	–	8,0	4,0	8,0	2,0	55,0	16,0	7,3	2,0	–	–	4	Cylindrical	■
JHF181100E1R200.0Z4-HXT	03067302	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	2,0	–	–	4	Cylindrical	■
JHF181100E1R200.0Z5-HXT	03067303	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	2,0	–	–	5	Cylindrical	■
JHF181120E1R300.0Z4-HXT	03067304	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	3,0	–	–	4	Cylindrical	■
JHF181120E1R300.0Z5-HXT	03067305	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	3,0	–	–	5	Cylindrical	■
JHF181160E1R300.0Z4-HXT	03067306	1	E	–	16,0	10,0	16,0	3,0	80,0	32,0	14,8	3,0	–	–	4	Cylindrical	■
JHF181020G2R050.0Z4-HXT	03067307	2	G	–	2,0	1,0	6,0	0,5	50,0	8,0	1,8	0,5	7,5	–	4	Cylindrical	■
JHF181030G2R075.0Z4-HXT	03067308	2	G	–	3,0	1,5	6,0	0,75	50,0	12,0	2,7	0,75	5,0	–	4	Cylindrical	■
JHF181040G2R100.0Z4-HXT	03067309	2	G	–	4,0	2,0	6,0	1,0	50,0	16,0	3,6	1,0	3,0	–	4	Cylindrical	■
JHF181060E2R150.0Z4A-HXT	03067311	2	E	■	6,0	3,0	6,0	1,5	65,0	24,0	5,4	1,5	–	–	4	Cylindrical	■
JHF181060E2R150.0Z4-HXT	03067310	2	E	–	6,0	3,0	6,0	1,5	65,0	24,0	5,4	1,5	–	–	4	Cylindrical	■
JHF181080E2R200.0Z4A-HXT	03067313	2	E	■	8,0	4,0	8,0	2,0	70,0	32,0	7,3	2,0	–	–	4	Cylindrical	■
JHF181080E2R200.0Z4-HXT	03067312	2	E	–	8,0	4,0	8,0	2,0	70,0	32,0	7,3	2,0	–	–	4	Cylindrical	■
JHF181100E2R200.0Z4A-HXT	03067315	2	E	■	10,0	6,0	10,0	2,0	85,0	40,0	9,2	2,0	–	–	4	Cylindrical	■
JHF181100E2R200.0Z4-HXT	03067314	2	E	–	10,0	6,0	10,0	2,0	85,0	40,0	9,2	2,0	–	–	4	Cylindrical	■
JHF181120E2R300.0Z4A-HXT	03067317	2	E	■	12,0	6,0	12,0	3,0	100,0	48,0	11,0	3,0	–	–	4	Cylindrical	■
JHF181120E2R300.0Z4-HXT	03067316	2	E	–	12,0	6,0	12,0	3,0	100,0	48,0	11,0	3,0	–	–	4	Cylindrical	■
JHF181020J3R050.0Z4-HXT	03067318	3	J	–	2,0	1,0	6,0	0,5	50,0	10,0	1,8	0,5	6,8	0,9	4	Cylindrical	■
JHF181030J3R075.0Z4-HXT	03067319	3	J	–	3,0	1,5	6,0	0,75	50,0	15,0	2,7	0,75	4,4	0,9	4	Cylindrical	■
JHF181040J3R100.0Z4-HXT	03067320	3	J	–	4,0	2,0	6,0	1,0	60,0	20,0	3,6	1,0	2,6	0,9	4	Cylindrical	■
JHF181060J3R150.0Z4-HXT	03067321	3	J	–	6,0	3,0	8,0	1,5	65,0	30,0	5,4	1,5	1,9	0,9	4	Cylindrical	■
JHF181080J3R200.0Z4-HXT	03067325	3	J	–	8,0	4,0	10,0	2,0	85,0	40,0	7,3	2,0	1,5	0,9	4	Cylindrical	■
JHF181100J3R200.0Z4-HXT	03067327	3	J	–	10,0	6,0	12,0	2,0	100,0	50,0	9,2	2,0	1,2	0,9	4	Cylindrical	■
JHF181020J4R050.0Z3-HXT	03067329	4	J	–	2,0	1,0	6,0	0,5	50,0	14,0	1,8	0,5	5,6	0,9	3	Cylindrical	■
JHF181030J4R075.0Z3-HXT	03067330	4	J	–	3,0	1,5	6,0	0,75	60,0	21,0	2,7	0,75	3,4	0,9	3	Cylindrical	■
JHF181040J4R100.0Z3-HXT	03067331	4	J	–	4,0	2,0	6,0	1,0	65,0	28,0	3,6	1,0	2,0	0,9	3	Cylindrical	■
JHF181060J4R150.0Z3-HXT	03067332	4	J	–	6,0	3,0	8,0	1,5	80,0	42,0	5,4	1,5	1,4	0,9	3	Cylindrical	■
JHF181080J4R200.0Z3-HXT	03067333	4	J	–	8,0	4,0	10,0	2,0	100,0	56,0	7,3	2,0	1,1	0,9	3	Cylindrical	■
JHF181100J4R200.0Z3-HXT	03067334	4	J	–	10,0	6,0	12,0	2,0	125,0	70,0	9,2	2,0	0,9	0,9	3	Cylindrical	■

■ **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 699 - 707

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)*

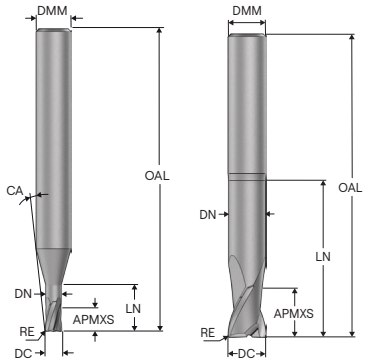
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

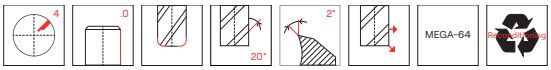
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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	Attacco	Prodotto standard
				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	Cylindrical	■
120025-MEGA-64	00019448	2	G	2,5	6,0	3,0	50,0	6,0	2,4	0,25	8,5	4	Cylindrical	■
120030-MEGA-64	00019450	2	G	3,0	6,0	4,0	50,0	7,0	2,8	0,3	7,0	4	Cylindrical	■
120035-MEGA-64	00019460	2	G	3,5	6,0	4,5	50,0	8,0	3,2	0,35	5,5	4	Cylindrical	■
120040-MEGA-64	00019462	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,4	4,5	4	Cylindrical	■
120050-MEGA-64	00019476	2	G	5,0	6,0	6,0	50,0	12,0	4,6	0,5	2,5	4	Cylindrical	■
120060-MEGA-64	00019479	2	E	6,0	6,0	7,0	55,0	14,0	5,6	0,6	–	4	Cylindrical	■
120080-MEGA-64	00019481	2	E	8,0	8,0	10,0	60,0	18,0	7,4	0,8	–	4	Cylindrical	■
120100-MEGA-64	00019494	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	4	Cylindrical	■
120120-MEGA-64	00019501	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,2	–	4	Cylindrical	■
120160-MEGA-64	00019503	2	E	16,0	16,0	18,0	90,0	35,0	15,4	1,6	–	4	Cylindrical	■

■ **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)*

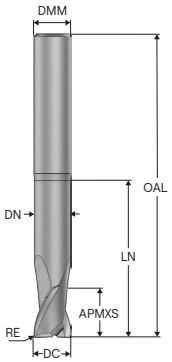
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

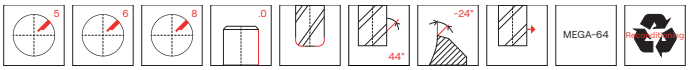
Alta velocità – Acciaio temprato – Spallamento – 5-8 Eliche – Cilindrico – Raggio di punta





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	Attacco	Prodotto standard
				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	Cylindrical	■
130080-MEGA-64	00019507	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,2	5	Cylindrical	■
130100-MEGA-64	00019511	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,3	6	Cylindrical	■
130120-MEGA-64	00019512	2	E	12,0	12,0	12,0	80,0	24,0	11,4	0,5	6	Cylindrical	■
130160-MEGA-64	00019514	2	E	16,0	16,0	16,0	90,0	30,0	15,4	0,5	8	Cylindrical	■
130200-MEGA-64	00019542	2	E	20,0	20,0	20,0	100,0	35,0	19,2	0,5	8	Cylindrical	■

■ **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)*

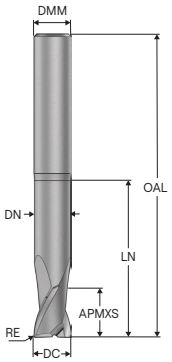
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

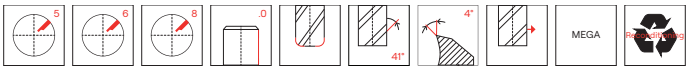
Alta velocità – Universale – Spallamento – 5-8 Eliche – Cilindrico – Raggio di punta





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	Attacco	Prodotto standard
				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	Cylindrical	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	Cylindrical	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	Cylindrical	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	Cylindrical	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	Cylindrical	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	Cylindrical	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	Cylindrical	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	Cylindrical	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	Cylindrical	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	Cylindrical	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	Cylindrical	■

■ **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)*

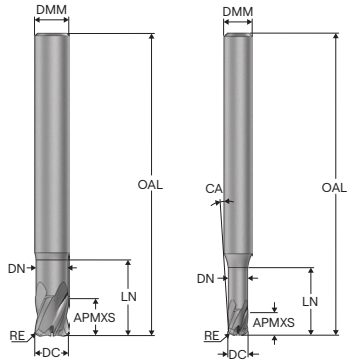
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

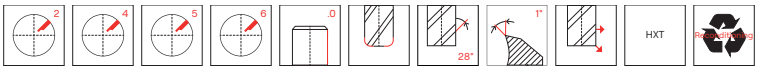
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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

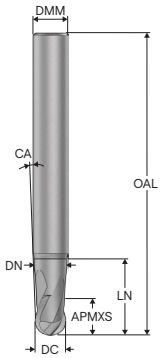
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	Cylindrical	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0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

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

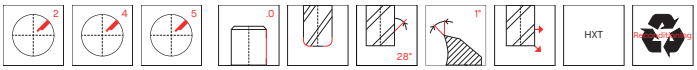
JH142

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

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

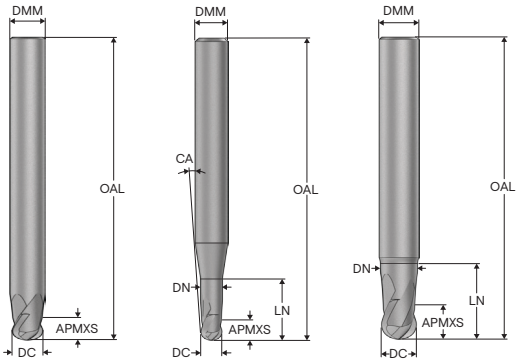
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

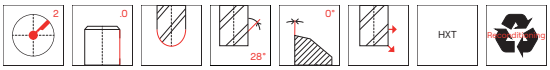
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

JH112

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







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

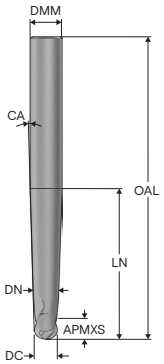
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm				
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	1,0	6,45	2	Cylindrical	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	1,5	3,3	2	Cylindrical	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	2,0	–	2	Cylindrical	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	3,0	–	2	Cylindrical	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	4,0	–	2	Cylindrical	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	5,0	–	2	Cylindrical	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	1,5	–	2	Cylindrical	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	2,0	–	2	Cylindrical	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	2,5	–	2	Cylindrical	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	3,0	–	2	Cylindrical	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	1,0	8,12	2	Cylindrical	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	1,25	7,39	2	Cylindrical	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	1,75	3,81	2	Cylindrical	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	2,0	3,34	2	Cylindrical	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	3,0	2,78	2	Cylindrical	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	4,0	–	2	Cylindrical	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	5,0	–	2	Cylindrical	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	6,0	–	2	Cylindrical	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	1,0	3,82	2	Cylindrical	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	1,5	2,91	2	Cylindrical	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	2,0	1,97	2	Cylindrical	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	2,5	0,53	2	Cylindrical	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	3,0	–	2	Cylindrical	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	4,0	–	2	Cylindrical	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	5,0	–	2	Cylindrical	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	6,0	–	2	Cylindrical	■

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

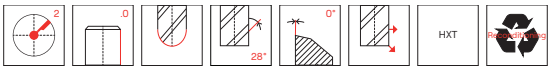
JH112

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	LN	DN	RE	CA°	NA°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm					
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	35,0	1,9	1,0	3,3	3,55	2	Cylindrical	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	40,0	2,8	1,5	2,2	2,5	2	Cylindrical	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	52,0	3,7	2,0	1,2	1,4	2	Cylindrical	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	56,0	4,6	2,5	1,6	1,95	2	Cylindrical	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	56,0	5,6	3,0	1,1	1,4	2	Cylindrical	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	62,0	7,4	4,0	1,0	1,43	2	Cylindrical	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	61,0	9,4	5,0	1,0	1,5	2	Cylindrical	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	62,0	5,6	3,0	2,0	2,3	2	Cylindrical	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	67,0	7,4	4,0	1,8	2,3	2	Cylindrical	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	79,0	9,4	5,0	0,8	1,1	2	Cylindrical	■

■ **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 699 - 707

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

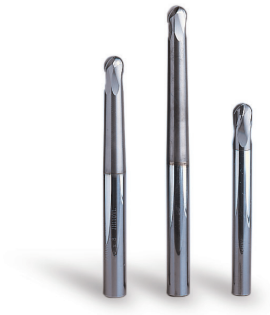
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100 — 1400)*
K2	E	0.250 *0,250*	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)*

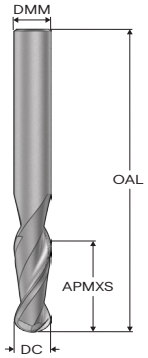
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

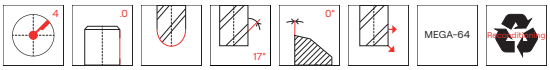
Alta velocità – Acciaio temprato – A testa sferica – 4 Eliche – Cilindrico





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	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	3,0	4	Cylindrical	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4,0	4	Cylindrical	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	5,0	4	Cylindrical	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	6,0	4	Cylindrical	■

■ **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)*

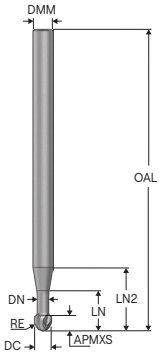
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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	DN	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	1,8	1,5	4	Cylindrical	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	2,4	2,0	4	Cylindrical	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	3,0	2,5	4	Cylindrical	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	3,6	3,0	4	Cylindrical	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	4,8	4,0	4	Cylindrical	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	6,0	5,0	4	Cylindrical	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	7,2	6,0	4	Cylindrical	■

■ **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)*

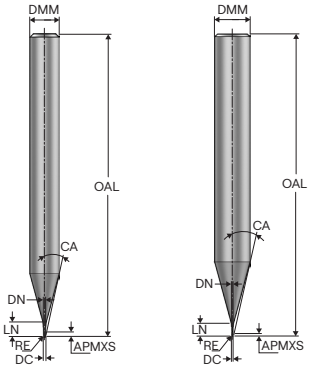
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

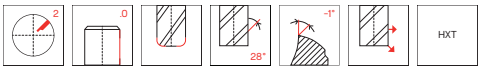
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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

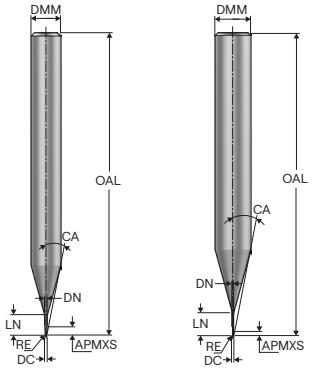
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm						
JME142002G1R005Z2.0-HXT	03205080	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,05	15,12	–	-1,0	2	Cylindrical	■
JME142003G1R005Z2.0-HXT	03205082	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,05	14,77	–	-1,0	2	Cylindrical	■
JME142004G1R005Z2.0-HXT	03205084	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,05	14,39	–	-1,0	2	Cylindrical	■
JME142005G1R005Z2.0-HXT	03205086	1	G	0,5	4,0	0,375	40,0	0,75	0,46	0,05	14,01	–	-1,0	2	Cylindrical	■
JME142006G1R005Z2.0-HXT	03205099	1	G	0,6	4,0	0,45	40,0	0,9	0,56	0,05	13,67	–	-1,0	2	Cylindrical	■
JME142008G1R005Z2.0-HXT	03205121	1	G	0,8	6,0	0,6	50,0	1,2	0,76	0,05	13,98	–	-1,0	2	Cylindrical	■
JME142010G1R005Z2.0-HXT	03205139	1	G	1,0	6,0	0,75	50,0	1,5	0,95	0,05	13,49	–	-1,0	2	Cylindrical	■
JME142012G1R005Z2.0-HXT	03205151	1	G	1,2	6,0	0,9	50,0	1,8	1,15	0,05	13,02	–	-1,0	2	Cylindrical	■
JME142015G1R005Z2.0-HXT	03205161	1	G	1,5	6,0	1,125	50,0	2,25	1,45	0,05	12,3	–	-1,0	2	Cylindrical	■
JME142002J2R005Z2.0-HXT	03205081	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,05	14,23	0,9	-1,0	2	Cylindrical	■
JME142003J2R005Z2.0-HXT	03205083	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,05	13,67	0,9	-1,0	2	Cylindrical	■
JME142004J2R005Z2.0-HXT	03205085	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,05	13,1	0,9	-1,0	2	Cylindrical	■
JME142005J2R005Z2.0-HXT	03205087	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,05	12,54	0,9	-1,0	2	Cylindrical	■
JME142005J2R010Z2.0-HXT	03205093	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,1	12,61	0,9	-1,0	2	Cylindrical	■
JME142005G2R005Z2.0-HXT	03205088	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,05	13,5	–	-1,0	2	Cylindrical	■
JME142005G2R010Z2.0-HXT	03205094	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,1	13,55	–	-1,0	2	Cylindrical	■
JME142006J2R005Z2.0-HXT	03205100	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,05	11,76	0,9	-1,0	2	Cylindrical	■
JME142006J2R010Z2.0-HXT	03205107	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,1	11,83	0,9	-1,0	2	Cylindrical	■
JME142006G2R005Z2.0-HXT	03205101	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,05	9,48	–	-1,0	2	Cylindrical	■
JME142006G2R010Z2.0-HXT	03205108	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,1	9,51	–	-1,0	2	Cylindrical	■
JME142008J2R005Z2.0-HXT	03205122	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,05	10,92	0,9	-1,0	2	Cylindrical	■
JME142008J2R010Z2.0-HXT	03205129	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,1	10,98	0,9	-1,0	2	Cylindrical	■
JME142008J2R020Z2.0-HXT	03205135	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,2	11,1	0,9	-1,0	2	Cylindrical	■
JME142008G2R005Z2.0-HXT	03205123	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,05	9,15	–	-1,0	2	Cylindrical	■
JME142008G2R010Z2.0-HXT	03205130	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,1	9,17	–	-1,0	2	Cylindrical	■
JME142008G2R020Z2.0-HXT	03205136	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,2	9,22	–	-1,0	2	Cylindrical	■
JME142010G2R005Z2.0-HXT	03205140	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,05	8,29	–	-1,0	2	Cylindrical	■
JME142010G2R010Z2.0-HXT	03205145	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,1	8,31	–	-1,0	2	Cylindrical	■
JME142010G2R020Z2.0-HXT	03205148	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,2	8,36	–	-1,0	2	Cylindrical	■
JME142012G2R005Z2.0-HXT	03205152	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,05	7,97	–	-1,0	2	Cylindrical	■
JME142012G2R010Z2.0-HXT	03205155	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,1	7,99	–	-1,0	2	Cylindrical	■
JME142012G2R020Z2.0-HXT	03205158	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,2	8,04	–	-1,0	2	Cylindrical	■
JME142015G2R005Z2.0-HXT	03205162	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,05	7,6	–	-1,0	2	Cylindrical	■
JME142015G2R010Z2.0-HXT	03205167	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,1	9,7	–	-1,0	2	Cylindrical	■
JME142015G2R020Z2.0-HXT	03205171	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,2	9,76	–	-1,0	2	Cylindrical	■

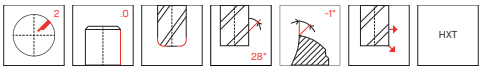
■ **Prodotto standard.**
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

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

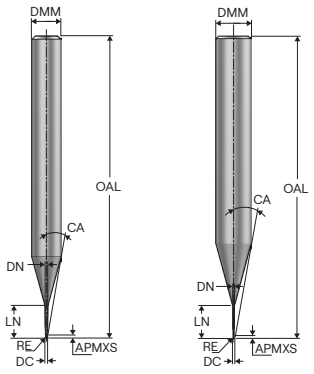
Codice di ordinazione	Codice prodotto	Indice di lung-hezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm						
JME142020G2R005Z2.0-HXT	03205180	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,05	8,52	–	-1,0	2	Cylindrical	■
JME142020G2R010Z2.0-HXT	03205185	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,1	8,55	–	-1,0	2	Cylindrical	■
JME142020G2R020Z2.0-HXT	03205188	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,2	8,6	–	-1,0	2	Cylindrical	■
JME142020G2R030Z2.0-HXT	03205191	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,3	8,66	–	-1,0	2	Cylindrical	■
JME142030G2R005Z2.0-HXT	03205201	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,05	5,81	–	-1,0	2	Cylindrical	■
JME142005J3R005Z2.0-HXT	03205089	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,05	11,24	0,9	-1,0	2	Cylindrical	■
JME142005J3R010Z2.0-HXT	03205095	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,1	11,29	0,9	-1,0	2	Cylindrical	■
JME142005G3R005Z2.0-HXT	03205090	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,05	11,55	–	-1,0	2	Cylindrical	■
JME142005G3R010Z2.0-HXT	03205096	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,1	11,59	–	-1,0	2	Cylindrical	■
JME142006J3R005Z2.0-HXT	03205103	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,05	10,58	0,9	-1,0	2	Cylindrical	■
JME142006J3R010Z2.0-HXT	03205109	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,1	10,63	0,9	-1,0	2	Cylindrical	■
JME142006G3R005Z2.0-HXT	03205104	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,05	8,46	–	-1,0	2	Cylindrical	■
JME142006G3R010Z2.0-HXT	03205110	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,1	8,48	–	-1,0	2	Cylindrical	■
JME142008J3R005Z2.0-HXT	03205124	3	J	0,8	4,0	0,6	40,0	4,0	0,76	0,05	9,36	0,9	-1,0	2	Cylindrical	■
JME142008G3R005Z2.0-HXT	03205126	3	G	0,8	6,0	0,6	50,0	5,5	0,76	0,05	9,89	–	-1,0	2	Cylindrical	■
JME142010G3R005Z2.0-HXT	03205141	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,05	8,84	–	-1,0	2	Cylindrical	■
JME142010G3R010Z2.0-HXT	03205146	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,1	8,86	–	-1,0	2	Cylindrical	■
JME142010G3R020Z2.0-HXT	03205149	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,2	8,91	–	-1,0	2	Cylindrical	■
JME142015G3R005Z2.0-HXT	03205163	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,05	7,05	–	-1,0	2	Cylindrical	■
JME142015G3R010Z2.0-HXT	03205169	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,1	7,06	–	-1,0	2	Cylindrical	■
JME142015G3R020Z2.0-HXT	03205172	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,2	7,1	–	-1,0	2	Cylindrical	■

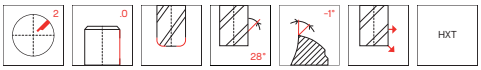
■ **Prodotto standard.**
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

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

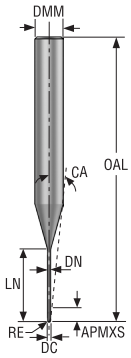
Codice di ordinazione	Codice prodotto	Indice di lung-hezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm						
JME142020G3R005Z2.0-HXT	03205181	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,05	5,9	–	-1,0	2	Cylindrical	■
JME142020G3R010Z2.0-HXT	03205186	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,1	5,92	–	-1,0	2	Cylindrical	■
JME142020G3R020Z2.0-HXT	03205189	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,2	5,95	–	-1,0	2	Cylindrical	■
JME142030G3R010Z2.0-HXT	03205206	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,1	4,15	–	-1,0	2	Cylindrical	■
JME142005J4R010Z2.0-HXT	03205097	4	J	0,5	4,0	0,375	40,0	4,0	0,46	0,1	9,76	0,9	-1,0	2	Cylindrical	■
JME142005G4R005Z2.0-HXT	03205092	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,05	10,42	–	-1,0	2	Cylindrical	■
JME142005G4R010Z2.0-HXT	03205098	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,1	10,45	–	-1,0	2	Cylindrical	■
JME142006J4R005Z2.0-HXT	03205105	4	J	0,6	4,0	0,45	40,0	5,0	0,56	0,05	8,79	0,9	-1,0	2	Cylindrical	■
JME142008G4R005Z2.0-HXT	03205128	4	G	0,8	6,0	0,6	50,0	8,0	0,76	0,05	8,49	–	-1,0	2	Cylindrical	■
JME142010G4R010Z2.0-HXT	03205147	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,1	7,48	–	-1,0	2	Cylindrical	■
JME142010G4R020Z2.0-HXT	03205150	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,2	7,52	–	-1,0	2	Cylindrical	■
JME142012G4R010Z2.0-HXT	03205157	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,1	6,62	–	-1,0	2	Cylindrical	■
JME142012G4R020Z2.0-HXT	03205160	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,2	6,65	–	-1,0	2	Cylindrical	■
JME142015G4R010Z2.0-HXT	03205170	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,1	5,55	–	-1,0	2	Cylindrical	■
JME142015G4R020Z2.0-HXT	03205173	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,2	5,58	–	-1,0	2	Cylindrical	■

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

JME142

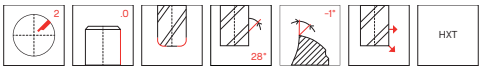
Miniaturizzato – Acciaio temprato – Spallamento – 2 Eliche – Cilindrico – Raggio di punta





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°	PSIR°	PCEDC	Attacco	Prodotto standard
				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	-1,0	2	Cylindrical	■
JME142020G4R020Z2.0-HXT	03205190	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,2	4,21	-1,0	2	Cylindrical	■

■ **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	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.026	0.032	0.036	0.044	0.055	90 (59 — 110)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0010*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*295 (200 — 360)*
H5	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	160 (140 — 190)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*520 (460 — 620)*
H7	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.026	0.032	0.036	0.044	0.055	90 (59 — 110)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0010*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*295 (200 — 360)*
H8	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	160 (140 — 190)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*520 (460 — 620)*
H11	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	205 (170 — 240)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*670 (560 — 780)*
H12	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	190 (160 — 220)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*620 (530 — 720)*
H21	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	160 (140 — 190)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*520 (460 — 620)*
H31	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	120 (110 — 140)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*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	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.018	0.022	0.024	0.030	0.036	65 (43 — 85)
		0,012	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00070*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*215 (150 — 270)*
H5	M/A	0.020	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	120 (97 — 130)
		0,020	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*395 (320 — 420)*
H7	M/A	0.012	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.018	0.022	0.024	0.030	0.036	65 (43 — 85)
		0,012	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00070*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*215 (150 — 270)*
H8	M/A	0.020	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	120 (97 — 130)
		0,020	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*395 (320 — 420)*
H11	M/A	0.020	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	150 (130 — 170)
		0,020	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*490 (430 — 550)*
H12	M/A	0.020	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	135 (120 — 160)
		0,020	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*445 (400 — 520)*
H21	M/A	0.012	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.018	0.022	0.024	0.030	0.036	120 (98 — 140)
		0,012	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00070*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*395 (330 — 450)*
H31	M/A	0.020	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	90 (73 — 100)
		0,020	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*295 (240 — 320)*

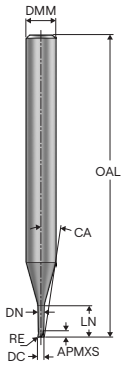
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

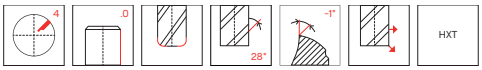
JME144

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 lung-hezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Attacco	Prodotto standard
				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	9,08	0,9	-1,0	4	Cylindrical	■
JME144010J2R010Z4.0-HXT	03205217	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,1	9,13	0,9	-1,0	4	Cylindrical	■
JME144010J2R020Z4.0-HXT	03205220	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,2	9,22	0,9	-1,0	4	Cylindrical	■
JME144015J2R005Z4.0-HXT	03205227	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,05	7,52	0,9	-1,0	4	Cylindrical	■
JME144015J2R010Z4.0-HXT	03205229	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,1	7,56	0,9	-1,0	4	Cylindrical	■
JME144015J2R020Z4.0-HXT	03205232	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,2	7,63	0,9	-1,0	4	Cylindrical	■
JME144020J2R005Z4.0-HXT	03205234	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,05	5,97	0,9	-1,0	4	Cylindrical	■
JME144020J2R010Z4.0-HXT	03205236	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,1	6,0	0,9	-1,0	4	Cylindrical	■
JME144020J2R020Z4.0-HXT	03205239	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,2	6,06	0,9	-1,0	4	Cylindrical	■
JME144020J2R030Z4.0-HXT	03205241	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,3	6,12	0,9	-1,0	4	Cylindrical	■
JME144030J2R010Z4.0-HXT	03205243	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,1	2,66	0,9	-1,0	4	Cylindrical	■
JME144030J2R020Z4.0-HXT	03205246	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,2	2,69	0,9	-1,0	4	Cylindrical	■
JME144010J3R010Z4.0-HXT	03205218	3	J	1,0	4,0	0,75	40,0	5,0	0,95	0,1	8,3	0,9	-1,0	4	Cylindrical	■
JME144015J3R010Z4.0-HXT	03205230	3	J	1,5	4,0	1,125	50,0	7,5	1,45	0,1	6,06	0,9	-1,0	4	Cylindrical	■
JME144020J3R005Z4.0-HXT	03205235	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,05	4,29	0,9	-1,0	4	Cylindrical	■
JME144020J3R010Z4.0-HXT	03205237	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,1	4,31	0,9	-1,0	4	Cylindrical	■

■ **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)*

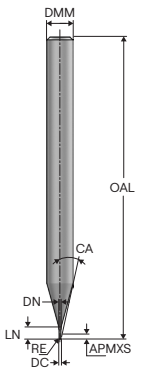
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

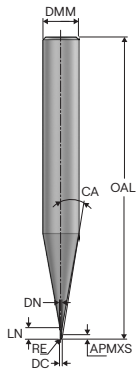
JMB112

Miniaturizzato – Acciaio temprato – A testa sferica – 2 Eliche – Cilindrico

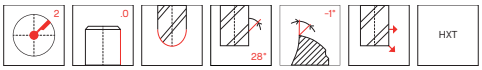




J



G



—Tolleranze:
—Run-out= <0,005 mm
—DMM= h5
—DC= <Ø0,6= 0/-0,008 mm
—DC= ≥Ø0,6= 0/-0,01 mm
—RE=DC <Ø1,5= ±0,004 mm
—RE=DC ≥Ø1,5= ±0,005 mm

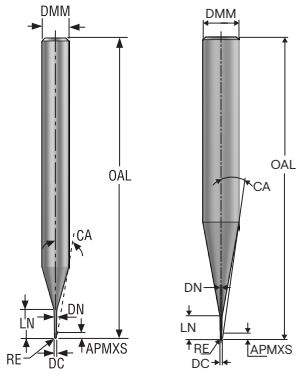
Codice di ordinazione	Codice prodotto	Indice di lung-hezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm						
JMB112002G1BZ2.0-HXT	03204964	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,1	15,11	–	-1,0	2	Cylindrical	■
JMB112003G1BZ2.0-HXT	03204966	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,15	14,77	–	-1,0	2	Cylindrical	■
JMB112004G1BZ2.0-HXT	03204968	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,2	14,32	–	-1,0	2	Cylindrical	■
JMB112005G1BZ2.0-HXT	03204970	1	G	0,5	4,0	0,5	40,0	1,0	0,46	0,25	13,97	–	-1,0	2	Cylindrical	■
JMB112006G1BZ2.0-HXT	03204977	1	G	0,6	4,0	0,6	40,0	1,2	0,56	0,3	13,64	–	-1,0	2	Cylindrical	■
JMB112008G1BZ2.0-HXT	03204984	1	G	0,8	6,0	0,8	50,0	1,6	0,76	0,4	13,96	–	-1,0	2	Cylindrical	■
JMB112010G1BZ2.0-HXT	03204991	1	G	1,0	6,0	1,0	50,0	2,0	0,95	0,5	13,49	–	-1,0	2	Cylindrical	■
JMB112012G1BZ2.0-HXT	03205000	1	G	1,2	6,0	1,2	50,0	2,4	1,15	0,6	13,02	–	-1,0	2	Cylindrical	■
JMB112015G1BZ2.0-HXT	03205009	1	G	1,5	6,0	1,5	50,0	3,0	1,45	0,75	12,2	–	-1,0	2	Cylindrical	■
JMB112002J2BZ2.0-HXT	03204965	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,1	14,33	0,9	-1,0	2	Cylindrical	■
JMB112003J2BZ2.0-HXT	03204967	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,15	13,85	0,9	-1,0	2	Cylindrical	■
JMB112004J2BZ2.0-HXT	03204969	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,2	13,3	0,9	-1,0	2	Cylindrical	■
JMB112005J2BZ2.0-HXT	03204971	2	J	0,5	4,0	0,5	40,0	1,5	0,46	0,25	12,85	0,9	-1,0	2	Cylindrical	■
JMB112005G2BZ2.0-HXT	03204972	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	9,91	–	-1,0	2	Cylindrical	■
JMB112006J2BZ2.0-HXT	03204978	2	J	0,6	4,0	0,6	50,0	2,0	0,56	0,3	12,09	0,9	-1,0	2	Cylindrical	■
JMB112006G2BZ2.0-HXT	03204979	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	9,62	–	-1,0	2	Cylindrical	■
JMB112008J2BZ2.0-HXT	03204985	2	J	0,8	4,0	0,8	50,0	2,5	0,76	0,4	11,34	0,9	-1,0	2	Cylindrical	■
JMB112008G2BZ2.0-HXT	03204986	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	9,33	–	-1,0	2	Cylindrical	■
JMB112010J2BZ2.0-HXT	03204992	2	J	1,0	4,0	1,0	40,0	4,0	0,95	0,5	9,49	0,9	-1,0	2	Cylindrical	■
JMB112010G2BZ2.0-HXT	03204993	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	8,49	–	-1,0	2	Cylindrical	■
JMB112012J2BZ2.0-HXT	03205001	2	J	1,2	4,0	1,2	50,0	4,5	1,15	0,6	8,83	0,9	-1,0	2	Cylindrical	■
JMB112012G2BZ2.0-HXT	03205002	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	8,21	–	-1,0	2	Cylindrical	■
JMB112015J2BZ2.0-HXT	03205010	2	J	1,5	4,0	1,5	50,0	5,0	1,45	0,75	8,1	0,9	-1,0	2	Cylindrical	■
JMB112015G2BZ2.0-HXT	03205011	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,14	–	-1,0	2	Cylindrical	■
JMB112020J2BZ2.0-HXT	03205024	2	J	2,0	4,0	2,0	50,0	6,0	1,94	1,0	6,6	0,9	-1,0	2	Cylindrical	■
JMB112020G2BZ2.0-HXT	03205025	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,1	–	-1,0	2	Cylindrical	■
JMB112030J2BZ2.0-HXT	03205037	2	J	3,0	4,0	3,0	50,0	9,0	2,85	1,5	3,04	0,9	-1,0	2	Cylindrical	■
JMB112030G2BZ2.0-HXT	03205038	2	G	3,0	6,0	3,0	50,0	9,0	2,85	1,5	6,35	–	-1,0	2	Cylindrical	■

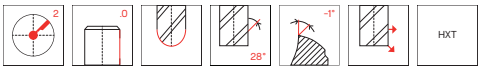
■ **Prodotto standard.**
Per i valori WDX: Profondità di taglio max relativa a $\alpha\eta$ ($l\alpha\eta$, rif.)*

JMB112

Miniaturizzato – Acciaio temprato – A testa sferica – 2 Eliche – Cilindrico







– Tolleranze:
– Run-out= <0,005 mm
– DMM= h5
– DC= <Ø0,6= 0/-0,008 mm
– DC= ≥Ø0,6= 0/-0,01 mm
– RE=DC <Ø1,5= ±0,004 mm
– RE=DC ≥Ø1,5= ±0,005 mm

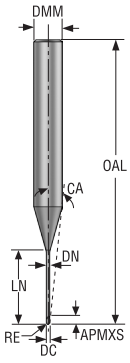
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm						
JMB112005J3BZ2.0-HXT	03204973	3	J	0,5	4,0	0,5	40,0	2,5	0,46	0,25	11,49	0,9	-1,0	2	Cylindrical	■
JMB112005G3BZ2.0-HXT	03204974	3	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	8,81	–	-1,0	2	Cylindrical	■
JMB112006J3BZ2.0-HXT	03204980	3	J	0,6	4,0	0,6	40,0	3,0	0,56	0,3	10,83	0,9	-1,0	2	Cylindrical	■
JMB112006G3BZ2.0-HXT	03204981	3	G	0,6	6,0	0,6	50,0	4,0	0,56	0,3	8,56	–	-1,0	2	Cylindrical	■
JMB112008J3BZ2.0-HXT	03204987	3	J	0,8	4,0	0,8	40,0	4,0	0,76	0,4	9,67	0,9	-1,0	2	Cylindrical	■
JMB112008G3BZ2.0-HXT	03204988	3	G	0,8	6,0	0,8	50,0	5,5	0,76	0,4	10,1	–	-1,0	2	Cylindrical	■
JMB112010J3BZ2.0-HXT	03204994	3	J	1,0	4,0	1,0	40,0	5,0	0,95	0,5	8,6	0,9	-1,0	2	Cylindrical	■
JMB112010G3BZ2.0-HXT	03204995	3	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	–	-1,0	2	Cylindrical	■
JMB112012J3BZ2.0-HXT	03205003	3	J	1,2	4,0	1,2	50,0	6,0	1,15	0,6	7,65	0,9	-1,0	2	Cylindrical	■
JMB112012G3BZ2.0-HXT	03205004	3	G	1,2	6,0	1,2	50,0	8,0	1,15	0,6	8,42	–	-1,0	2	Cylindrical	■
JMB112015J3BZ2.0-HXT	03205012	3	J	1,5	4,0	1,5	40,0	7,5	1,45	0,75	6,4	0,9	-1,0	2	Cylindrical	■
JMB112015G3BZ2.0-HXT	03205013	3	G	1,5	6,0	1,5	50,0	10,0	1,45	0,75	7,31	–	-1,0	2	Cylindrical	■
JMB112020J3BZ2.0-HXT	03205026	3	J	2,0	4,0	2,0	50,0	10,0	1,94	1,0	4,61	0,9	-1,0	2	Cylindrical	■
JMB112020G3BZ2.0-HXT	03205027	3	G	2,0	6,0	2,0	50,0	12,0	1,94	1,0	6,19	–	-1,0	2	Cylindrical	■
JMB112030J3BZ2.0-HXT	03205039	3	J	3,0	4,0	3,0	50,0	15,0	2,85	1,5	1,91	0,9	-1,0	2	Cylindrical	■
JMB112030G3BZ2.0-HXT	03205040	3	G	3,0	6,0	3,0	60,0	15,0	2,85	1,5	4,41	–	-1,0	2	Cylindrical	■

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

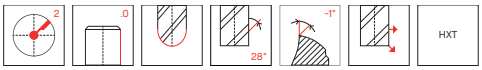
JMB112

Miniaturizzato – Acciaio temprato – A testa sferica – 2 Eliche – Cilindrico





G



—Tolleranze:
—Run-out= <0,005 mm
—DMM= h5
—DC= <Ø0,6= 0/-0,008 mm
—DC= ≥Ø0,6= 0/-0,01 mm
—RE=DC <Ø1,5= ±0,004 mm
—RE=DC ≥Ø1,5= ±0,005 mm

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PSIR°	PCEDC	Attacco	Prodotto standard
				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	9,86	-1,0	2	Cylindrical	■
JMB112008G4BZ2.0-HXT	03204990	4	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	8,65	-1,0	2	Cylindrical	■
JMB112010G4BZ2.0-HXT	03204998	4	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	7,63	-1,0	2	Cylindrical	■
JMB112015G4BZ2.0-HXT	03205015	4	G	1,5	6,0	1,5	70,0	15,0	1,45	0,75	5,7	-1,0	2	Cylindrical	■
JMB112020G4BZ2.0-HXT	03205029	4	G	2,0	6,0	2,0	60,0	18,0	1,94	1,0	4,68	-1,0	2	Cylindrical	■
JMB112030G4BZ2.0-HXT	03205042	4	G	3,0	6,0	3,0	80,0	30,0	2,85	1,5	2,51	-1,0	2	Cylindrical	■
JMB112010G6BZ2.0-HXT	03205054	6	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	4,99	-1,0	2	Cylindrical	■

■ **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 699 - 707

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.
- D8961, 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		D8961	JC845	JC850	JC860	JC870	JC871
Pag.		539	542	544	546	548	554
Famiglia		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Tipo di fresa							
Attacco	Cilindrico	■	■	■	■	■	■
	Weldon						
Numero di eliche		6	3	4	5,6,8,9		
CSP							
	Metrico		6-8	3-12	6-12	3-12	3-12
	Pollici					1/4 -1/2	1/4 -1/2
Lunghezze disponibili		2,3	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.		560	564	568	572	574	576	578
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
CSP							■	
	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

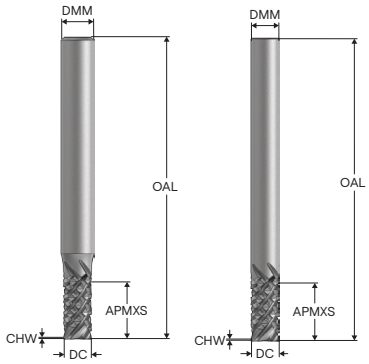
						
Nome		JPD850	JPD880	JPD890	J93F	J28
Pag.		581	583	585	587	589
Famiglia		PCD	PCD	PCD	VHM	VHM
Tipo di fresa						
Attacco	Cilindrico	■	■	■	■	■
	Weldon					
Numero di eliche		2	2	2	2	1
CSP		■	■	■		
	Metrico	4-10	6-16	6-12	1,5-20	3-12
	Pollici					
Lunghezze disponibili		2	2,3	2,3	1,2,3,4	2
Operazione						
						
						
SMG						
TS1					●	●
TS2		●	●	●		
TS3		●	●	●		
TP1					●	
TP2		●	●	●		
TP3		●	●	●		
Nido d'ape*						

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

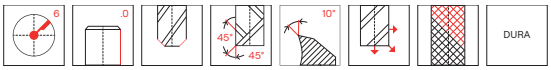
D8961

Compositi – Sgrossatore – 6 Eliche – Cilindrico – Smusso





—Tolleranze:
—DMM= h5
—DC= -0/-0,05 mm



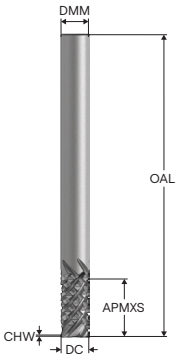
Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	Attacco	Prodotto standard
					mm	mm	mm	mm	mm		
D8961-050F2C.0Z6	DURA	10318178	2	F	5,0	6,0	10,0	65,0	0,152	Cylindrical	■
D8961-060D2C.0Z6	DURA	10318180	2	D	6,0	6,0	12,0	65,0	0,152	Cylindrical	■
D8961-080D2C.0Z6	DURA	10318182	2	D	8,0	8,0	16,0	70,0	0,203	Cylindrical	■
D8961-100D2C.0Z6	DURA	10318184	2	D	10,0	10,0	20,0	75,0	0,203	Cylindrical	■
D8961-120D2C.0Z6	DURA	10318186	2	D	12,0	12,0	24,0	76,0	0,254	Cylindrical	■
D8961-140D2C.0Z6	DURA	10318188	2	D	14,0	14,0	28,0	82,0	0,254	Cylindrical	■
D8961-160D2C.0Z6	DURA	10318190	2	D	16,0	16,0	32,0	94,0	0,254	Cylindrical	■
D8961-050F3C.0Z6	DURA	10318179	3	F	5,0	6,0	15,0	70,0	0,152	Cylindrical	■
D8961-060D3C.0Z6	DURA	10318181	3	D	6,0	6,0	18,0	70,0	0,152	Cylindrical	■
D8961-080D3C.0Z6	DURA	10318183	3	D	8,0	8,0	24,0	75,0	0,203	Cylindrical	■
D8961-100D3C.0Z6	DURA	10318185	3	D	10,0	10,0	30,0	90,0	0,203	Cylindrical	■
D8961-120D3C.0Z6	DURA	10318187	3	D	12,0	12,0	36,0	90,0	0,254	Cylindrical	■
D8961-140D3C.0Z6	DURA	10318189	3	D	14,0	14,0	42,0	96,0	0,254	Cylindrical	■
D8961-160D3C.0Z6	DURA	10318191	3	D	16,0	16,0	48,0	110,0	0,254	Cylindrical	■

■ **Prodotto standard.**

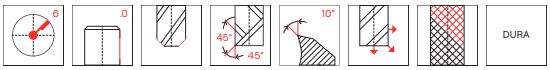
D8961

Compositi – Sgrossatore – 6 Eliche – Cilindrico – Smusso – Pollici





—Tolleranze:
—DMM=-.0001"/-.0004"
—DC=0/ -0.002"



Codice di ordinazione	Qualità	Codice prodotto	Indice di lunghezza	Forma utensile	DC	DMM	APMXS	OAL	CHW	Attacco	Prodotto standard
					inch	inch	inch	inch	inch		
D8961-.250D2C.0Z6	DURA	10318192	2	D	0.250	0.250	0.500	2.500	0.006	Cylindrical	■
D8961-.313D2C.0Z6	DURA	10318194	2	D	0.313	0.313	0.625	2.500	0.008	Cylindrical	■
D8961-.375D2C.0Z6	DURA	10318196	2	D	0.375	0.375	0.750	2.500	0.008	Cylindrical	■
D8961-.500D2C.0Z6	DURA	10318198	2	D	0.500	0.500	1.000	3.000	0.010	Cylindrical	■
D8961-.625D2C.0Z6	DURA	10318200	2	D	0.625	0.625	1.250	3.500	0.010	Cylindrical	■
D8961-.250D3C.0Z6	DURA	10318193	3	D	0.250	0.250	0.750	3.000	0.006	Cylindrical	■
D8961-.313D3C.0Z6	DURA	10318195	3	D	0.313	0.313	0.937	3.000	0.008	Cylindrical	■
D8961-.375D3C.0Z6	DURA	10318197	3	D	0.375	0.375	1.125	3.000	0.008	Cylindrical	■
D8961-.500D3C.0Z6	DURA	10318199	3	D	0.500	0.500	1.500	4.000	0.010	Cylindrical	■
D8961-.625D3C.0Z6	DURA	10318201	3	D	0.625	0.625	1.875	4.000	0.010	Cylindrical	■

■ **Prodotto standard.**

Parametri di taglio – D8961 Contornatura

SMG		a_e/DC	a_p/DC	f_z							v_c
				5	6	8	10	12	14	16	
TS2	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	170 (150 — 190) *560 (500 — 620)*
TS3	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	115 (91 — 140) *375 (300 — 450)*
TP2	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	115 (91 — 160) *375 (300 — 520)*
TP3	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	85 (52 — 110) *280 (180 — 360)*

Parametri di taglio – D8961 Scanalatura

SMG		a_p/DC	f_z							v_c
			5	6	8	10	12	14	16	
TS2	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	130 (110 — 140) *425 (370 — 450)*
TS3	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	90 (70 — 100) *295 (230 — 320)*
TP2	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	90 (70 — 120) *295 (230 — 390)*
TP3	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	65 (40 — 89) *215 (140 — 290)*

Parametri di taglio – D8961 Contornatura – Pollici

SMG		a_e/DC	a_p/DC	f_z					v_c
				1/4	5/16	3/8	1/2	5/8	
TS2	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	170 (150 — 190) *560 (500 — 620)*
TS3	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	115 (91 — 140) *375 (300 — 450)*
TP2	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	115 (91 — 160) *375 (300 — 520)*
TP3	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	85 (52 — 110) *280 (180 — 360)*

Parametri di taglio – D8961 Scanalatura – Pollici

SMG		a_p/DC	f_z					v_c
			1/4	5/16	3/8	1/2	5/8	
TS2	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	130 (110 — 140) *425 (370 — 450)*
TS3	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	90 (70 — 100) *295 (230 — 320)*
TP2	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	90 (70 — 120) *295 (230 — 390)*
TP3	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	65 (40 — 89) *215 (140 — 290)*

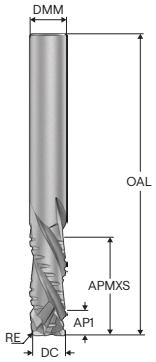
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

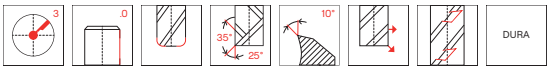
JC845

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	profilo rompitru-ciolo	DC	DMM	APMXS	AP1	OAL	RE	PCEDC	Attacco	Prodotto standard
					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	Cylindrical	■
JC845080D2R050.0Z3-DURA	02843007	2	D	■	8,0	8,0	24,0	5,2	75,0	0,5	3	Cylindrical	■
JC845100D2R050.0Z3-DURA	02843008	2	D	■	10,0	10,0	30,0	6,3	85,0	0,5	3	Cylindrical	■
JC845120D2R050.0Z5-DURA	02843009	2	D	■	12,0	12,0	36,0	8,3	100,0	0,5	5	Cylindrical	■

■ **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)*

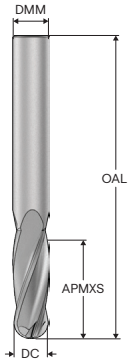
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

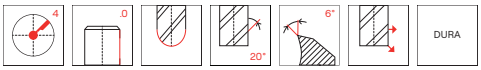
JC850

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	RE	PCEDC	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
850030Z4.0-DURA	02719949	2	D	3,0	3,0	9,0	50,0	1,5	4	Cylindrical	■
850040Z4.0-DURA	02719952	2	D	4,0	4,0	12,0	50,0	2,0	4	Cylindrical	■
850060Z4.0-DURA	02719953	2	D	6,0	6,0	18,0	65,0	3,0	4	Cylindrical	■
850080Z4.0-DURA	02719954	2	D	8,0	8,0	24,0	70,0	4,0	4	Cylindrical	■
850100Z4.0-DURA	02719955	2	D	10,0	10,0	30,0	85,0	5,0	4	Cylindrical	■
850120Z4.0-DURA	02719956	2	D	12,0	12,0	36,0	100,0	6,0	4	Cylindrical	■

■ **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)*

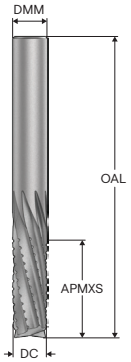
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

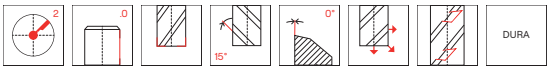
Nido d'ape – Spallamento – 5-9 Eliche – Cilindrico – Spigolo vivo





D

—Tolleranze:
—DMM=h5
—DC= -0.02-0.08 mm
—FCEDC=denti frontali



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	L	APMXS	OAL	FCEDC	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm				
860060Z5.0-DURA	02720211	2	D	■	6,0	6,0	18,0	18,0	70,0	2	5	Cylindrical	■
860080Z6.0-DURA	02720212	2	D	■	8,0	8,0	24,0	24,0	80,0	2	6	Cylindrical	■
860100Z8.0-DURA	02720216	2	D	■	10,0	10,0	30,0	30,0	90,0	2	8	Cylindrical	■
860120Z9.0-DURA	02720217	2	D	■	12,0	12,0	36,0	36,0	110,0	2	9	Cylindrical	■

■ **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)*

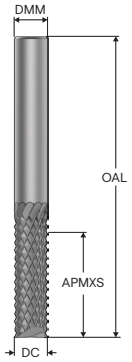
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

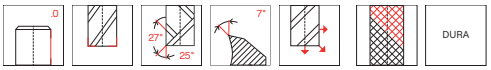
Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo





D

—Tolleranze:
—DMM=h5
—DC=-0,02/-0,08 mm
—Sgrossatore (downcut)*



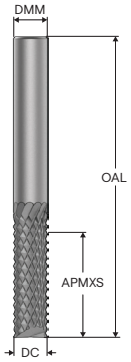
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	L	APMXS	OAL	FCEDC	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm				
870030.0-DURA	02720219	2	D	■	3,0	3,0	9,0	9,0	50,0	2	8	Cylindrical	■
870040.0-DURA	02720226	2	D	■	4,0	4,0	12,0	12,0	50,0	2	8	Cylindrical	■
870060.0-DURA	02720228	2	D	■	6,0	6,0	18,0	18,0	65,0	2	10	Cylindrical	■
870080.0-DURA	02720229	2	D	■	8,0	8,0	24,0	24,0	75,0	2	12	Cylindrical	■
870100.0-DURA	02720231	2	D	■	10,0	10,0	30,0	30,0	85,0	2	12	Cylindrical	■
870120.0-DURA	02720232	2	D	■	12,0	12,0	36,0	36,0	100,0	2	14	Cylindrical	■

■ **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

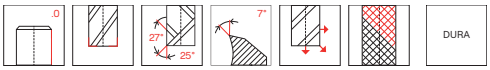
Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo – Pollici





D

—Tolleranze:
—DMM= h5
—DC= -.0008/-.0030 *Inch*
—Sgrossatore (downcut)*



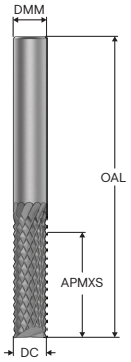
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch				
8700250.0-DURA	02720784	2	D	■	0.250	0.250	0.750	2.250	2	10	Cylindrical	■
8700375.0-DURA	02720785	2	D	■	0.375	0.375	1.250	3.500	2	12	Cylindrical	■

■ **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

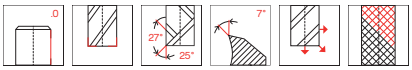
Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo





D

—Tolleranze:
—DMM=h5
—DC=-0,02/-0,08 mm
—Sgrossatore (downcut)*



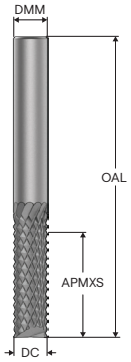
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	L	APMXS	OAL	FCEDC	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm				
870030.0	02742789	2	D	■	3,0	3,0	9,0	9,0	50,0	2	8	Cylindrical	■
870040.0	02742792	2	D	■	4,0	4,0	12,0	12,0	50,0	2	8	Cylindrical	■
870050.0	02742793	2	D	■	5,0	5,0	15,0	15,0	50,0	2	10	Cylindrical	■
870060.0	02742794	2	D	■	6,0	6,0	18,0	18,0	65,0	2	10	Cylindrical	■
870080.0	02742795	2	D	■	8,0	8,0	24,0	24,0	75,0	2	12	Cylindrical	■
870100.0	02742796	2	D	■	10,0	10,0	30,0	30,0	85,0	2	12	Cylindrical	■
870120.0	02742797	2	D	■	12,0	12,0	36,0	36,0	100,0	2	14	Cylindrical	■

■ **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

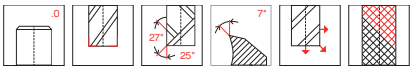
Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo – Pollici





D

—Tolleranze:
—DMM= h5
—DC=- .0008 / -.0015 *pollici*
—Sgrossatore (downcut)*



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch				
8700250.0	02742798	2	D	■	0.250	0.250	0.750	2.250	2	10	Cylindrical	■
8700500.0	02742800	2	D	■	0.500	0.500	1.500	4.250	2	14	Cylindrical	■

■ **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 699 - 707

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)*

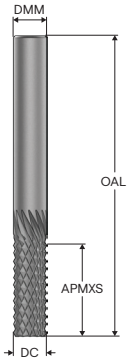
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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)*



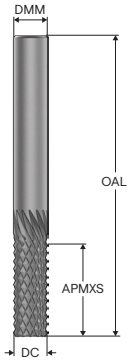
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm			
871030.0-DURA	02720249	2	D	■	3,0	3,0	9,0	50,0	8	Cylindrical	■
871040.0-DURA	02720250	2	D	■	4,0	4,0	12,0	50,0	8	Cylindrical	■
871060.0-DURA	02720252	2	D	■	6,0	6,0	18,0	65,0	10	Cylindrical	■
871080.0-DURA	02720253	2	D	■	8,0	8,0	24,0	75,0	12	Cylindrical	■
871100.0-DURA	02720254	2	D	■	10,0	10,0	30,0	85,0	12	Cylindrical	■
871120.0-DURA	02720257	2	D	■	12,0	12,0	36,0	100,0	14	Cylindrical	■

■ **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)*



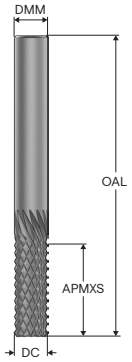
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
8710250.0-DURA	02720788	2	D	■	0.250	0.250	0.750	2.250	10	Cylindrical	■
8710375.0-DURA	02720789	2	D	■	0.375	0.375	1.250	3.500	12	Cylindrical	■
8710500.0-DURA	02720790	2	D	■	0.500	0.500	1.500	4.250	14	Cylindrical	■

■ **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

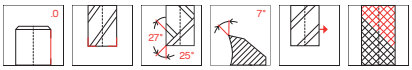
Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo





D

—Tolleranze:
—DMM= h5
—DC= -0,02/-0,08 mm
—Sgrossatore (downcut)*



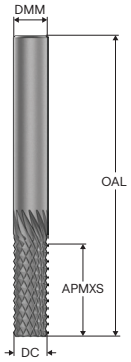
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm			
871030.0	02742801	2	D	■	3,0	3,0	9,0	50,0	8	Cylindrical	■
871040.0	02742803	2	D	■	4,0	4,0	12,0	50,0	8	Cylindrical	■
871060.0	02742806	2	D	■	6,0	6,0	18,0	65,0	10	Cylindrical	■
871080.0	02742807	2	D	■	8,0	8,0	24,0	75,0	12	Cylindrical	■
871100.0	02742808	2	D	■	10,0	10,0	30,0	85,0	12	Cylindrical	■
871120.0	02742809	2	D	■	12,0	12,0	36,0	100,0	14	Cylindrical	■

■ **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

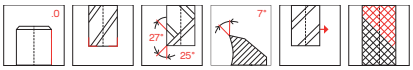
Compositi – Sgrossatore – Spallamento – Cilindrico – Spigolo vivo – Pollici





D

—Tolleranze:
—DMM=h5
—DC=-0,02/-0,08 mm
—Sgrossatore (downcut)*



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch			
8710500.0	02742814	2	D	■	0.500	0.500	1.500	4.250	14	Cylindrical	■

■ **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 699 - 707

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)*

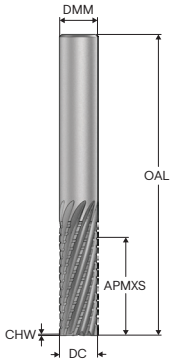
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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



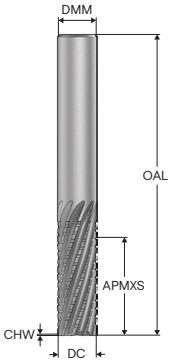
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm			
JC875030D2.0-DURA	02968155	2	D	■	3,0	3,0	9,0	50,0	0,05	5	Cylindrical	■
JC875050D2.0-DURA	02968157	2	D	■	5,0	5,0	15,0	50,0	0,05	6	Cylindrical	■
JC875060D2.0-DURA	02968158	2	D	■	6,0	6,0	18,0	65,0	0,06	6	Cylindrical	■
JC875080D2.0-DURA	02968159	2	D	■	8,0	8,0	24,0	70,0	0,08	10	Cylindrical	■
JC875100D2.0-DURA	02968160	2	D	■	10,0	10,0	30,0	80,0	0,1	10	Cylindrical	■

■ **Prodotto standard.**

JC875

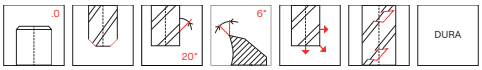
Compositi – Spallamento – 6-10 Eliche – Cilindrico – Smusso – Pollici





D

—Tolleranze:
—DMM=h5
—DC= -.0008/-.0030 *Inch*



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	CHW	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
JC875.250D2.0-DURA	02968162	2	D	■	0.250	0.250	0.750	3.000	0.002	6	Cylindrical	■

■ **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 699 - 707

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)*

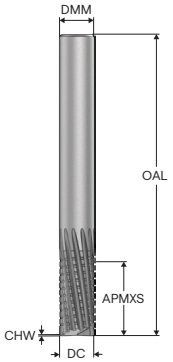
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

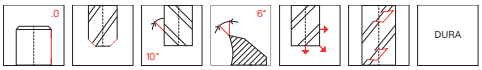
Compositi – Spallamento – 6-14 Eliche – Cilindrico – Smusso





D

—Tolleranze:
—DMM=h5
—DC=-0,02 -0,08 mm
—Elica sinistra



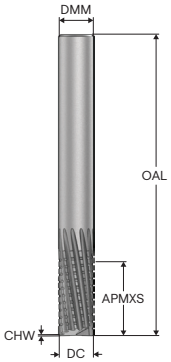
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	L	APMXS	OAL	CHW	FCEDC	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm				
JC876030D2C.0Z6-DURA	03135004	2	D	■	3,0	3,0	7,5	7,5	50,0	0,035	2	6	Cylindrical	■
JC876040D2C.0Z6-DURA	03135005	2	D	■	4,0	4,0	10,0	10,0	54,0	0,045	2	6	Cylindrical	■
JC876060D2C.0Z8-DURA	03135006	2	D	■	6,0	6,0	15,0	15,0	62,0	0,075	2	8	Cylindrical	■
JC876060D2C.0Z10-DURA	03135007	2	D	■	6,0	6,0	15,0	15,0	62,0	0,075	2	10	Cylindrical	■
JC876080D2C.0Z10-DURA	03135009	2	D	■	8,0	8,0	20,0	20,0	70,0	0,1	2	10	Cylindrical	■
JC876100D2C.0Z12-DURA	03135011	2	D	■	10,0	10,0	25,0	25,0	82,0	0,125	2	12	Cylindrical	■
JC876120D2C.0Z14-DURA	03135012	2	D	■	12,0	12,0	30,0	30,0	95,0	0,15	2	14	Cylindrical	■

■ **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	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	CHW	FCEDC	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch				
JC876.250D2C.0Z8-DURA	03135125	2	D	■	0.250	0.250	0.625	2.500	0.003	2	8	Cylindrical	■
JC876.375D2C.0Z12-DURA	03135127	2	D	■	0.375	0.375	1.000	3.000	0.005	2	12	Cylindrical	■

■ **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 699 - 707

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)*

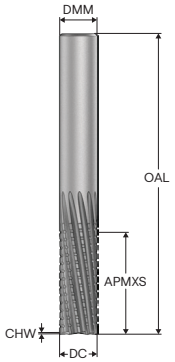
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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



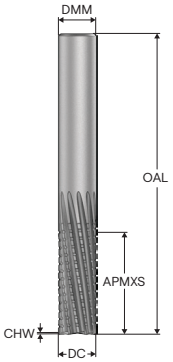
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	L	APMXS	OAL	CHW	FCEDC	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm				
JC877030D2C.0Z6-DURA	03135013	2	D	■	3,0	3,0	9,0	9,0	50,0	0,035	3	6	Cylindrical	■
JC877040D2C.0Z6-DURA	03135014	2	D	■	4,0	4,0	12,0	12,0	54,0	0,045	3	6	Cylindrical	■
JC877060D2C.0Z8-DURA	03135015	2	D	■	6,0	6,0	18,0	18,0	62,0	0,075	4	8	Cylindrical	■
JC877060D2C.0Z10-DURA	03135016	2	D	■	6,0	6,0	18,0	18,0	62,0	0,075	5	10	Cylindrical	■
JC877080D2C.0Z10-DURA	03135018	2	D	■	8,0	8,0	24,0	24,0	70,0	0,1	5	10	Cylindrical	■
JC877100D2C.0Z12-DURA	03135020	2	D	■	10,0	10,0	30,0	30,0	82,0	0,125	6	12	Cylindrical	■
JC877120D2C.0Z14-DURA	03135021	2	D	■	12,0	12,0	36,0	36,0	95,0	0,15	7	14	Cylindrical	■

■ **Prodotto standard.**

JC877

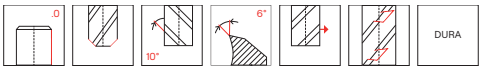
Compositi – Spallamento – 8-14 Eliche – Cilindrico – Smusso – Pollici





D

—Tolleranze:
—DMM=h5
—DC= -.0008/-.0030 *Inch*
—Elica sinistra



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitru-ciolo	DC	DMM	APMXS	OAL	CHW	FCEDC	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch				
JC877.250D2C.0Z8-DURA	03135129	2	D	■	0.250	0.250	0.750	2.500	0.003	4	8	Cylindrical	■

■ **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 699 - 707

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)*

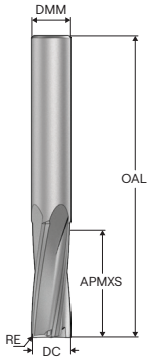
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

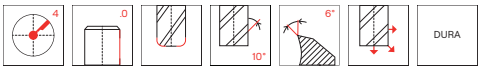
Compositi – Spallamento – 4 Eliche – Cilindrico – Raggio di punta





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	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
880040R020Z4.0-DURA	02843012	2	D	4,0	4,0	12,0	50,0	0,2	4	Cylindrical	■
880050R020Z4.0-DURA	02843013	2	D	5,0	5,0	15,0	50,0	0,2	4	Cylindrical	■
880060R020Z4.0-DURA	02720258	2	D	6,0	6,0	18,0	65,0	0,2	4	Cylindrical	■
880080R020Z4.0-DURA	02720259	2	D	8,0	8,0	24,0	70,0	0,2	4	Cylindrical	■
880100R020Z4.0-DURA	02720260	2	D	10,0	10,0	30,0	80,0	0,2	4	Cylindrical	■
880120R020Z4.0-DURA	02720261	2	D	12,0	12,0	36,0	100,0	0,2	4	Cylindrical	■
880160R020Z4.0-DURA	02720262	2	D	16,0	16,0	48,0	110,0	0,2	4	Cylindrical	■
880200R020Z4.0-DURA	02720263	2	D	20,0	20,0	60,0	130,0	0,2	4	Cylindrical	■

■ **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)*

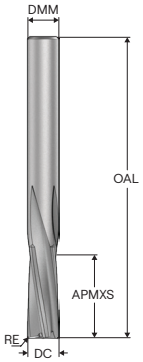
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

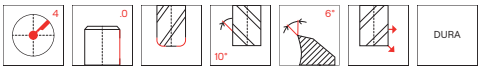
JC885

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	Attacco	Prodotto standard
				mm	mm	mm	mm	mm			
JC885040D2R020.0Z4-DURA	02843014	2	D	4,0	4,0	12,0	50,0	0,2	4	Cylindrical	■
JC885060D2R020.0Z4-DURA	02843016	2	D	6,0	6,0	18,0	70,0	0,2	4	Cylindrical	■
JC885080D2R020.0Z4-DURA	02843017	2	D	8,0	8,0	24,0	80,0	0,2	4	Cylindrical	■

■ **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)*

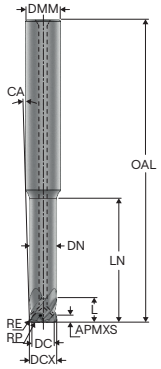
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

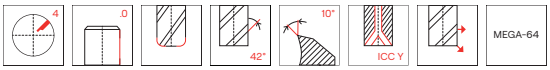
Elevato avanzamento – Materiali sandwich – Raggio di punta – 4 Eliche – Cilindrico – Raggio di punta





G

—Tolleranze:
—DMM=h5
—DC= e7
—RE= ±0,1 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DCX	DC	DMM	L	APMXS	OAL	LN	DN	RE	RP	UTCN	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm				
JC898080G3HZ4A.0-M64	03245308	3	G	■	8,0	4,0	10,0	6,0	0,43	88,0	35,0	7,6	0,5	0,87	0,22	1,5	4	Cylindrical	■
JC898150G3HZ4A.0-M64	03245309	3	G	■	15,0	7,5	16,0	12,0	0,796	125,0	70,0	14,3	0,94	1,63	0,4	0,4	4	Cylindrical	■

■ **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)*

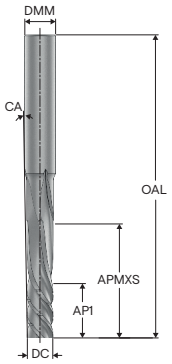
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

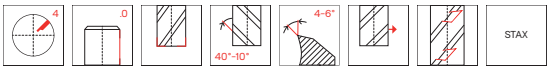
JC899

Alte prestazioni – Materiali sandwich – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo





F



—Tolleranze:
—DMM=h5
—DC= ±0,02 mm

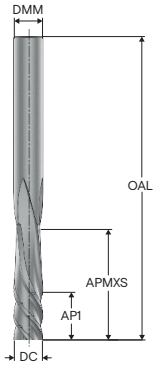
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	OAL	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm				
JC899085F3S.0Z4-STAX	03245482	3	F	■	8,5	10,0	38,0	100,0	0,8	4	Cylindrical	■
JC899148F3S.0Z4-STAX	03245480	3	F	■	14,8	16,0	55,0	150,0	0,53	4	Cylindrical	■
JC899148F4S.0Z4-STAX	03245481	4	F	■	14,8	16,0	62,0	150,0	0,48	4	Cylindrical	■

■ **Prodotto standard.**

JC899

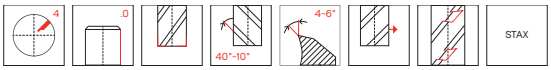
Alte prestazioni – Materiali sandwich – Spallamento – 4 Eliche – Cilindrico – Spigolo vivo – Pollici





D

—Tolleranze:
—DMM=h5
—DC= ±0,0008 *Inch*



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	profilo rompitruciolo	DC	DMM	APMXS	AP1	OAL	PCEDC	Attacco	Prodotto standard
					inch	inch	inch	inch	inch			
JC8990375D4S.0Z4-STAX	03245483	4	D	■	0.373	0.375	1.500	0.625	4.000	4	Cylindrical	■

■ **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)*

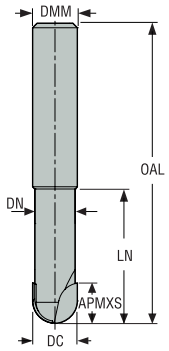
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

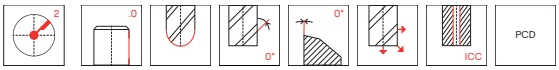
Compositi – A testa sferica – 2 Eliche – Cilindrico





E

—Tolleranze:
—DMM=h5
—DC= h10
—CSP= 2 canali diritti



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm			
JPD850060E2B.0Z2A	02968184	2	E	■	6,0	6,0	7,0	58,0	18,0	5,4	3,0	2	Cylindrical	■
JPD850080E2B.0Z2A	02968185	2	E	■	8,0	8,0	8,0	64,0	24,0	7,2	4,0	2	Cylindrical	■
JPD850100E2B.0Z2A	02968186	2	E	■	10,0	10,0	10,0	73,0	30,0	9,0	5,0	2	Cylindrical	■

■ **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)*

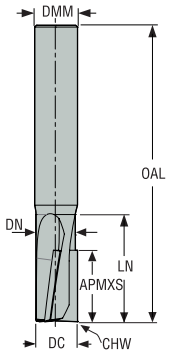
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

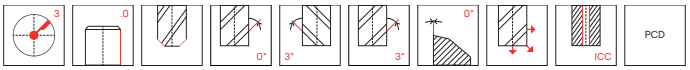
Compositi – Spallamento – 3 Eliche – Cilindrico – Smusso





E

—Tolleranze:
—DMM=h5
—DC=h10
—CSP=Y



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					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	Cylindrical	■
JPD880080E2C.0Z3A	02968191	2	E	■	8,0	8,0	15,0	64,0	20,0	7,3	0,1	3	Cylindrical	■
JPD880100E2C.0Z3A	02968192	2	E	■	10,0	10,0	13,0	73,0	30,0	9,2	0,1	3	Cylindrical	■
JPD880120E2C.0Z3A	02968194	2	E	■	12,0	12,0	13,0	83,0	30,0	11,0	0,1	3	Cylindrical	■
JPD880160E2C.0Z3A	02968196	2	E	■	16,0	16,0	13,0	90,0	35,0	14,8	0,1	3	Cylindrical	■
JPD880100E3C.0Z3A	02968193	3	E	■	10,0	10,0	20,0	73,0	30,0	9,2	0,1	3	Cylindrical	■
JPD880160E3C.0Z3A	02968197	3	E	■	16,0	16,0	20,0	90,0	35,0	14,8	0,1	3	Cylindrical	■

■ **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)*

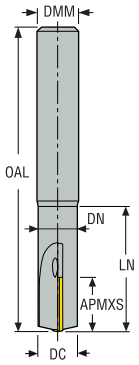
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

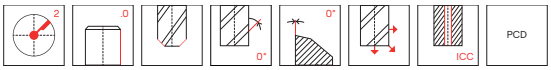
Compositi – Spallamento – 2 Eliche – Cilindrico – Smusso





E

—Tolleranze:
—DMM=h5
—DC=h10
—CSP=2 canali diritti



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Attacco	Prodotto standard
					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	Cylindrical	■
JPD890080E2S.0Z2A	02791383	2	E	■	8,0	8,0	15,0	64,0	20,0	7,4	0,1	2	Cylindrical	■
JPD890100E2S.0Z2A	02791384	2	E	■	10,0	10,0	13,0	73,0	30,0	9,4	0,1	2	Cylindrical	■
JPD890120E2S.0Z2A	02791386	2	E	■	12,0	12,0	13,0	83,0	30,0	11,4	0,1	2	Cylindrical	■
JPD890100E3S.0Z2A	02791385	3	E	■	10,0	10,0	20,0	73,0	30,0	9,4	0,1	2	Cylindrical	■
JPD890120E3S.0Z2A	02791387	3	E	■	12,0	12,0	20,0	83,0	30,0	11,4	0,1	2	Cylindrical	■

■ **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)*

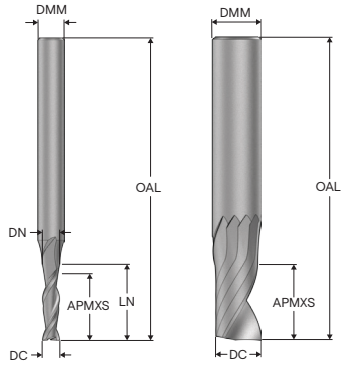
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

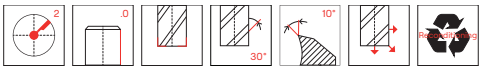
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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	Attacco	Prodotto standard
				mm	mm	mm	mm				
93015-F	02605874	2	F	1,5	3,0	6,0	40,0	4,0	2	Cylindrical	■
93020-F	02605888	2	F	2,0	3,0	9,0	40,0	2,5	2	Cylindrical	■
93030-F	02606060	2	D	3,0	3,0	12,0	40,0	–	2	Cylindrical	■
93040-F	02606061	2	D	4,0	4,0	14,0	50,0	–	2	Cylindrical	■
93060-F	02606063	2	D	6,0	6,0	20,0	65,0	–	2	Cylindrical	■
93080-F	02606064	2	D	8,0	8,0	20,0	70,0	–	2	Cylindrical	■
93100-F	02606065	2	D	10,0	10,0	25,0	80,0	–	2	Cylindrical	■
93120-F	02606066	2	D	12,0	12,0	25,0	90,0	–	2	Cylindrical	■
93160-F	02606068	2	D	16,0	16,0	30,0	90,0	–	2	Cylindrical	■
93L060-F	02606071	3	D	6,0	6,0	40,0	100,0	–	2	Cylindrical	■
93L080-F	02606072	3	D	8,0	8,0	40,0	100,0	–	2	Cylindrical	■
93L100-F	02606073	3	D	10,0	10,0	40,0	100,0	–	2	Cylindrical	■
93L120-F	02606074	3	D	12,0	12,0	45,0	100,0	–	2	Cylindrical	■
93L160-F	02606077	3	D	16,0	16,0	45,0	100,0	–	2	Cylindrical	■
93L200-F	02606078	3	D	20,0	20,0	55,0	125,0	–	2	Cylindrical	■
93XL120-F	02606079	4	D	12,0	12,0	30,0	150,0	–	2	Cylindrical	■
93XL160-F	02606080	4	D	16,0	16,0	65,0	150,0	–	2	Cylindrical	■
93XL200-F	02606081	4	D	20,0	20,0	65,0	150,0	–	2	Cylindrical	■

■ **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)*

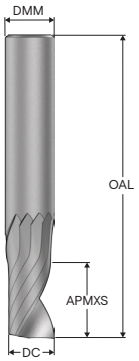
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

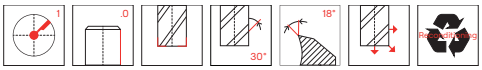
Uso generico – Plastica – Spallamento – 1 Elica – Cilindrico – Spigolo vivo





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	Attacco	Prodotto standard
				mm	mm	mm	mm			
28030	00029353	2	D	3,0	3,0	10,0	40,0	1	Cylindrical	■
28040	00029361	2	D	4,0	4,0	14,0	50,0	1	Cylindrical	■
28050	00029363	2	D	5,0	5,0	16,0	60,0	1	Cylindrical	■
28060	00029366	2	D	6,0	6,0	20,0	65,0	1	Cylindrical	■
28080	00029369	2	D	8,0	8,0	25,0	75,0	1	Cylindrical	■
28100	00029370	2	D	10,0	10,0	25,0	75,0	1	Cylindrical	■
28120	00029372	2	D	12,0	12,0	25,0	75,0	1	Cylindrical	■

■ **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 699 - 707

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.		594	596	598	600
Famiglia		DIAMOND	DIAMOND	DIAMOND	DIAMOND
Tipo di fresa					
Attacco	Cilindrico	■	■	■	■
	Weldon				
Numero di eliche		2	3	4	2
CSP					
	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

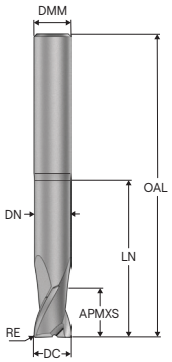
			 	
Nome		SMB614/616	JME642	JMB642/JMB662
Pag.		604	604	606
Famiglia		MINI DIAMOND	MINI DIAMOND	MINI DIAMOND
Tipo di fresa				
Attacco	Cilindrico	■	■	■
	Weldon			
Numero di eliche		2	2	2
CSP				
	Metrico	0,6-3	0,2-2,0	0,2-3,0
	Pollici			
Lunghezze disponibili		1,3,5,6,7	1,3,5,6,7	1,3,5,6,7
Operazione				
				
				
SMG				
GR		•	•	•

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

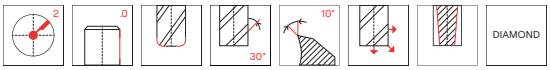
JD620

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	Attacco	Prodotto standard
				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	Cylindrical	■
620V040R050-DIAMOND	00023427	2	E	4,0	4,0	5,0	60,0	30,0	3,85	0,5	2	Cylindrical	■
620V060R050-DIAMOND	00023429	2	E	6,0	6,0	10,0	80,0	40,0	5,8	0,5	2	Cylindrical	■
620V080R050-DIAMOND	00023431	2	E	8,0	8,0	10,0	80,0	40,0	7,7	0,5	2	Cylindrical	■
620V100R050-DIAMOND	00023435	2	E	10,0	10,0	10,0	80,0	40,0	9,7	0,5	2	Cylindrical	■
620V120R050-DIAMOND	00023437	2	E	12,0	12,0	10,0	80,0	40,0	11,7	0,5	2	Cylindrical	■
620VL060R050-DIAMOND	00023444	3	E	6,0	6,0	10,0	100,0	70,0	5,8	0,5	2	Cylindrical	■
620VL080R050-DIAMOND	00023446	3	E	8,0	8,0	10,0	100,0	70,0	7,8	0,5	2	Cylindrical	■
620VL080R100-DIAMOND	00023447	3	E	8,0	8,0	10,0	100,0	70,0	7,8	1,0	2	Cylindrical	■
620VL100R050-DIAMOND	00023448	3	E	10,0	10,0	10,0	100,0	70,0	9,8	0,5	2	Cylindrical	■
620VL100R100-DIAMOND	00023449	3	E	10,0	10,0	10,0	100,0	70,0	9,8	1,0	2	Cylindrical	■
620VL120R050-DIAMOND	00023450	3	E	12,0	12,0	10,0	100,0	70,0	11,8	0,5	2	Cylindrical	■
620VL120R100-DIAMOND	00023451	3	E	12,0	12,0	10,0	100,0	70,0	11,7	1,0	2	Cylindrical	■
620VSL100R100-DIAMOND	00023452	4	E	10,0	10,0	10,0	150,0	100,0	9,8	1,0	2	Cylindrical	■
620VSL120R100-DIAMOND	00023453	4	E	12,0	12,0	10,0	150,0	100,0	11,8	1,0	2	Cylindrical	■

■ **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)*

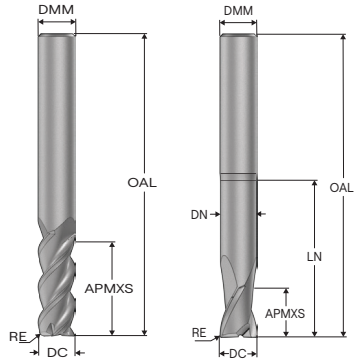
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

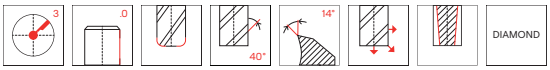
JD630

Diamante – Grafite – Spallamento – 3 Eliche – Cilindrico – Raggio di punta





D 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	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
630030R015-DIAMOND	00023454	2	D	3,0	3,0	12,0	40,0	–	–	0,15	3	Cylindrical	■
630040R020-DIAMOND	00023456	2	D	4,0	4,0	14,0	50,0	–	–	0,2	3	Cylindrical	■
630050R030-DIAMOND	00023457	2	D	5,0	5,0	16,0	50,0	–	–	0,3	3	Cylindrical	■
630060R030-DIAMOND	00023458	2	D	6,0	6,0	20,0	65,0	–	–	0,3	3	Cylindrical	■
630080R050-DIAMOND	00023459	2	D	8,0	8,0	20,0	65,0	–	–	0,5	3	Cylindrical	■
630V030R030-DIAMOND	00023464	3	E	3,0	3,0	5,0	40,0	15,0	2,9	0,3	3	Cylindrical	■
630V040R030-DIAMOND	00023465	3	E	4,0	4,0	5,0	50,0	20,0	3,9	0,3	3	Cylindrical	■
630VL030R020-DIAMOND	00023467	4	E	3,0	3,0	5,0	60,0	25,0	2,9	0,2	3	Cylindrical	■
630VL040R020-DIAMOND	00023470	4	E	4,0	4,0	5,0	60,0	30,0	3,9	0,2	3	Cylindrical	■
630VL050R020-DIAMOND	00023471	4	E	5,0	5,0	6,0	70,0	40,0	4,9	0,2	3	Cylindrical	■
630VL060R050-DIAMOND	00023472	4	E	6,0	6,0	10,0	100,0	60,0	5,9	0,5	3	Cylindrical	■

■ **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)*

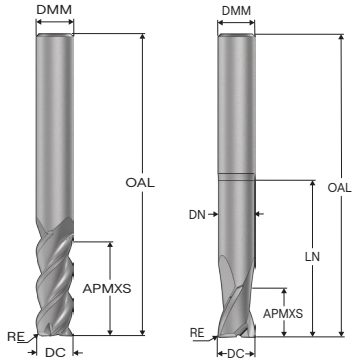
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

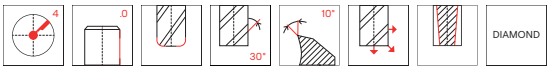
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

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	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
640100R050-DIAMOND	00023474	2	D	10,0	10,0	25,0	75,0	–	–	0,5	4	Cylindrical	■
640120R050-DIAMOND	00023475	2	D	12,0	12,0	25,0	80,0	–	–	0,5	4	Cylindrical	■
640V060R050-DIAMOND	00023479	3	E	6,0	6,0	10,0	80,0	40,0	5,9	0,5	4	Cylindrical	■
640V080R050-DIAMOND	00023480	3	E	8,0	8,0	10,0	80,0	40,0	7,8	0,5	4	Cylindrical	■
640V100R050-DIAMOND	00023481	3	E	10,0	10,0	12,0	80,0	40,0	9,8	0,5	4	Cylindrical	■
640V120R050-DIAMOND	00023483	3	E	12,0	12,0	15,0	80,0	40,0	11,8	0,5	4	Cylindrical	■
640VL100R050-DIAMOND	00023486	4	E	10,0	10,0	12,0	125,0	80,0	9,8	0,5	4	Cylindrical	■
640VL120R050-DIAMOND	02462698	4	E	12,0	12,0	15,0	125,0	80,0	11,7	0,5	4	Cylindrical	■

■ **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)*

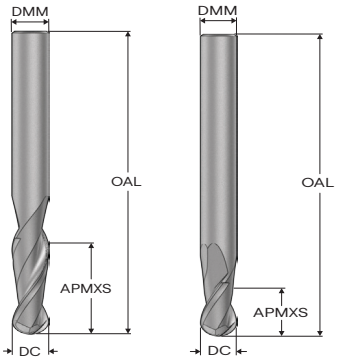
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

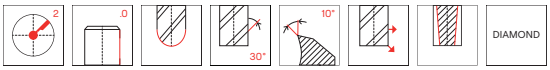
JD660

Diamante – Grafite – A testa sferica – 2 Eliche – Cilindrico





D E



– 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	Attacco	Prodotto standard
				mm	mm	mm	mm	mm	mm	mm			
660030-DIAMOND	00023488	1	D	3,0	3,0	8,0	40,0	–	–	1,5	2	Cylindrical	■
660040-DIAMOND	00023489	1	D	4,0	4,0	14,0	50,0	–	–	2,0	2	Cylindrical	■
660060-DIAMOND	00023491	1	D	6,0	6,0	20,0	65,0	–	–	3,0	2	Cylindrical	■
660V030-DIAMOND	00023501	2	E	3,0	3,0	6,0	40,0	15,0	2,9	1,5	2	Cylindrical	■
660V040-DIAMOND	00023502	2	E	4,0	4,0	6,0	40,0	15,0	3,9	2,0	2	Cylindrical	■
660V060-DIAMOND	00023505	2	E	6,0	6,0	10,0	65,0	35,0	5,9	3,0	2	Cylindrical	■
660L030-DIAMOND	00023494	3	D	3,0	3,0	20,0	60,0	–	–	1,5	2	Cylindrical	■
660L040-DIAMOND	00023496	3	D	4,0	4,0	30,0	60,0	–	–	2,0	2	Cylindrical	■
660L060-DIAMOND	00023498	3	D	6,0	6,0	40,0	100,0	–	–	3,0	2	Cylindrical	■
660VL030-DIAMOND	00023511	4	E	3,0	3,0	6,0	60,0	30,0	2,9	1,5	2	Cylindrical	■
660VL040-DIAMOND	00023512	4	E	4,0	4,0	6,0	60,0	30,0	3,9	2,0	2	Cylindrical	■
660VL060-DIAMOND	00023516	4	E	6,0	6,0	10,0	100,0	70,0	5,8	3,0	2	Cylindrical	■

■ **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)*

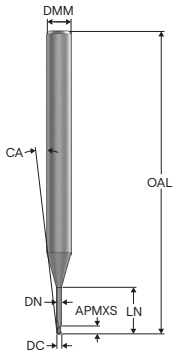
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

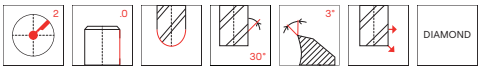
SMB614/616

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	LN	DN	RE	CA°	PCEDC	Attacco	Prodotto standard
					mm	mm	mm	mm	mm	mm	mm				
SMB614010G4B.0Z2	DIA	10108776	4	G	1,0	4,0	1,0	50,0	7,5	0,95	0,5	6,54	2	Cylindrical	■
SMB614020G4B.0Z2	DIA	10108777	4	G	2,0	4,0	2,0	50,0	12,0	1,9	1,0	3,74	2	Cylindrical	■
SMB614030G4B.0Z2	DIA	10108778	4	G	3,0	4,0	3,0	50,0	20,0	2,85	1,5	1,36	2	Cylindrical	■
SMB614020G5B.0Z2	DIA	10108779	5	G	2,0	4,0	2,0	50,0	16,0	1,9	1,0	3,13	2	Cylindrical	■
SMB614006G6B.0Z2	DIA	10108780	6	G	0,6	4,0	0,6	50,0	6,0	0,55	0,3	7,72	2	Cylindrical	■
SMB614008G6B.0Z2	DIA	10108781	6	G	0,8	4,0	0,8	50,0	10,0	0,75	0,4	5,69	2	Cylindrical	■
SMB614010G6B.0Z2	DIA	10108782	6	G	1,0	4,0	0,5	50,0	12,0	0,95	0,5	4,88	2	Cylindrical	■
SMB614020G6B.0Z2	DIA	10108783	6	G	2,0	4,0	2,0	50,0	20,0	1,9	1,0	2,46	2	Cylindrical	■
SMB614006G7B.0Z2	DIA	10108784	7	G	0,6	4,0	0,6	50,0	10,0	0,55	0,3	5,87	2	Cylindrical	■
SMB614010G7B.0Z2	DIA	10108785	7	G	1,0	4,0	1,0	50,0	18,0	0,95	0,5	3,64	2	Cylindrical	■

■ **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 699 - 707

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)*

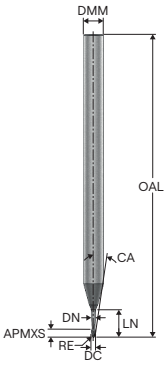
Per il ricalcolo dei parametri di taglio, vedere le pagine 699 - 707

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

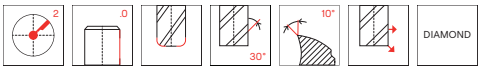
JME642

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	Attacco	Prodotto standard
				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	Cylindrical	■
JME642003G1R002.0Z2-DIA	03215525	1	G	0,3	4,0	0,5	40,0	0,5	0,28	0,02	14,1	2	Cylindrical	■
JME642004G1R004.0Z2-DIA	03215526	1	G	0,4	4,0	0,6	40,0	2,0	0,37	0,04	11,67	2	Cylindrical	■
JME642005G3R005.0Z2-DIA	03215527	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,05	10,97	2	Cylindrical	■
JME642006G3R006.0Z2-DIA	03215528	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,06	10,31	2	Cylindrical	■
JME642008G3R008.0Z2-DIA	03215529	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,08	9,31	2	Cylindrical	■
JME642010G3R010.0Z2-DIA	03215530	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,1	8,04	2	Cylindrical	■
JME642012G3R012.0Z2-DIA	03215531	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,12	7,09	2	Cylindrical	■
JME642015G3R015.0Z2-DIA	03215532	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,15	5,8	2	Cylindrical	■
JME642020G3R015.0Z2-DIA	03236441	3	G	2,0	4,0	2,2	60,0	10,0	1,9	0,15	4,11	2	Cylindrical	■
JME642020G3R020.0Z2-DIA	03215533	3	G	2,0	4,0	3,0	60,0	10,0	1,9	0,2	4,11	2	Cylindrical	■
JME642005G5R005.0Z2-DIA	03215534	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,05	9,43	2	Cylindrical	■
JME642006G5R006.0Z2-DIA	03215535	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,06	8,5	2	Cylindrical	■
JME642008G5R008.0Z2-DIA	03215536	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,08	7,02	2	Cylindrical	■
JME642010G5R010.0Z2-DIA	03215537	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,1	6,06	2	Cylindrical	■
JME642012G5R012.0Z2-DIA	03215538	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,12	5,23	2	Cylindrical	■
JME642015G5R015.0Z2-DIA	03215539	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,15	4,25	2	Cylindrical	■
JME642020G5R015.0Z2-DIA	03236442	5	G	2,0	4,0	2,2	60,0	16,0	1,9	0,15	2,87	2	Cylindrical	■
JME642020G5R020.0Z2-DIA	03215540	5	G	2,0	4,0	3,0	60,0	16,0	1,9	0,2	2,87	2	Cylindrical	■
JME642010G6R010.0Z2-DIA	03215541	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,1	4,86	2	Cylindrical	■
JME642015G6R015.0Z2-DIA	03215542	6	G	1,5	4,0	2,4	50,0	18,0	1,4	0,15	3,13	2	Cylindrical	■
JME642020G6R020.0Z2-DIA	03215543	6	G	2,0	4,0	3,0	60,0	25,0	1,9	0,2	1,97	2	Cylindrical	■
JME642020G7R020.0Z2-DIA	03215544	7	G	2,0	4,0	3,0	60,0	30,0	1,9	0,2	1,68	2	Cylindrical	■

■ **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)*

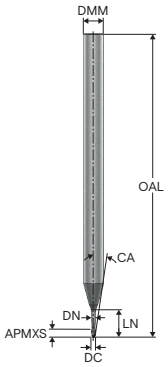
Tabella basata su LV3, eseguire il ricalcolo in base alla versione di lunghezza scelta. Vedere le pagine. 699 - 707

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

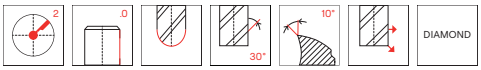
JMB642/JMB662

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	Attacco	Prodotto standard
				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	Cylindrical	■
JMB642003G1B.0Z2-DIA	03215374	1	G	0,3	4,0	0,5	40,0	0,6	0,28	0,15	14,17	2	Cylindrical	■
JMB642004G1B.0Z2-DIA	03215375	1	G	0,4	4,0	2,0	40,0	0,8	0,37	0,2	13,8	2	Cylindrical	■
JMB642005G3B.0Z2-DIA	03215376	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,25	11,19	2	Cylindrical	■
JMB642006G3B.0Z2-DIA	03215377	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,3	10,55	2	Cylindrical	■
JMB642008G3B.0Z2-DIA	03215378	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,4	9,38	2	Cylindrical	■
JMB642010G3B.0Z2-DIA	03215379	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,5	8,33	2	Cylindrical	■
JMB642012G3B.0Z2-DIA	03215380	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,6	7,38	2	Cylindrical	■
JMB642015G3B.0Z2-DIA	03215381	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,75	6,08	2	Cylindrical	■
JMB642020G3B.0Z2-DIA	03215382	3	G	2,0	4,0	3,0	60,0	10,0	1,9	1,0	4,35	2	Cylindrical	■
JMB662030G3B.0Z2-DIA	03215384	3	G	3,0	6,0	3,0	60,0	15,0	2,8	1,5	4,38	2	Cylindrical	■
JMB642005G5B.0Z2-DIA	03215387	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,25	9,6	2	Cylindrical	■
JMB642006G5B.0Z2-DIA	03215388	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,3	8,68	2	Cylindrical	■
JMB642008G5B.0Z2-DIA	03215389	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,4	7,18	2	Cylindrical	■
JMB642010G5B.0Z2-DIA	03215390	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,5	6,22	2	Cylindrical	■
JMB642012G5B.0Z2-DIA	03215391	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,6	5,4	2	Cylindrical	■
JMB642015G5B.0Z2-DIA	03215392	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,75	4,4	2	Cylindrical	■
JMB642020G5B.0Z2-DIA	03215393	5	G	2,0	4,0	3,0	60,0	16,0	1,9	1,0	2,99	2	Cylindrical	■
JMB662030G5B.0Z2-DIA	03215395	5	G	3,0	6,0	3,0	60,0	24,0	2,8	1,5	3,0	2	Cylindrical	■
JMB642010G6B.0Z2-DIA	03215396	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,5	4,96	2	Cylindrical	■
JMB642015G6B.0Z2-DIA	03215397	6	G	1,5	4,0	2,4	60,0	18,0	1,4	0,75	3,21	2	Cylindrical	■
JMB642020G6B.0Z2-DIA	03215398	6	G	2,0	4,0	3,0	60,0	25,0	1,9	1,0	2,03	2	Cylindrical	■
JMB642020G7B.0Z2-DIA	03215399	7	G	2,0	4,0	3,0	60,0	30,0	1,9	1,0	1,72	2	Cylindrical	■

■ **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 699 - 707

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, XHF5831, XHF580, XHF780 XVE540 e XVE510 per tipo con smusso o raggio.
- XSB540, XSB720 e XVB510 per tipo a testa sferica.
- XVC506, XVC509, XS5021, XS5061 e XVC512 per tipo conico.
- XHT740 per tipo a barile.

Selezione utensile X-Heads

							
Nome		XSE550	XSB540	XSE720	XSB720	XSE450	XHT740
Pag.		620	637	639	645	651	655
Famiglia		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	4,6
CSP			■				
	Metrico	10-20	10-16	10-25	10-20	10-20	10-16
	Pollici	3/8-1		3/8-1	3/8-1	3/8-1	
Lunghezze disponibili		1,2	1	3	3	2	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

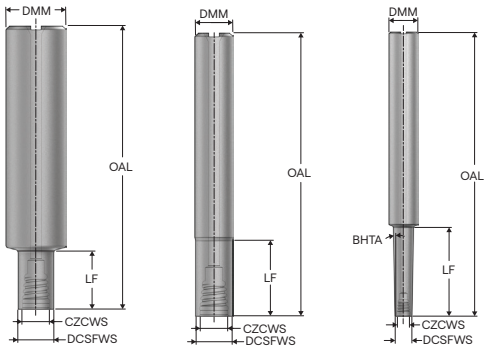
Selezione utensile X-Heads

										
Nome		XHF580	XHF780	XS5021	XS5061	XVE540	XVE510	XVB510	XVC506/509/512	XVK310
Pag.		658	663	669	671	680	685	688	692	696
Famiglia		X-HEADS HFM	X-HEADS HFM	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM
Tipo di fresa										
Numero di eliche		4	4	2	6	3,4	2	2	2	4
CSP		■				■				
	Metrico	10-16	10-16	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	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°	Attacco	Prodotto standard
					mm	mm	mm	mm			
XE10160G1-065-00.0S	10138083	1	G	E10	9,6	16,0	5,0	65,0	0,0	Cylindrical	■
XE12160G1-065-00.0S	10138084	1	G	E12	11,6	16,0	5,0	65,0	0,0	Cylindrical	■
XE16200G1-070-00.0S	10138085	1	G	E16	15,4	20,0	5,0	70,0	0,0	Cylindrical	■
XE20250G1-080-00.0S	10138086	1	G	E20	19,2	25,0	5,0	80,0	0,0	Cylindrical	■
XE25320G1-080-00.0S	10138087	1	G	E25	24,1	32,0	5,0	80,0	0,0	Cylindrical	■
XE10100E2-055-00.0S	10138092	2	E	E10	9,6	10,0	10,0	55,0	0,0	Cylindrical	■
XE10100E2-075-00.0S	10138093	2	E	E10	9,6	10,0	20,0	75,0	0,0	Cylindrical	■
XE12120E2-065-00.0S	10138094	2	E	E12	11,6	12,0	12,0	65,0	0,0	Cylindrical	■
XE12120E2-100-00.0S	10138095	2	E	E12	11,6	12,0	22,0	100,0	0,0	Cylindrical	■
XE10160G2-075-00.0S	10138088	2	G	E10	9,6	16,0	15,0	75,0	0,0	Cylindrical	■
XE12160G2-080-00.0S	10138089	2	G	E12	11,6	16,0	18,0	80,0	0,0	Cylindrical	■
XE12160J2-140-05.0S	10138107	2	J	E12	11,6	16,0	25,1	140,0	5,0	Cylindrical	■
XE16160E2-070-00.0S	10138096	2	E	E16	15,4	16,0	16,0	70,0	0,0	Cylindrical	■
XE16200G2-090-00.0S	10138090	2	G	E16	15,4	20,0	24,0	90,0	0,0	Cylindrical	■
XE16200G2-110-00.0S	10138091	2	G	E16	15,4	20,0	25,0	110,0	0,0	Cylindrical	■
XE20200E2-120-00.0S	10138097	2	E	E20	19,2	20,0	30,0	120,0	0,0	Cylindrical	■
XE25250E2-140-00.0S	10138098	2	E	E25	24,1	25,0	40,0	140,0	0,0	Cylindrical	■
XE25320J2-200-05.0S	10138112	2	J	E25	24,1	32,0	45,1	200,0	5,0	Cylindrical	■
XE10160J3-120-01.0S	10138099	3	J	E10	9,6	16,0	35,0	120,0	1,0	Cylindrical	■
XE10160J3-140-05.0S	10138106	3	J	E10	9,6	16,0	36,6	140,0	5,0	Cylindrical	■
XE12160J3-155-01.0S	10138101	3	J	E12	11,6	16,0	42,0	155,0	1,0	Cylindrical	■
XE16200J3-190-01.0S	10138103	3	J	E16	15,4	20,0	56,0	190,0	1,0	Cylindrical	■
XE16250J3-170-05.0S	10138110	3	J	E16	15,4	25,0	54,9	170,0	5,0	Cylindrical	■
XE20320J3-180-05.0S	10138111	3	J	E20	19,2	32,0	73,2	180,0	5,0	Cylindrical	■
XE12200J4-155-05.0S	10138109	4	J	E12	11,6	20,0	48,0	155,0	5,0	Cylindrical	■
XE16200J4-190-01.0S	10138104	4	J	E16	15,4	20,0	75,0	190,0	1,0	Cylindrical	■
XE20250J4-200-01.0S	10138105	4	J	E20	19,2	25,0	80,0	200,0	1,0	Cylindrical	■
XE12320J4-250-10.0S	10138114	4	J	E12	11,6	32,0	57,8	250,0	10,0	Cylindrical	■
XE10160J5-160-01.0S	10138100	5	J	E10	9,6	16,0	50,0	160,0	1,0	Cylindrical	■
XE12160J5-170-01.0S	10138102	5	J	E12	11,6	16,0	60,0	170,0	1,0	Cylindrical	■
XE10200J5-140-05.0S	10138108	5	J	E10	9,6	20,0	59,4	140,0	5,0	Cylindrical	■
XE10320J6-250-10.0S	10138113	6	J	E10	9,6	32,0	63,5	250,0	10,0	Cylindrical	■

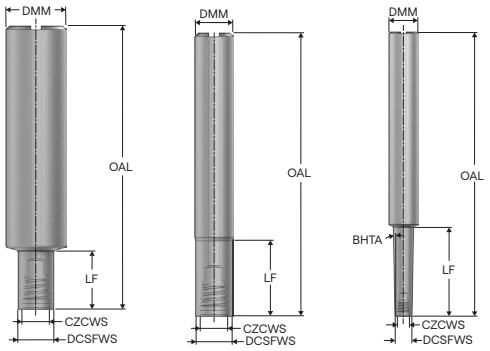
Parti di ricambio, comprese nella fornitura Accessori

Per fresa	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°	Attacco	Prodotto standard
					inch	inch	inch	inch			
XE10.500G1-2.50-00.0S	10138050	1	G	E10	0.360	0.500	0.250	2.500	0,0	Cylindrical	■
XE12.500E1-3.00-00.0S	10138054	1	E	E12	0.480	0.500	0.250	3.000	0,0	Cylindrical	■
XE16.625E1-3.00-00.0S	10138057	1	E	E16	0.606	0.625	0.250	3.000	0,0	Cylindrical	■
XE20.750E1-3.00-00.0S	10138060	1	E	E20	0.724	0.750	0.250	3.000	0,0	Cylindrical	■
XE251.00E1-3.50-00.0S	10138062	1	E	E25	0.961	1.000	0.250	3.500	0,0	Cylindrical	■
XE10.375E2-3.00-00.0S	10334248	2	E	E10	0.362	0.375	0.799	3.000	0,0	Cylindrical	■
XE10.375E2-2.50-00.0S	10138053	2	E	E10	0.360	0.375	0.402	2.500	0,0	Cylindrical	■
XE10.500G2-3.00-00.0S	10138051	2	G	E10	0.360	0.500	1.000	3.000	0,0	Cylindrical	■
XE12.500E2-2.50-00.0S	10138055	2	E	E12	0.480	0.500	0.500	2.500	0,0	Cylindrical	■
XE12.500E2-4.50-00.0S	10138056	2	E	E12	0.480	0.500	1.000	4.500	0,0	Cylindrical	■
XE12.625J2-6.50-05.0S	10138075	2	J	E12	0.480	0.625	0.827	6.500	5,0	Cylindrical	■
XE16.625E2-3.00-00.0S	10138058	2	E	E16	0.606	0.625	0.650	3.000	0,0	Cylindrical	■
XE16.625E2-4.50-00.0S	10138059	2	E	E16	0.606	0.625	1.000	4.500	0,0	Cylindrical	■
XE16.750J2-6.50-05.0S	10138076	2	J	E16	0.606	0.750	0.821	6.500	5,0	Cylindrical	■
XE20.750E2-4.50-00.0S	10138061	2	E	E20	0.724	0.750	1.000	4.500	0,0	Cylindrical	■
XE201.00J2-6.00-05.0S	10334251	2	J	E20	0.724	1.000	1.575	6.000	5,0	Cylindrical	■
XE251.00E2-4.50-00.0S	10218129	2	E	E25	0.961	1.000	1.500	4.500	0,0	Cylindrical	■
XE251.25G2-6.50-00.0S	10138052	2	G	E25	0.961	1.250	2.500	6.500	0,0	Cylindrical	■
XE251.25J2-7.50-05.0S	10218130	2	J	E25	0.961	1.250	1.654	7.500	5,0	Cylindrical	■
XE10.625J3-4.50-01.0S	10138063	3	J	E10	0.360	0.625	1.402	4.500	1,0	Cylindrical	■
XE12.625J3-6.00-01.0S	10138065	3	J	E12	0.480	0.625	1.650	6.000	1,0	Cylindrical	■
XE16.750J3-7.50-01.0S	10138068	3	J	E16	0.606	0.750	2.252	7.500	1,0	Cylindrical	■
XE161.00J3-7.00-05.0S	10138077	3	J	E16	0.606	1.000	2.250	7.000	5,0	Cylindrical	■
XE10.625J4-5.50-05.0S	10334250	4	J	E10	0.374	0.625	1.512	5.500	5,0	Cylindrical	■
XE10.625J4-4.00-03.0S	10138071	4	J	E10	0.360	0.625	1.799	4.000	3,0	Cylindrical	■
XE12.625J4-7.50-01.0S	10138066	4	J	E12	0.480	0.625	2.400	7.500	1,0	Cylindrical	■
XE12.750J4-4.50-03.0S	10138073	4	J	E12	0.480	0.750	2.201	4.500	3,0	Cylindrical	■
XE16.750J4-7.50-01.0S	10138070	4	J	E16	0.606	0.750	3.000	7.500	1,0	Cylindrical	■
XE201.00J4-8.00-01.0S	10334249	4	J	E20	0.724	1.000	3.150	8.000	1,0	Cylindrical	■
XE10.625J5-6.50-01.0S	10138064	5	J	E10	0.360	0.625	2.000	6.500	1,0	Cylindrical	■
XE12.750J5-6.00-03.0S	10138074	5	J	E12	0.480	0.750	2.575	6.000	3,0	Cylindrical	■
XE12.750J5-6.50-01.0S	10138067	5	J	E12	0.480	0.750	2.850	6.500	1,0	Cylindrical	■
XE16.750J6-7.50-01.0S	10138069	6	J	E16	0.606	0.750	3.748	7.500	1,0	Cylindrical	■
XE10.750J9-6.00-03.0S	10138072	9	J	E10	0.360	0.750	3.720	6.000	3,0	Cylindrical	■

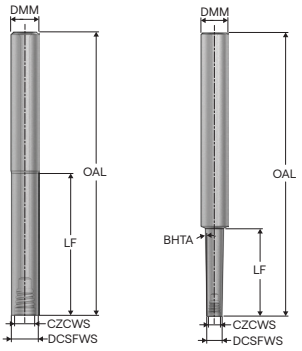
Parti di ricambio, comprese nella fornitura Accessori

Per fresa	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





E J



—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°	Attacco	Prodotto standard
					mm	mm	mm	mm			
XE12160J2-165-05.0E	10334240	2	J	E12	11,6	16,0	25,1	165,0	5,0	Cylindrical	■
XE16200J2-165-05.0E	10334241	2	J	E16	15,4	20,0	26,3	165,0	5,0	Cylindrical	■
XE20200E2-095-00.0E	10138123	2	E	E20	19,2	20,0	38,0	95,0	0,0	Cylindrical	■
XE20250J2-150-05.0E	10334242	2	J	E20	19,2	25,0	33,1	150,0	5,0	Cylindrical	■
XE25320J2-190-05.0E	10218127	2	J	E25	24,1	32,0	45,1	190,0	5,0	Cylindrical	■
XE25320J2-215-05.0E	10218128	2	J	E25	24,1	32,0	45,1	215,0	5,0	Cylindrical	■
XE10120G3-095-00.0E	10334223	3	G	E10	9,6	12,0	30,0	95,0	0,0	Cylindrical	■
XE10160J3-140-05.0E	10334239	3	J	E10	9,6	16,0	36,6	140,0	5,0	Cylindrical	■
XE12160G3-107-00.0E	10334226	3	G	E12	11,6	16,0	36,0	107,0	0,0	Cylindrical	■
XE16160E3-126-00.0E	10334229	3	E	E16	15,4	16,0	48,0	126,0	0,0	Cylindrical	■
XE20320J3-175-05.0E	10334243	3	J	E20	19,2	32,0	73,2	175,0	5,0	Cylindrical	■
XE10120G4-105-00.0E	10334224	4	G	E10	9,6	12,0	40,0	105,0	0,0	Cylindrical	■
XE12120E4-100-00.0E	10138121	4	E	E12	11,6	12,0	48,0	100,0	0,0	Cylindrical	■
XE12160G4-120-00.0E	10334227	4	G	E12	11,6	16,0	48,0	120,0	0,0	Cylindrical	■
XE16160E4-140-00.0E	10334230	4	E	E16	15,4	16,0	64,0	140,0	0,0	Cylindrical	■
XE20250J4-200-02.0E	10138129	4	J	E20	19,2	25,0	83,0	200,0	2,0	Cylindrical	■
XE25250E4-200-00.0E	10138125	4	E	E25	24,1	25,0	120,0	200,0	0,0	Cylindrical	■
XE10100E5-100-00.0E	10138120	5	E	E10	9,6	10,0	50,0	100,0	0,0	Cylindrical	■
XE10120G5-125-00.0E	10334225	5	G	E10	9,6	12,0	50,0	125,0	0,0	Cylindrical	■
XE10160J5-120-01.0E	10334232	5	J	E10	9,6	16,0	50,0	120,0	1,0	Cylindrical	■
XE16160E5-135-00.0E	10138122	5	E	E16	15,4	16,0	80,0	135,0	0,0	Cylindrical	■
XE12160G5-150-00.0E	10334228	5	G	E12	11,6	16,0	60,0	150,0	0,0	Cylindrical	■
XE16200J5-135-01.0E	10334235	5	J	E16	15,4	20,0	80,0	135,0	1,0	Cylindrical	■
XE20200E5-180-00.0E	10138124	5	E	E20	19,2	20,0	110,0	180,0	0,0	Cylindrical	■
XE12160J7-150-01.0E	10138127	7	J	E12	11,6	16,0	90,0	150,0	1,0	Cylindrical	■
XE16200J7-175-01.0E	10138128	7	J	E16	15,4	20,0	118,0	175,0	1,0	Cylindrical	■
XE10160J8-150-01.0E	10334233	8	J	E10	9,6	16,0	80,0	150,0	1,0	Cylindrical	■
XE10160J9-155-01.0E	10138126	9	J	E10	9,6	16,0	100,0	155,0	1,0	Cylindrical	■

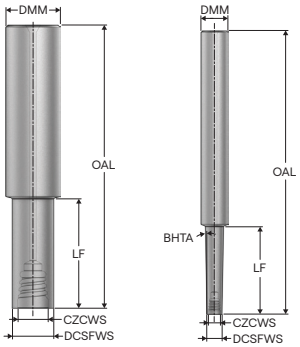
Parti di ricambio, comprese nella fornitura Accessori

Per fresa	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





G J



—Tolleranze:
—DMM= h6
—DCSFWS= ±.002 Pollici
—BHTA= ±20'

Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCSFMS	DMM	LF	OAL	BHTA°	Attacco	Prodotto standard
					inch	inch	inch	inch			
XE12.625J2-6.50-05.0E	10334245	2	J	E12	0.480	0.625	0.827	6.500	5,0	Cylindrical	■
XE16.750J2-6.50-05.0E	10334246	2	J	E16	0.606	0.750	0.823	6.500	5,0	Cylindrical	■
XE201.00J2-6.00-05.0E	10334247	2	J	E20	0.724	1.000	1.575	6.000	5,0	Cylindrical	■
XE251.25G2-6.50-00.0E	10138078	2	G	E25	0.961	1.250	2.500	6.500	0,0	Cylindrical	■
XE251.25J2-8.50-05.0E	10218131	2	J	E25	0.961	1.250	1.654	8.500	5,0	Cylindrical	■
XE10.625J4-5.50-05.0E	10334244	4	J	E10	0.360	0.625	1.512	5.500	5,0	Cylindrical	■
XE12.625J4-7.50-01.0E	10138080	4	J	E12	0.480	0.625	2.400	7.500	1,0	Cylindrical	■
XE16.750J4-7.50-01.0E	10138081	4	J	E16	0.606	0.750	3.000	7.500	1,0	Cylindrical	■
XE201.00J4-8.00-01.0E	10138082	4	J	E20	0.724	1.000	3.150	8.000	1,0	Cylindrical	■
XE10.500G5-5.00-00.0E	10334236	5	G	E10	0.360	0.500	2.000	5.000	0,0	Cylindrical	■
XE10.625J5-6.50-01.0E	10138079	5	J	E10	0.360	0.625	2.000	6.500	1,0	Cylindrical	■
XE12.625G5-6.00-00.0E	10334237	5	G	E12	0.480	0.625	2.400	6.000	0,0	Cylindrical	■
XE16.625E5-7.00-00.0E	10334238	5	E	E16	0.606	0.625	3.200	7.000	0,0	Cylindrical	■

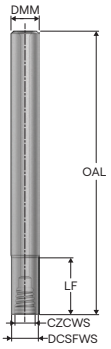
Parti di ricambio, comprese nella fornitura Accessori

Per fresa	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°	Attacco	Prodotto standard
					mm	mm	mm	mm			
XE10100E2-100-00.0DM	10138115	2	E	E10	9,6	10,0	20,0	100,0	0,0	Cylindrical	■
XE12120E2-110-00.0DM	10138116	2	E	E12	11,6	12,0	25,0	110,0	0,0	Cylindrical	■
XE16160E2-130-00.0DM	10138117	2	E	E16	15,4	16,0	35,0	130,0	0,0	Cylindrical	■
XE20200E2-160-00.0DM	10138118	2	E	E20	19,2	20,0	45,0	160,0	0,0	Cylindrical	■
XE25250E2-185-00.0DM	10138119	2	E	E25	24,1	25,0	65,0	185,0	0,0	Cylindrical	■

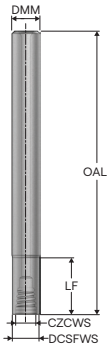
Parti di ricambio, comprese nella fornitura Accessori

Per fresa	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°	Attacco	Prodotto standard
					inch	inch	inch	inch			
XE251.00E2-7.28-00.0DM	10218132	2	E	E25	0.961	1.000	2.559	7.283	0,0	Cylindrical	■

Parti di ricambio, comprese nella fornitura

Accessori

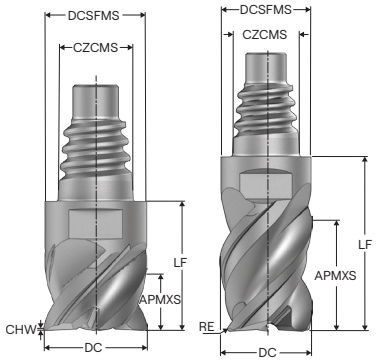
Per fresa	Chiave	Bit	Chiave dinamometrica
			
E25	XW-E25	XTWH-E25.20	XTW-E16.E25

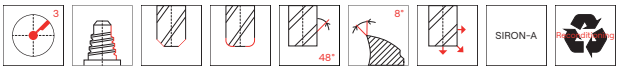
■ **Prodotto standard.**

XSE550

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





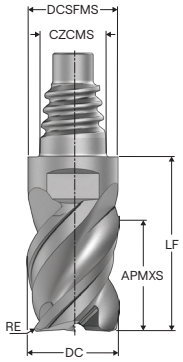


– Tolleranze:
– DC= e7
– RE= ±0,02 mm
– Riaffilatura possibile se DC è ≥Ø12 mm

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
XSE550E10100D1R050Z3	10138138	1	D	E10	10,0	9,7	5,5	12,3	–	0,5	3	8,0	■
XSE550E10100D1R100Z3	10219210	1	D	E10	10,0	9,7	5,5	12,3	–	1,0	3	8,0	■
XSE550E10100D1R200Z3	10219211	1	D	E10	10,0	9,7	5,5	12,3	–	2,0	3	8,0	■
XSE550E10100D2R050Z3	10138142	2	D	E10	10,0	9,7	12,0	18,7	–	0,5	3	8,0	■
XSE550E10100D2R100Z3	10219218	2	D	E10	10,0	9,7	12,0	18,7	–	1,0	3	8,0	■
XSE550E10100D2R200Z3	10219219	2	D	E10	10,0	9,7	12,0	18,7	–	2,0	3	8,0	■
XSE550E12120D1R050Z3	10138139	1	D	E12	12,0	11,7	6,6	14,4	–	0,5	3	10,0	■
XSE550E12120D1R100Z3	10219212	1	D	E12	12,0	11,7	6,6	14,4	–	1,0	3	10,0	■
XSE550E12120D1R200Z3	10219213	1	D	E12	12,0	11,7	6,6	14,4	–	2,0	3	10,0	■
XSE550E12120D2R050Z3	10138143	2	D	E12	12,0	11,7	14,4	22,1	–	0,5	3	10,0	■
XSE550E12120D2R100Z3	10219220	2	D	E12	12,0	11,7	14,4	22,1	–	1,0	3	10,0	■
XSE550E12120D2R200Z3	10219221	2	D	E12	12,0	11,7	14,4	22,1	–	2,0	3	10,0	■
XSE550E16160D1R050Z3	10138140	1	D	E16	16,0	15,5	8,8	18,6	–	0,5	3	12,0	■
XSE550E16160D1R100Z3	10219214	1	D	E16	16,0	15,5	8,8	18,6	–	1,0	3	12,0	■
XSE550E16160D1R200Z3	10219215	1	D	E16	16,0	15,5	8,8	18,6	–	2,0	3	12,0	■
XSE550E16160D2R050Z3	10138144	2	D	E16	16,0	15,5	19,2	29,2	–	0,5	3	12,0	■
XSE550E16160D2R100Z3	10219222	2	D	E16	16,0	15,5	19,2	29,2	–	1,0	3	12,0	■
XSE550E16160D2R200Z3	10219223	2	D	E16	16,0	15,5	19,2	29,2	–	2,0	3	12,0	■
XSE550E20200D1R050Z3	10138141	1	D	E20	20,0	19,3	11,0	21,2	–	0,5	3	16,0	■
XSE550E20200D2R050Z3	10138145	2	D	E20	20,0	19,3	24,0	34,3	–	0,5	3	16,0	■
XSE550E20200D1R100Z3	10219216	1	D	E20	20,0	19,7	11,0	21,2	–	1,0	3	16,0	■
XSE550E20200D1R200Z3	10219217	1	D	E20	20,0	19,7	11,0	21,2	–	2,0	3	16,0	■
XSE550E20200D2R100Z3	10219224	2	D	E20	20,0	19,7	24,0	34,3	–	1,0	3	16,0	■
XSE550E20200D2R200Z3	10219225	2	D	E20	20,0	19,7	24,0	34,3	–	2,0	3	16,0	■
XSE550E25250D1CZ3	10219207	1	D	E25	25,0	24,2	13,75	25,5	0,3125	–	3	20,0	■
XSE550E25250D1R050Z3	10219208	1	D	E25	25,0	24,2	13,75	25,5	–	0,5	3	20,0	■
XSE550E25250D1R100Z3	10219209	1	D	E25	25,0	24,2	13,75	25,5	–	1,0	3	20,0	■

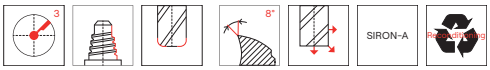
XSE550 – Pollici
Alte prestazioni – Universale – Spallamento – 3 Eliche – Raggio di punta – Pollici





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	8,0	■
XSE550E10.375D2R030Z3	10138149	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8,0	■
XSE550E12.500D1R030Z3	10138147	1	D	E12	0.500	0.484	0.275	0.567	0.030	3	10,0	■
XSE550E12.500D2R030Z3	10138150	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10,0	■
XSE550E20.750D1R030Z3	10138148	1	D	E20	0.750	0.728	0.413	0.835	0.030	3	16,0	■
XSE550E20.750D2R030Z3	10138151	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16,0	■

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)*

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)*

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)*

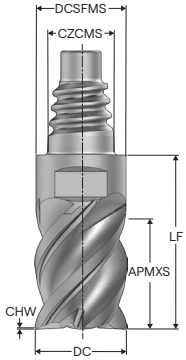
Parametri di taglio – XSE550 – Scanalatura PCEDC 3 – Pollici

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)*

XSE550

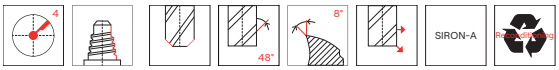
Alte prestazioni – Universale – Spallamento – 4 Eliche – Smusso





D

—Tolleranze:
—DC= e7
—Riaffilatura possibile se DC è ≥Ø12 mm



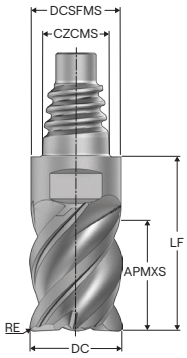
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	CHW	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D1CZ4	10219229	1	D	E10	10,0	9,7	5,5	12,3	0,125	4	8,0	■
XSE550E10100D2CZ4	10138152	2	D	E10	10,0	9,7	12,0	18,7	0,125	4	8,0	■
XSE550E12120D1CZ4	10219230	1	D	E12	12,0	11,7	6,6	14,4	0,15	4	10,0	■
XSE550E12120D2CZ4	10138153	2	D	E12	12,0	11,7	14,4	22,1	0,15	4	10,0	■
XSE550E16160D1CZ4	10219231	1	D	E16	16,0	15,5	8,8	18,6	0,2	4	12,0	■
XSE550E16160D2CZ4	10138154	2	D	E16	16,0	15,5	19,2	29,2	0,2	4	12,0	■
XSE550E20200D2CZ4	10138155	2	D	E20	20,0	19,3	24,0	34,3	0,25	4	16,0	■
XSE550E20200D1CZ4	10219232	1	D	E20	20,0	19,7	11,0	21,2	0,25	4	16,0	■
XSE550E25250D1CZ4	10219226	1	D	E25	25,0	24,2	13,75	25,5	0,3125	4	20,0	■

■ **Prodotto standard.**

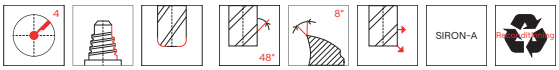
XSE550

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





D



—Tolleranze:
—DC= e7
—RE= ±0,02 mm
—Riaffilatura possibile se DC è ≥Ø12 mm

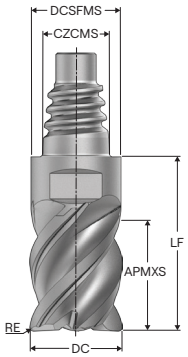
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D1R100Z4	10219233	1	D	E10	10,0	9,7	5,5	12,3	1,0	4	8,0	■
XSE550E10100D1R200Z4	10219234	1	D	E10	10,0	9,7	5,5	12,3	2,0	4	8,0	■
XSE550E10100D1R050Z4	10138156	1	D	E10	10,0	9,7	5,5	12,3	0,5	4	8,0	■
XSE550E10100D2R100Z4	10138161	2	D	E10	10,0	9,7	12,0	18,7	1,0	4	8,0	■
XSE550E10100D2R050Z4	10138160	2	D	E10	10,0	9,7	12,0	18,7	0,5	4	8,0	■
XSE550E10100D2R200Z4	10138162	2	D	E10	10,0	9,7	12,0	18,7	2,0	4	8,0	■
XSE550E10100D2R250Z4	10138163	2	D	E10	10,0	9,7	12,0	18,7	2,5	4	8,0	■
XSE550E12120D1R100Z4	10219235	1	D	E12	12,0	11,7	6,6	14,4	1,0	4	10,0	■
XSE550E12120D1R200Z4	10219236	1	D	E12	12,0	11,7	6,6	14,4	2,0	4	10,0	■
XSE550E12120D1R050Z4	10138157	1	D	E12	12,0	11,7	6,6	14,4	0,5	4	10,0	■
XSE550E12120D2R100Z4	10138165	2	D	E12	12,0	11,7	14,4	22,1	1,0	4	10,0	■
XSE550E12120D2R050Z4	10138164	2	D	E12	12,0	11,7	14,4	22,1	0,5	4	10,0	■
XSE550E12120D2R200Z4	10138166	2	D	E12	12,0	11,7	14,4	22,1	2,0	4	10,0	■
XSE550E12120D2R300Z4	10138167	2	D	E12	12,0	11,7	14,4	22,1	3,0	4	10,0	■
XSE550E16160D1R100Z4	10219237	1	D	E16	16,0	15,5	8,8	18,6	1,0	4	12,0	■
XSE550E16160D1R200Z4	10219238	1	D	E16	16,0	15,5	8,8	18,6	2,0	4	12,0	■
XSE550E16160D1R050Z4	10138158	1	D	E16	16,0	15,5	8,8	18,6	0,5	4	12,0	■
XSE550E16160D2R100Z4	10138169	2	D	E16	16,0	15,5	19,2	29,2	1,0	4	12,0	■
XSE550E16160D2R050Z4	10138168	2	D	E16	16,0	15,5	19,2	29,2	0,5	4	12,0	■
XSE550E16160D2R200Z4	10138170	2	D	E16	16,0	15,5	19,2	29,2	2,0	4	12,0	■
XSE550E16160D2R300Z4	10138171	2	D	E16	16,0	15,5	19,2	29,2	3,0	4	12,0	■
XSE550E20200D1R100Z4	10138159	1	D	E20	20,0	19,3	11,0	21,2	1,0	4	16,0	■
XSE550E20200D2R100Z4	10138172	2	D	E20	20,0	19,3	24,0	34,3	1,0	4	16,0	■
XSE550E20200D2R200Z4	10138173	2	D	E20	20,0	19,3	24,0	34,3	2,0	4	16,0	■
XSE550E20200D2R300Z4	10138174	2	D	E20	20,0	19,3	24,0	34,3	3,0	4	16,0	■
XSE550E20200D2R400Z4	10138175	2	D	E20	20,0	19,3	24,0	34,3	4,0	4	16,0	■
XSE550E20200D1R200Z4	10219239	1	D	E20	20,0	19,7	11,0	21,2	2,0	4	16,0	■
XSE550E25250D1R100Z4	10219227	1	D	E25	25,0	24,2	13,75	25,5	1,0	4	20,0	■
XSE550E25250D1R200Z4	10219228	1	D	E25	25,0	24,2	13,75	25,5	2,0	4	20,0	■

■ **Prodotto standard.**

XSE550 – Pollici

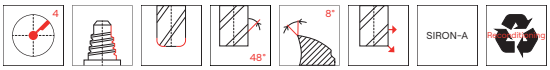
Alte prestazioni – Universale – Spallamento – 4 Eliche – Raggio di punta – Pollici





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	8,0	■
XSE550E10.375D2R030Z4	10138179	2	D	E10	0.375	0.364	0.450	0.720	0.030	4	8,0	■
XSE550E12.500D1R030Z4	10138177	1	D	E12	0.500	0.484	0.275	0.567	0.030	4	10,0	■
XSE550E12.500D2R030Z4	10138180	2	D	E12	0.500	0.484	0.600	0.906	0.030	4	10,0	■
XSE550E20.750D1R030Z4	10138178	1	D	E20	0.750	0.728	0.413	0.835	0.030	4	16,0	■
XSE550E20.750D2R030Z4	10138181	2	D	E20	0.750	0.728	0.900	1.295	0.030	4	16,0	■

■ **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)*

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)*

Parametri di taglio – XSE550 – Contornatura PCEDC 4 – Pollici

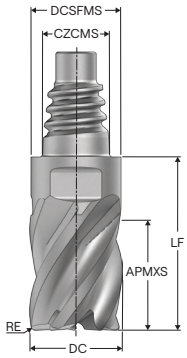
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	195 (170 — 220) *640 (560 — 720)*
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)*

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)*

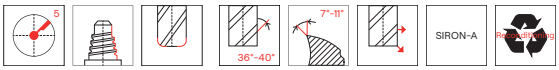
XSE550
Alte prestazioni – Universale – Spallamento – 5 Eliche – Raggio di punta





D

– Tolleranze:
– DC= 0/-0,0508 mm
– RE= ±0,0254 mm
– Riaffilatura possibile se DC è ≥Ø12 mm



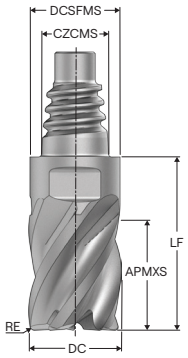
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D2R050Z5	10138337	2	D	E10	10,0	9,7	12,0	18,7	0,5	5	8,0	■
XSE550E10100D2R100Z5	10138338	2	D	E10	10,0	9,7	12,0	18,7	1,0	5	8,0	■
XSE550E12120D2R050Z5	10138339	2	D	E12	12,0	11,7	14,4	22,1	0,5	5	10,0	■
XSE550E12120D2R100Z5	10138340	2	D	E12	12,0	11,7	14,4	22,1	1,0	5	10,0	■
XSE550E16160D2R050Z5	10138341	2	D	E16	16,0	15,5	19,2	29,2	0,5	5	12,0	■
XSE550E16160D2R100Z5	10138342	2	D	E16	16,0	15,5	19,2	29,2	1,0	5	12,0	■
XSE550E20200D2R050Z5	10138343	2	D	E20	20,0	19,3	24,0	34,3	0,5	5	16,0	■
XSE550E20200D2R100Z5	10138344	2	D	E20	20,0	19,3	24,0	34,3	1,0	5	16,0	■

■ **Prodotto standard.**

XSE550

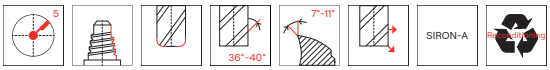
Alte prestazioni – Universale – Spallamento – 5 Eliche – Raggio di punta – Pollici





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	8,0	■
XSE550E10.375D2R030Z5	10138346	2	D	E10	0.375	0.364	0.450	0.720	0.030	5	8,0	■
XSE550E10.375D2R045Z5	10138347	2	D	E10	0.375	0.364	0.450	0.720	0.044	5	8,0	■
XSE550E12.500D2R030Z5	10138348	2	D	E12	0.500	0.484	0.600	0.906	0.030	5	10,0	■
XSE550E12.500D2R060Z5	10138349	2	D	E12	0.500	0.484	0.600	0.906	0.060	5	10,0	■
XSE550E12.500D2R120Z5	10138350	2	D	E12	0.500	0.484	0.600	0.906	0.120	5	10,0	■
XSE550E16.625D2R030Z5	10138351	2	D	E16	0.625	0.610	0.750	1.150	0.030	5	12,0	■
XSE550E16.625D2R060Z5	10138352	2	D	E16	0.625	0.610	0.750	1.150	0.060	5	12,0	■
XSE550E16.625D2R120Z5	10138353	2	D	E16	0.625	0.610	0.750	1.150	0.120	5	12,0	■
XSE550E20.750D2R030Z5	10138354	2	D	E20	0.750	0.728	0.900	1.295	0.030	5	16,0	■
XSE550E20.750D2R060Z5	10138355	2	D	E20	0.750	0.728	0.900	1.295	0.060	5	16,0	■
XSE550E20.750D2R120Z5	10138356	2	D	E20	0.750	0.728	0.900	1.295	0.120	5	16,0	■
XSE550E251.00D2R030Z5	10138357	2	D	E25	1.000	0.965	1.200	1.673	0.030	5	20,0	■
XSE550E251.00D2R060Z5	10138358	2	D	E25	1.000	0.965	1.200	1.673	0.060	5	20,0	■
XSE550E251.00D2R120Z5	10138359	2	D	E25	1.000	0.965	1.200	1.673	0.120	5	20,0	■

■ **Prodotto standard.**

Parametri di taglio – XSE550 – Contornatura PCEDC 5

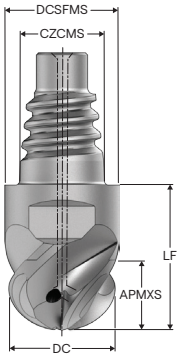
SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	165 (130 — 190) *540 (430 — 620)*
P2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	160 (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)*

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)*

XSB540
Alte prestazioni – Universale – A testa sferica – 4 Eliche





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	RE	PCEDC	SW	Qualità
						mm	mm	mm	mm	mm			SIRA
XSB540E10100D1BZ4A	10138334	1	D	■	E10	10,0	9,7	5,5	12,3	5,0	4	8,0	■
XSB540E12120D1BZ4A	10138335	1	D	■	E12	12,0	11,7	6,6	14,4	6,0	4	10,0	■
XSB540E16160D1BZ4A	10138336	1	D	■	E16	16,0	15,5	8,8	18,6	8,0	4	12,0	■

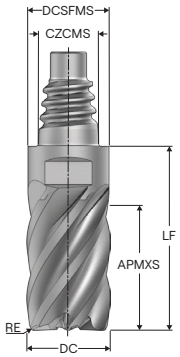
■ **Prodotto standard.**

Parametri di taglio – XSB540 Copiatura sgrossatura

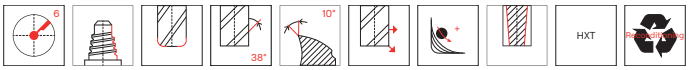
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,10 *0.10*	0,50 *0.50*	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)*

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

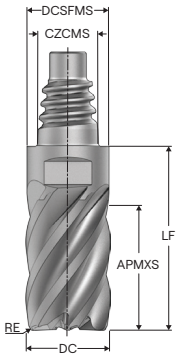
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			HXT
XSE720E10100D3R050Z6	10138187	3	D	E10	10,0	9,7	15,0	21,8	0,5	6	8,0	■
XSE720E10100D3R100Z6	10138188	3	D	E10	10,0	9,7	15,0	21,8	1,0	6	8,0	■
XSE720E12120D3R050Z6	10138189	3	D	E12	12,0	11,7	18,0	25,9	0,5	6	10,0	■
XSE720E12120D3R100Z6	10138190	3	D	E12	12,0	11,7	18,0	25,9	1,0	6	10,0	■
XSE720E12120D3R200Z6	10138191	3	D	E12	12,0	11,7	18,0	25,9	2,0	6	10,0	■
XSE720E12120D3R300Z6	10138192	3	D	E12	12,0	11,7	18,0	25,9	3,0	6	10,0	■
XSE720E16160D3R050Z6	10138193	3	D	E16	16,0	15,5	24,0	34,1	0,5	6	12,0	■
XSE720E16160D3R100Z6	10138194	3	D	E16	16,0	15,5	24,0	34,1	1,0	6	12,0	■
XSE720E16160D3R200Z6	10138195	3	D	E16	16,0	15,5	24,0	34,1	2,0	6	12,0	■
XSE720E16160D3R300Z6	10138196	3	D	E16	16,0	15,5	24,0	34,1	3,0	6	12,0	■
XSE720E20200D3R050Z6	10138197	3	D	E20	20,0	19,3	30,0	40,2	0,5	6	16,0	■
XSE720E20200D3R100Z6	10138198	3	D	E20	20,0	19,3	30,0	40,2	1,0	6	16,0	■
XSE720E20200D3R200Z6	10138199	3	D	E20	20,0	19,3	30,0	40,2	2,0	6	16,0	■
XSE720E20200D3R300Z6	10138200	3	D	E20	20,0	19,3	30,0	40,2	3,0	6	16,0	■
XSE720E25250D3R200Z6	10138201	3	D	E25	25,0	24,2	37,5	49,5	2,0	6	20,0	■
XSE720E25250D3R300Z6	10138202	3	D	E25	25,0	24,2	37,5	49,5	3,0	6	20,0	■
XSE720E25250D3R400Z6	10138203	3	D	E25	25,0	24,2	37,5	49,5	4,0	6	20,0	■

■ **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	8,0	■
XSE720E10.375D3R030Z6	10138209	3	D	E10	0.375	0.364	0.563	0.827	0.030	6	8,0	■
XSE720E12.500D3SZ6	10138205	3	D	E12	0.500	0.484	0.750	1.055	–	6	10,0	■
XSE720E12.500D3R030Z6	10138210	3	D	E12	0.500	0.484	0.750	1.055	0.030	6	10,0	■
XSE720E12.500D3R060Z6	10138211	3	D	E12	0.500	0.484	0.750	1.055	0.060	6	10,0	■
XSE720E12.500D3R120Z6	10138212	3	D	E12	0.500	0.484	0.750	1.055	0.120	6	10,0	■
XSE720E16.625D3SZ6	10138206	3	D	E16	0.625	0.610	0.938	1.343	–	6	12,0	■
XSE720E16.625D3R030Z6	10138213	3	D	E16	0.625	0.610	0.938	1.343	0.030	6	12,0	■
XSE720E16.625D3R060Z6	10138214	3	D	E16	0.625	0.610	0.938	1.343	0.060	6	12,0	■
XSE720E16.625D3R120Z6	10138215	3	D	E16	0.625	0.610	0.938	1.343	0.120	6	12,0	■
XSE720E20.750D3SZ6	10138207	3	D	E20	0.750	0.728	1.125	1.524	–	6	16,0	■
XSE720E20.750D3R030Z6	10138216	3	D	E20	0.750	0.728	1.125	1.524	0.030	6	16,0	■
XSE720E20.750D3R060Z6	10138217	3	D	E20	0.750	0.728	1.125	1.524	0.060	6	16,0	■
XSE720E20.750D3R120Z6	10138218	3	D	E20	0.750	0.728	1.125	1.524	0.120	6	16,0	■
XSE720E251.00D3SZ6	10138208	3	D	E25	1.000	0.965	1.500	1.980	–	6	20,0	■
XSE720E251.00D3R030Z6	10138219	3	D	E25	1.000	0.965	1.500	1.980	0.030	6	20,0	■
XSE720E251.00D3R060Z6	10138220	3	D	E25	1.000	0.965	1.500	1.980	0.060	6	20,0	■
XSE720E251.00D3R120Z6	10138221	3	D	E25	1.000	0.965	1.500	1.980	0.120	6	20,0	■

■ **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

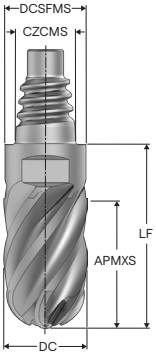
Parametri di taglio – XSE720 sgrossatura avanzata – Pollici

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

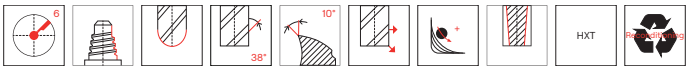
XSB720
Alte prestazioni – Superlega – A testa sferica – 6 Eliche





D

—Tolleranze:
—DC= e7
—RE= ±0,02 mm
—Riaffilatura possibile se DC è ≥Ø12 mm



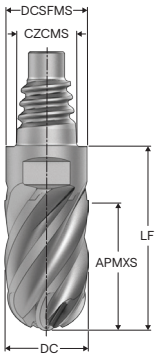
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			HXT
XSB720E10100D3BZ6	10138222	3	D	E10	10,0	9,7	15,0	21,8	5,0	6	8,0	■
XSB720E12120D3BZ6	10138223	3	D	E12	12,0	11,7	18,0	25,9	6,0	6	10,0	■
XSB720E16160D3BZ6	10138224	3	D	E16	16,0	15,5	24,0	34,1	8,0	6	12,0	■
XSB720E20200D3BZ6	10138225	3	D	E20	20,0	19,3	30,0	40,2	10,0	6	16,0	■

■ **Prodotto standard.**

XSB720

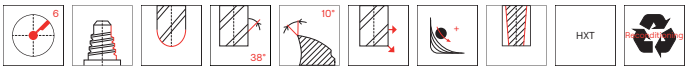
Alte prestazioni – Superlega – A testa sferica – 6 Eliche – Pollici





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	RE	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			HXT
XSB720E10.375D3BZ6	10138226	3	D	E10	0.375	0.364	0.563	0.827	0.188	6	8,0	■
XSB720E12.500D3BZ6	10138227	3	D	E12	0.500	0.484	0.750	1.055	0.250	6	10,0	■
XSB720E16.625D3BZ6	10138228	3	D	E16	0.625	0.610	0.938	1.343	0.313	6	12,0	■
XSB720E20.750D3BZ6	10138229	3	D	E20	0.750	0.728	1.125	1.524	0.375	6	16,0	■
XSB720E251.00D3BZ6	10138230	3	D	E25	1.000	0.965	1.500	1.980	0.500	6	20,0	■

■ **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

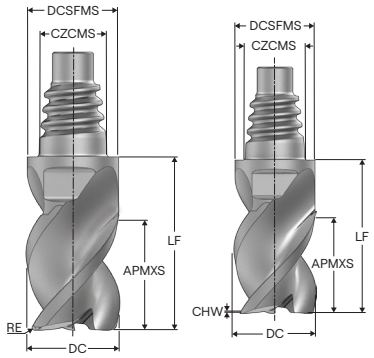
Parametri di taglio – XSB720 Contornatura sgrossatura avanzata a_e/DC=0,07 –

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)*

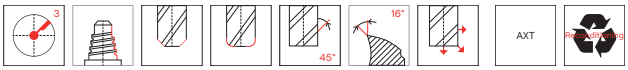
SMG = Gruppo materiale Seco
Refrigerante = A=aria D=a secco E=emulsione M=nebulizzazione
v_c= m/min (sf/min)
f_z = mm (in/dente)
a_p = mm/DC (in/DC) = fattore
a_e = mm/DC (in/DC) = fattore
Tutti i parametri di taglio sono valori indicativi

XSE450
Alte prestazioni – Alluminio – Spallamento – 3 Eliche – Raggio di punta o smusso





—Tolleranze:
—DC= 0/-0,0508 mm
—RE= ±0,0254 mm
—Riaffilatura possibile se DC è ≥Ø12 mm



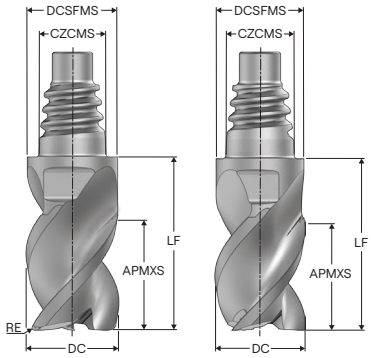
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm	mm			AXT
XSE450E10100D2CZ3	10271542	2	D	E10	10,0	9,7	12,0	18,7	0,1	–	3	8,0	■
XSE450E10100D2R100Z3	10271547	2	D	E10	10,0	9,7	12,0	18,7	–	1,0	3	8,0	■
XSE450E10100D2R050Z3	10138362	2	D	E10	10,0	9,7	12,0	18,7	–	0,5	3	8,0	■
XSE450E12120D2CZ3	10271543	2	D	E12	12,0	11,7	14,4	22,1	0,1	–	3	10,0	■
XSE450E12120D2R300Z3	10271551	2	D	E12	12,0	11,7	14,4	22,1	–	3,0	3	10,0	■
XSE450E12120D2R050Z3	10138363	2	D	E12	12,0	11,7	14,4	22,1	–	0,5	3	10,0	■
XSE450E12120D2R100Z3	10138364	2	D	E12	12,0	11,7	14,4	22,1	–	1,0	3	10,0	■
XSE450E16160D2CZ3	10271544	2	D	E16	16,0	15,5	19,2	29,2	0,1	–	3	12,0	■
XSE450E16160D2R300Z3	10271553	2	D	E16	16,0	15,5	19,2	29,2	–	3,0	3	12,0	■
XSE450E16160D2R050Z3	10138365	2	D	E16	16,0	15,5	19,2	29,2	–	0,5	3	12,0	■
XSE450E16160D2R100Z3	10138366	2	D	E16	16,0	15,5	19,2	29,2	–	1,0	3	12,0	■
XSE450E20200D2CZ3	10271545	2	D	E20	20,0	19,3	24,0	34,3	0,1	–	3	16,0	■
XSE450E20200D2R300Z3	10271555	2	D	E20	20,0	19,3	24,0	34,3	–	3,0	3	16,0	■
XSE450E20200D2R050Z3	10138367	2	D	E20	20,0	19,3	24,0	34,3	–	0,5	3	16,0	■
XSE450E20200D2R100Z3	10138369	2	D	E20	20,0	19,3	24,0	34,3	–	1,0	3	16,0	■

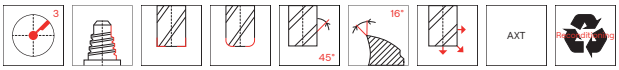
■ **Prodotto standard.**

XSE450

Alte prestazioni – Alluminio – Spallamento – 3 Eliche – Spigolo vivo o 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
XSE450E10.375D2R010Z3	10271561	2	D	E10	0.375	0.364	0.450	0.720	0.010	3	8,0	■
XSE450E10.375D2SZ3	10138370	2	D	E10	0.375	0.364	0.450	0.720	–	3	8,0	■
XSE450E10.375D2R030Z3	10138375	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8,0	■
XSE450E12.500D2R010Z3	10271562	2	D	E12	0.500	0.484	0.600	0.906	0.010	3	10,0	■
XSE450E12.500D2SZ3	10138371	2	D	E12	0.500	0.484	0.600	0.906	–	3	10,0	■
XSE450E12.500D2R030Z3	10138376	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10,0	■
XSE450E12.500D2R060Z3	10138377	2	D	E12	0.500	0.484	0.600	0.906	0.060	3	10,0	■
XSE450E16.625D2SZ3	10138372	2	D	E16	0.625	0.610	0.750	1.150	–	3	12,0	■
XSE450E16.625D2R030Z3	10138378	2	D	E16	0.625	0.610	0.750	1.150	0.030	3	12,0	■
XSE450E16.625D2R060Z3	10138379	2	D	E16	0.625	0.610	0.750	1.150	0.060	3	12,0	■
XSE450E16.625D2R120Z3	10138380	2	D	E16	0.625	0.610	0.750	1.150	0.120	3	12,0	■
XSE450E20.750D2SZ3	10138373	2	D	E20	0.750	0.728	0.900	1.295	–	3	16,0	■
XSE450E20.750D2R030Z3	10138381	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16,0	■
XSE450E20.750D2R060Z3	10138382	2	D	E20	0.750	0.728	0.900	1.295	0.060	3	16,0	■
XSE450E20.750D2R120Z3	10138383	2	D	E20	0.750	0.728	0.900	1.295	0.120	3	16,0	■
XSE450E251.00D2SZ3	10138374	2	D	E25	1.000	0.965	1.200	1.673	–	3	20,0	■
XSE450E251.00D2R030Z3	10138384	2	D	E25	1.000	0.965	1.200	1.673	0.030	3	20,0	■
XSE450E251.00D2R060Z3	10138385	2	D	E25	1.000	0.965	1.200	1.673	0.060	3	20,0	■
XSE450E251.00D2R120Z3	10138386	2	D	E25	1.000	0.965	1.200	1.673	0.120	3	20,0	■

■ **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*	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*	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*	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*	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*	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*	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	0,48 *0.48*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	370 (310 — 410) *1225 (1100 — 1300)*
N2	E/M/A	0,48 *0.48*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	255 (210 — 300) *840 (690 — 980)*
N3	E/M/A	0,48 *0.48*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	170 (140 — 200) *560 (460 — 650)*
N11	E/M/A	0,48 *0.48*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	225 (190 — 270) *740 (630 — 880)*
TS1	A/D	0,48 *0.48*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,48 *0.48*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	255 (160 — 350) *840 (530 — 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)*

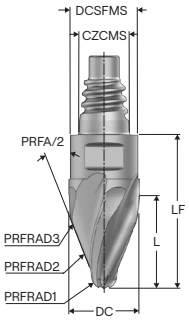
Parametri di taglio – XSE450 Scanalatura – Pollici

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

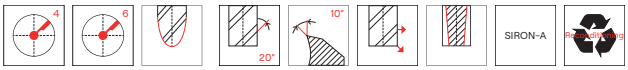
XHT740
Alta velocità – ISO– M e ISO– S – Forma conica – 4-6 Eliche





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 lung-hezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	L	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm	mm	mm	mm				SIRA
XHT740E10100T2R1.5R250Z4	10138388	2	T	E10	10,0	9,7	1,62	18,7	5,4	1,5	250,0	2,0	65,0	4	8,0	■
XHT740E10100T3R2R250Z4	10138391	3	T	E10	10,0	9,7	9,04	21,8	12,7	2,0	250,0	5,0	20,0	4	8,0	■
XHT740E10100T3R2R250Z6	10138395	3	T	E10	10,0	9,7	9,04	21,8	12,7	2,0	250,0	5,0	20,0	6	8,0	■
XHT740E12120T2R3R250Z4	10138389	2	T	E12	12,0	11,7	5,33	22,1	10,5	3,0	250,0	6,0	32,5	4	10,0	■
XHT740E12120T3R3R250Z4	10138392	3	T	E12	12,0	11,7	9,71	25,9	13,7	3,0	250,0	6,0	20,0	4	10,0	■
XHT740E12120T3R3R250Z6	10138396	3	T	E12	12,0	11,7	9,71	25,9	13,7	3,0	250,0	6,0	20,0	6	10,0	■
XHT740E16160T2R4R500Z4	10138390	2	T	E16	16,0	15,5	8,95	29,2	14,6	4,0	500,0	8,0	27,5	4	12,0	■
XHT740E16160T3R4R1000Z4	10138394	3	T	E16	16,0	15,5	21,02	34,1	24,0	4,0	1000,0	5,0	20,0	4	12,0	■
XHT740E16160T3R4R500Z4	10138393	3	T	E16	16,0	15,5	12,94	34,1	17,6	4,0	500,0	8,0	20,0	4	12,0	■
XHT740E16160T3R4R500Z6	10138397	3	T	E16	16,0	15,5	12,94	34,1	17,6	4,0	500,0	8,0	20,0	6	12,0	■

■ **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)*

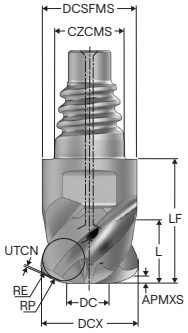
Parametri di taglio – XHT740 – Copiatura PCEDC 6

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

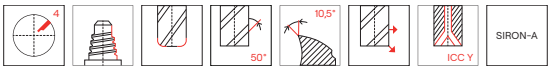
XHF580
Elevato avanzamento – Universale – 4 Eliche – Raggio di punta





D

– Tolleranze:
– DCX= h9
– RE= ±0,03 mm



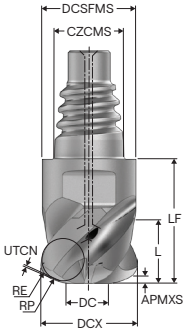
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Qualità
						mm	mm	mm	mm	mm	mm	mm	mm	mm			SIRA
XHF580E10100D1HZ4A	10137971	1	D	■	E10	10,0	3,4	9,7	0,7	6,0	12,4	1,5	1,99	0,27	4	8,0	■
XHF580E12120D1HZ4A	10137972	1	D	■	E12	12,0	4,5	11,7	0,8	7,5	14,5	1,5	2,1	0,323	4	10,0	■
XHF580E16160D1HZ4A	10137973	1	D	■	E16	16,0	6,2	15,5	1,0	10,0	18,7	2,0	2,747	0,426	4	12,0	■

■ **Prodotto standard.**

XHF580

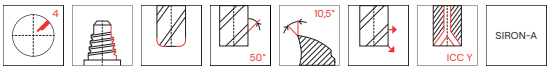
Elevato avanzamento – Universale – 3-4 Eliche – Raggio di punta – Pollici





D

—Tolleranze:
—DCX= h9
—RE= ±.0012 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	8,0	■
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	10,0	■
XHF580E16.625D1HZ4A	10137976	1	D	■	E16	0.625	0.236	0.610	0.039	0.394	0.736	0.080	0.110	0.016	4	12,0	■

■ **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

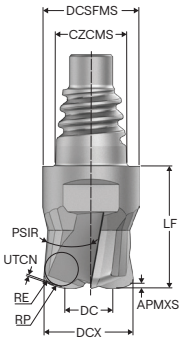
Parametri di taglio – XHF580 Scanalatura – Pollici

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

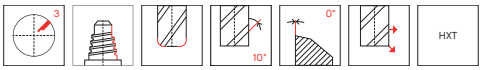
XHF780
Elevato avanzamento – ISO– M e ISO– S – 3 Eliche – Raggio di punta





D

– Tolleranze:
– DCX= -0,02/-0,04 mm
– RE= ±0,05 mm

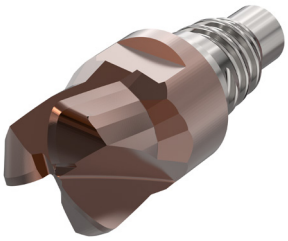


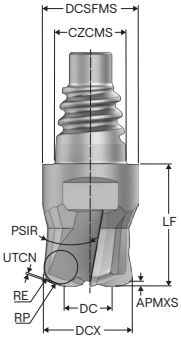
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm	mm	mm	mm	mm			HXT
XHF780E10100D1HZ3	10137957	1	D	E10	10,0	5,0	9,7	0,45	5,5	12,3	0,8	1,175	0,232	3	8,0	■
XHF780E12120D1HZ3	10137958	1	D	E12	12,0	6,0	11,7	0,5	6,6	14,4	1,0	1,416	0,262	3	10,0	■
XHF780E16160D1HZ3	10137959	1	D	E16	16,0	8,0	15,5	0,6	8,8	18,6	1,5	1,989	0,32	3	12,0	■

■ **Prodotto standard.**

XHF780

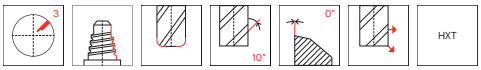
Elevato avanzamento – ISO– M e ISO– S – 3 Eliche – Raggio di punta – Pollici





D

—Tolleranze:
—DCX= -.0008/-0.0016 Pollici
—RE= ±.002 Pollici



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*			HXT
XHF780E10.375D1HZ3	10137960	1	D	E10	0.375	0.188	0.364	0.018	0.206	0.484	0.028	0.043	0.009	3	8,0	■
XHF780E12.500D1HZ3	10137961	1	D	E12	0.500	0.250	0.484	0.020	0.276	0.567	0.045	0.061	0.010	3	10,0	■
XHF780E16.625D1HZ3	10137962	1	D	E16	0.625	0.313	0.610	0.024	0.343	0.732	0.061	0.080	0.012	3	12,0	■

■ **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

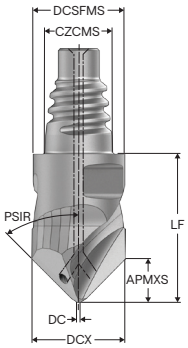
Parametri di taglio – XHF780 Scanalatura – Pollici

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

XS5021
Alte prestazioni – Universale – Smusso –2 Eliche





N

—Tolleranze:
—DCX= 0,02/-0,04 mm
—PSIR= ±0,5°
—Riaffilatura possibile se DC è ≥Ø12 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCX	DCSFMS	APMXS	LF	PSIR°	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm				SIRA
XS5021-E10100N1SZ2T45A	10343896	1	N	E10	0,5	10,0	9,7	7,1	16,0	45,0	2	8,0	■
XS5021-E12120N1SZ2T45A	10343897	1	N	E12	0,6	12,0	11,7	8,6	19,0	45,0	2	10,0	■
XS5021-E16160N1SZ2T45A	10343898	1	N	E16	0,8	16,0	15,5	12,0	26,4	45,0	2	12,0	■

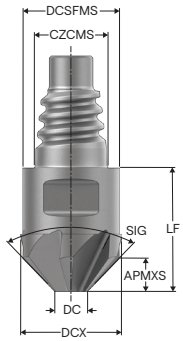
■ **Prodotto standard.**

Parametri di taglio – XS5021 Smussatura

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,075 *0.0030*	0,095 *0.0037*	275 (135 — 310) *900 (440 — 1010)*
P2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,075 *0.0030*	0,095 *0.0037*	270 (130 — 300) *890 (425 — 975)*
P3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,075 *0.0030*	0,095 *0.0037*	235 (110 — 260) *770 (370 — 850)*
P4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	220 (105 — 250) *720 (350 — 810)*
P5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P8	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P11	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	180 (80 — 200) *590 (270 — 650)*
P12	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,07 *0.0028*	0,06 *0.0024*	130 (60 — 140) *425 (200 — 460)*
M1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,095 *0.0037*	220 (100 — 240) *720 (330 — 790)*
M2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	180 (80 — 200) *590 (270 — 650)*
M3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,06 *0.0024*	0,07 *0.0028*	145 (65 — 155) *475 (210 — 510)*
M4	E/M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,06 *0.0024*	110 (50 — 120) *360 (160 — 390)*
M5	E/M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,06 *0.0024*	90 (40 — 100) *295 (140 — 330)*
K1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	215 (100 — 235) *710 (340 — 770)*
K2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	190 (90 — 205) *620 (300 — 675)*
K3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	160 (75 — 175) *520 (250 — 570)*
K4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	150 (70 — 165) *490 (240 — 540)*
K5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	80 (45 — 100) *260 (145 — 330)*
K6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	115 (65 — 145) *375 (210 —480)*
K7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	100 (60 — 130) *330 (190 — 425)*
N1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	1250 (775— 1800) *4100 (2540 — 5900)*
N2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	570 (310 — 720) *1870 (1020 — 2370)*
N3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	380 (210 — 480) *1240 (680 — 1580)*
N11	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	610 (240 — 555) *2000 (780 — 1820)*
S1	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	30 (17 — 40) *100 (55 — 125)*
S2	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	24 (15 — 31) *80 (44 — 102)*
S3	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	21 (12 — 27) *70 (38 — 88)*
S11	E	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	43 (25 — 55) *140 (80 — 180)*
S12	E	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	33 (20 — 42) *108 (60 — 138)*
S13	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	26 (15 — 33) *85 (50 — 110)*
H5	M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	60 (30 — 70) *195 (105— 240)*
H8	M/A	0,20 *0.20*	0,20 *0.20*	0,025 *0.0010*	0,035 *0.0014*	0,05 *0.0020*	60 (30 — 70) *195 (105— 240)*
H21	M/A	0,20 *0.20*	0,20 *0.20*	0,025 *0.0010*	0,035 *0.0014*	0,05 *0.0020*	60 (30 — 70) *195 (105— 240)*
H31	M/A	0,20 *0.20*	0,20 *0.20*	0,025 *0.0010*	0,035 *0.0014*	0,05 *0.0020*	45 (25 — 55) *145 (80 — 185)*

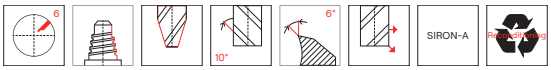
XS5061
Alte prestazioni – Universale – Smusso –6 Eliche





N

—Tolleranze:
—PSIR= ±0,5°
—Riaffilatura possibile se DC è ≥Ø12 mm



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCX	DCSFMS	APMXS	LF	PSIR°	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm				SIRA
XS5061-E10100N1SZ6T45	10219277	1	N	E10	1,95	10,1	9,7	4,075	12,3	45,0	6	8,0	■
XS5061-E12120N1SZ6T45	10219278	1	N	E12	2,95	12,1	11,7	4,575	14,4	45,0	6	10,0	■
XS5061-E16160N1SZ6T45	10219279	1	N	E16	3,95	16,1	15,5	6,075	18,6	45,0	6	12,0	■

■ **Prodotto standard.**

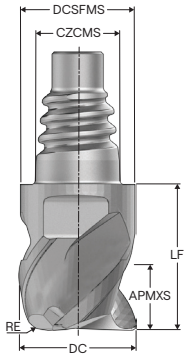
Parametri di taglio – XS5061 Smussatura

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	275 (135 — 310) *900 (440 — 1010)*
P2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	270 (130 — 300) *890 (425 — 975)*
P3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	235 (110 — 260) *770 (370 — 850)*
P4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,06 *0.0024*	0,07 *0.0028*	220 (105 — 250) *720 (350 — 810)*
P5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,06 *0.0024*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P8	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P11	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	180 (80 — 200) *590 (270 — 650)*
P12	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,055 *0.0022*	0,05 *0.0020*	130 (60 — 140) *425 (200 — 460)*
M1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,065 *0.0026*	0,075 *0.0030*	220 (100 — 240) *720 (330 — 790)*
M2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	180 (80 — 200) *590 (270 — 650)*
M3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,055 *0.0022*	145 (65 — 155) *475 (210 — 510)*
M4	E/M/A	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	110 (50 — 120) *360 (160 — 390)*
M5	E/M/A	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	90 (40 — 100) *295 (140 — 330)*
K1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	215 (100 — 235) *710 (340 — 770)*
K2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	190 (90 — 205) *620 (300 — 675)*
K3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	160 (75 — 175) *520 (250 — 570)*
K4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	150 (70 — 165) *490 (240 — 540)*
K5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,065 *0.0026*	80 (45 — 100) *260 (145 — 330)*
K6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	115 (65 — 145) *375 (210 —480)*
K7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,065 *0.0026*	100 (60 — 130) *330 (190 — 425)*
N1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	1250 (775— 1800) *4100 (2540 — 5900)*
N2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	570 (310 — 720) *1870 (1020 — 2370)*
N3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	380 (210 — 480) *1240 (680 — 1580)*
N11	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	610 (240 — 555) *2000 (780 — 1820)*
S1	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	30 (17 — 40) *100 (55 — 125)*
S2	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	24 (15 — 31) *80 (44 — 102)*
S3	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	21 (12 — 27) *70 (38 — 88)*
S11	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,055 *0.0022*	43 (25 — 55) *140 (80 — 180)*
S12	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,055 *0.0022*	33 (20 — 42) *108 (60 — 138)*
S13	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	26 (15 — 33) *85 (50 — 110)*
H5	M/A	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	60 (30 — 70) *195 (105— 240)*
H8	M/A	0,20 *0.20*	0,20 *0.20*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	60 (30 — 70) *195 (105— 240)*
H21	M/A	0,20 *0.20*	0,20 *0.20*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	60 (30 — 70) *195 (105— 240)*
H31	M/A	0,20 *0.20*	0,20 *0.20*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	45 (25 — 55) *145 (80 — 185)*

XVE540

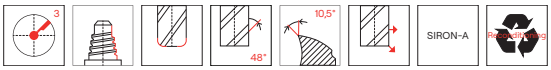
Uso generico – Universale – Spallamento – 3 Eliche – Raggio di punta





D

—Tolleranze:
—DC= h9
—RE= ±0,015 mm
—Riaffilatura possibile se DC è ≥Ø12 mm



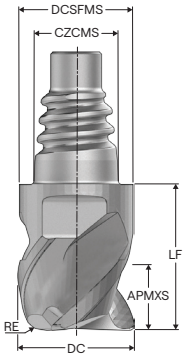
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z3	10137981	1	D	E10	10,0	9,7	5,5	12,4	0,5	3	8,0	■
XVE540E12120D1R050Z3	10137982	1	D	E12	12,0	11,7	6,5	14,5	0,5	3	10,0	■
XVE540E16160D1R050Z3	10137983	1	D	E16	16,0	15,5	8,5	18,7	0,5	3	12,0	■
XVE540E20200D1R050Z3	10137984	1	D	E20	20,0	19,3	11,0	21,3	0,5	3	16,0	■

■ **Prodotto standard.**

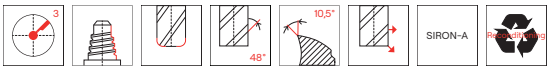
XVE540

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	8,0	■
XVE540E12.500D1R015Z3	10137986	1	D	E12	0.500	0.484	0.276	0.575	0.015	3	10,0	■
XVE540E16.625D1R015Z3	10137987	1	D	E16	0.625	0.610	0.335	0.736	0.015	3	12,0	■
XVE540E20.750D1R031Z3	10137988	1	D	E20	0.750	0.728	0.413	0.839	0.031	3	16,0	■

■ **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)*

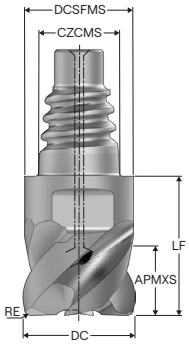
Parametri di taglio – XVE540 – Scanalatura PCEDC 3 – Pollici

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





D

—Tolleranze:
—DC= h9
—RE= ±0,015 mm
—Riaffilatura possibile se DC è ≥Ø12 mm



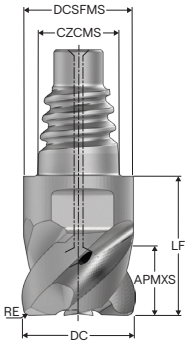
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
						mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z4A	10137989	1	D	■	E10	10,0	9,7	6,0	12,4	0,5	4	8,0	■
XVE540E12120D1R050Z4A	10137990	1	D	■	E12	12,0	11,7	7,5	14,5	0,5	4	10,0	■
XVE540E16160D1R050Z4A	10137991	1	D	■	E16	16,0	15,5	10,0	18,7	0,5	4	12,0	■
XVE540E20200D1R050Z4A	10137992	1	D	■	E20	20,0	19,3	12,0	21,3	0,5	4	16,0	■

■ **Prodotto standard.**

XVE540

Uso generico – Universale – Spallamento – 4 Eliche – Raggio di punta – 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	8,0	■
XVE540E12.500D1R031Z4A	10137994	1	D	■	E12	0.500	0.484	0.315	0.571	0.031	4	12,0	■
XVE540E16.625D1R031Z4A	10137995	1	D	■	E16	0.625	0.610	0.394	0.736	0.031	4	16,0	■
XVE540E20.750D1R031Z4A	10137996	1	D	■	E20	0.750	0.728	0.453	0.839	0.031	4	18,0	■

■ **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)*

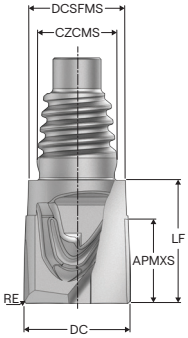
Parametri di taglio – XVE540 – Scanalatura PCEDC 4 Pollici

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

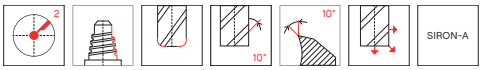
Uso generico – Universale – Spallamento – 2 Eliche – Raggio di punta





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	6,0	■
XVE510E12120D1R050Z2	10138004	1	D	E12	12,0	11,7	10,0	14,0	0,5	2	8,0	■

■ **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)*

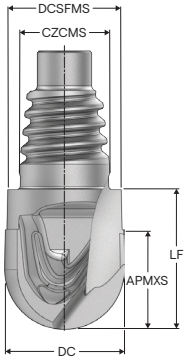
Parametri di taglio – XVE510 Scanalatura

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

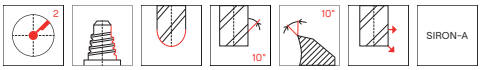
Uso generico – Universale – A testa sferica – 2 Eliche





D

—Tolleranze:
—DC= h9
—RE= ±0,01 mm



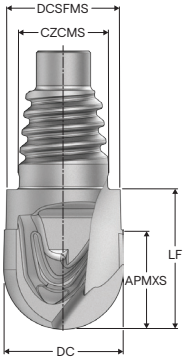
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			SIRA
XVB510E10100D1BZ2	10138005	1	D	E10	10,0	9,7	8,0	11,8	5,0	2	6,0	■
XVB510E12120D1BZ2	10138006	1	D	E12	12,0	11,7	10,0	14,0	6,0	2	8,0	■
XVB510E16160D1BZ2	10138007	1	D	E16	16,0	15,5	13,0	18,1	8,0	2	10,0	■

■ **Prodotto standard.**

XVB510

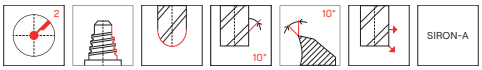
Uso generico – Universale – A testa sferica – 2 Eliche – Pollici





D

—Tolleranze:
—DC= h9
—RE= ±.0004 Pollici



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XVB510E10.375D1BZ2	10138008	1	D	E10	0.375	0.364	0.315	0.465	0.187	2	6,0	■
XVB510E12.500D1BZ2	10138009	1	D	E12	0.500	0.484	0.413	0.551	0.250	2	8,0	■
XVB510E16.625D1BZ2	10138010	1	D	E16	0.625	0.610	0.512	0.713	0.313	2	10,0	■

■ **Prodotto standard.**

Parametri di taglio – XVB510 Copiatura sgrossatura

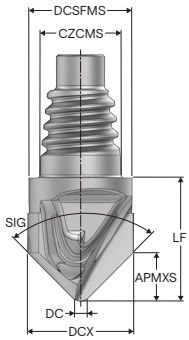
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (150 — 210) *610 (500 — 680)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	180 (150 — 210) *590 (500 — 680)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	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)*

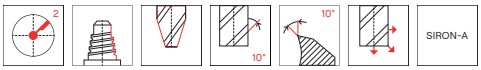
XVC506/509/512
Uso generico – Universale – Smusso – 2 Eliche





N

—Tolleranze:
—SIG= ±1°



Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Qualità
					mm	mm	mm	mm			SIRA
XVC506E10100N1SZ2	10138012	1	N	E10	1,5	9,7	7,23	11,8	2	6,0	■
XVC509E10100N1SZ2	10138014	1	N	E10	1,5	9,7	4,23	11,8	2	6,0	■
XVC506E12120N1SZ2	10138013	1	N	E12	1,5	11,7	7,73	14,0	2	8,0	■
XVC509E12120N1SZ2	10138015	1	N	E12	1,5	11,7	5,23	14,0	2	8,0	■
XVC512E12120N1SZ2	10138017	1	N	E12	1,5	11,7	3,03	14,0	2	8,0	■
XVC509E16160N1SZ2	10138016	1	N	E16	1,5	15,5	7,23	18,1	2	10,0	■

■ **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)*

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)*

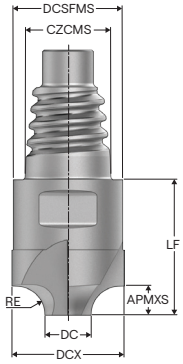
Parametri di taglio – XVC512 Smussatura

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)*

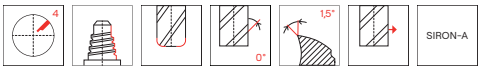
XVK310

Uso generico – Universale – Concava – 4 Eliche





– Tolleranze:
– RE= ≤5= ±0,05 mm
– RE= >5= ±0,1 mm



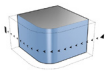
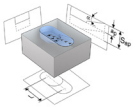
Codice di ordinazione	Codice prodotto	Indice di lunghezza	Forma utensile	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Qualità
					mm	mm	mm	mm	mm			SIRA
XVK310E12120D1K400Z4	10137999	1	D	E12	4,0	11,7	4,0	14,5	4,0	4	10,0	■
XVK310E12120D1K300Z4	10137998	1	D	E12	5,0	11,7	3,0	14,5	3,0	4	10,0	■
XVK310E16160D1K500Z4	10138000	1	D	E16	6,0	15,5	5,0	18,7	5,0	4	12,0	■
XVK310E20200D1K600Z4	10138001	1	D	E20	8,0	19,3	6,0	21,3	6,0	4	16,0	■

■ **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

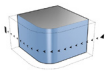
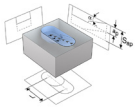
Usare la versione standard contornatura sgrossaturaparametri di taglio e poi ricalcolare i parametri!										Usare la versione standard parametri di taglio con versione standard scanalatura parametri di taglio e poi ricalcolare i parametri!				
	Scanalatura		Contornatura sgrossatura			Contornatura finitura				Rampa		Elicoidale		
Dritto														
	a_p	f_z	a_e	f_z	a_p	v_c	a_e	f_z	a_p	a_p	f_z	f_z	a_p/360º (% di DC)	foro Ø (≥ % di DC)
										≤ 30° *				
C5121														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	80%	100%	80%	100%	80%	100%	80%	100%	100%	100%	100%	100%	170%
LV3	60%	64%	100%	64%	100%	64%	100%	64%	100%	100%	85%	85%	100%	170%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	100%	75%	75%	100%	170%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	100%	65%	65%	100%	170%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	100%	55%	55%	100%	170%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	100%	45%	45%	100%	170%
LV8	x	x	100%	21%	100%	21%	100%	21%	100%	100%	35%	35%	100%	170%
										≤ 10° *				
C5131														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	80%	100%	80%	100%	80%	100%	80%	100%	100%	100%	100%	100%	170%
LV3	60%	64%	100%	64%	100%	64%	100%	64%	100%	100%	85%	85%	100%	170%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	100%	75%	75%	100%	170%
										≤ 30° *				
C5141														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	80%	100%	80%	100%	80%	100%	80%	100%	100%	100%	100%	100%	170%
LV3	60%	64%	100%	64%	100%	64%	100%	64%	100%	100%	85%	85%	100%	170%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	100%	75%	75%	100%	170%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	100%	65%	65%	100%	170%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	100%	55%	55%	100%	170%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	100%	45%	45%	100%	170%
LV8	x	x	100%	21%	100%	21%	100%	21%	100%	100%	35%	35%	100%	170%
LV9	x	x	100%	17%	100%	17%	100%	17%	100%	100%	25%	25%	100%	170%
										≤ 10° *				
C5231														
LV2	100%	100%	100%	100%	100%	100%	80%	100%	80%	100%	100%	100%	100%	100%
LV3	70%	80%	100%	80%	100%	80%	64%	100%	64%	100%	100%	85%	85%	100%
										≤ 10° *				
ST5541														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	90%	100%	85%	70%	90%	100%	85%	100%	100%	85%	85%	100%	170%
LV3	50%	70%	100%	75%	50%	80%	100%	75%	100%	100%	75%	75%	100%	170%
LV4	x	x	100%	65%	40%	70%	100%	65%	100%	100%	65%	65%	100%	170%
										≤ 10° *				
ST5551														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	75%	80%	100%	85%	75%	90%	100%	85%	100%	100%	85%	85%	100%	170%
LV3	x	x	100%	70%	55%	85%	100%	70%	100%	100%	70%	70%	100%	170%
LV4	x	x	100%	55%	25%	75%	100%	55%	100%	100%	55%	55%	100%	170%
LV5	x	x	100%	40%	20%	70%	100%	40%	100%	100%	40%	40%	100%	170%
LV6	x	x	100%	30%	15%	65%	100%	35%	100%	100%	35%	35%	100%	170%
LV8	x	x	100%	15%	10%	60%	100%	25%	100%	100%	25%	25%	100%	170%

*Massimo angolo di entrata in rampa
Tutti i valori sono percentuali dei parametri di taglio originali (100%).

Ricalcolo

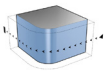
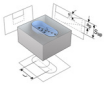
Usare la versione standard contornatura sgrossaturaparametri di taglio e poi ricalcolare i parametri!

Usare la versione standard parametri di taglio con versione standard scanalatura parametri di taglio e poi ricalcolare i parametri!

Dritto	Scanalatura		Contornatura sgrossatura			Contornatura finitura				Rampa		Elicoidale			Foratura	
																
	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/360° (% 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° *						
S4521																
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
										≤ 30° *						
S4531																
LV2	100	100	100	100	100	140	3	35	120	70	100	50	10	130	50	100
LV3	X	X	25	60	240	120	3	40	100	70	70	50	10	130	20	10
										≤ 30° *						
S4651																
LV2	X	X	100	100	100	140	3	35	100	X	X	100	2	130	X	X
LV4	X	X	100	85	200	120	3	40	200	X	X	60	1,5	130	X	X
										≤ 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
LV4	X	X	38	100	200	110	3	55	200	X	X	X	X	X	X	X
JS565																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	100	140	110	3	55	140	X	X	60	1,5	130	X	X
LV4	X	X	38	100	200	110	3	55	200	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

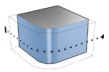
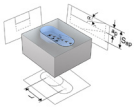
Usare la versione standard contornatura sgrossaturaparametri di taglio e poi ricalcolare i parametri!										Usare la versione standard parametri di taglio con versione standard scanalatura parametri di taglio e poi ricalcolare i parametri!						
	Scanalatura		Contornatura sgrossatura			Contornatura 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/360° (% 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!

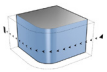
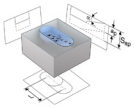
Usare la versione standard parametri di taglio con versione standard scanalatura parametri di taglio e poi ricalcolare i parametri!

Dritto	Scanalatura		Contornatura sgrossatura			Contornatura finitura				Rampa		Elicoidale			Foratura	
																
	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/360° (% 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%).

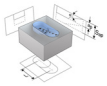
Ricalcolo

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/360° (% 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
										≤5°						
JC899																
LV3	X	X	100	100	100	100	3	50	100	X	X	X	X	X	X	X

*Massimo angolo di entrata in rampa

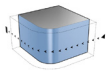
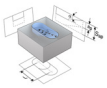
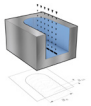
Tutti i valori sono percentuali dei parametri di taglio originali (100%).

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/360° (% 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°						
										≤ 30°						
HP4931																
LV2	100	100	100	100	100	X	X	X	X	50	50	50	5	130	30	50
LV3	100	100	100	100	100	X	X	X	X	50	50	50	5	130	30	50
LV4	100	75	100	75	100	X	X	X	X	50	50	50	5	130	30	50
										≤ 5°						
S4931																
LV3	100	100	100	100	100	X	X	X	X	50	50	50	5	130	X	X
LV4	100	75	100	75	100	X	X	X	X	50	50	50	5	130	X	X
LV5	100	75	100	75	100	X	X	X	X	50	50	50	5	130	X	X
										≤ 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

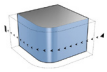
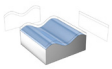
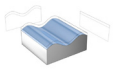
*Massimo angolo di entrata in rampa
Tutti i valori sono percentuali dei parametri di taglio originali (100%).

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/360° (% 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%).

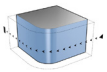
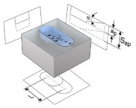
Ricalcolo

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/360° (% 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%).

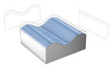
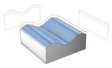
Ricalcolo

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				Rampa		Elicoidale		
SFERA														
	a_p	f_z	a_e	f_z	a_p	v_c	a_e	f_z	a_p	a_p	f_z	f_z	a_p/360º (% di DC)	foro Ø (≥ % di DC)
C5321														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	100%	80%	100%	80%	100%	80%	100%	80%	100%	70%	100%	85%	90%	170%
LV3	100%	64%	100%	64%	100%	64%	100%	64%	100%	65%	100%	85%	75%	160%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	65%	65%	70%	75%	160%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	x	x	65%	75%	160%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	x	x	60%	75%	160%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	x	x	55%	75%	160%
C5341														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	100%	80%	100%	80%	100%	80%	100%	80%	100%	70%	100%	85%	90%	170%
LV3	100%	64%	100%	64%	100%	64%	100%	64%	100%	65%	100%	85%	75%	160%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	65%	65%	70%	75%	160%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	x	x	65%	75%	160%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	x	x	60%	75%	160%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	x	x	55%	75%	160%
LV8	x	x	100%	21%	100%	21%	100%	21%	100%	x	x	50%	75%	160%
ST5341														
LV2	x	x	100%	100%	100%	100%	100%	100%	100%	x	x	x	x	x
LV3	x	x	100%	85%	100%	85%	100%	85%	100%	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				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/360° (% 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

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_c}$$ (giri/min)

Velocità di taglio

$$v_c = \frac{n \cdot \pi \cdot D_c}{1000}$$ (m/min)

Velocità di avanzamento

$$v_f = n \cdot z_n \cdot f_z$$ (mm/min)

Avanzamento per giro

$$f = z_n \cdot f_z$$ (mm/giro)

Volume di truciolo asportato

$$Q = \frac{a_e \cdot a_p \cdot v_f}{1000}$$ (cm^3/min)

Velocità di taglio e numero di giri/min in operazioni di copiatura

$$v_c = \frac{n \cdot \pi \cdot D_w}{1000}$$ (m/min)

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_w}$$ (Numero di giri al minuto)

$$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)}$$ (mm)

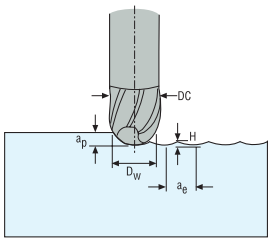
Calcolo di a_p in rapporto alla sporgenza della fresa:
Se la sporgenza (XS) supera il valore di 4 x DC e viene impiegato un attacco cilindrico, è importante adottare un'altra profondità di taglio (a_p) rispetto ai valori della tabella.
Utilizzare la seguente formula per calcolare il nuovo valore di a_p

$a_p$nuovo = a_p x $(4 \times DC/XS)^2$

Altezza profilo

$$H = \frac{D_c}{2} - \frac{\sqrt{D_c^2 - a_e^2}}{2}$$

$$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)}$$ (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

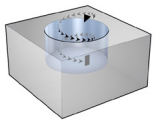
a_p = Profondità di taglio / profondità di taglio assiale (mm)
a_e = Larghezza di taglio / profondità di taglio radiale (mm)
DC = Diametro fresa
f = Avanzamento al giro (mm/giro)
f_z = Avanzamento al dente (mm/dente)
z_n = Numero di denti
n = Giri al minuto (giri/min)
Q = Volume di truciolo asportato (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

Interpolazione elicoidale
La tabella riportata qui di seguito mostra le raccomandazioni del diametro per l’interpolazione elicoidale

Diametro del foro raccomandato per interpolazione elicoidale

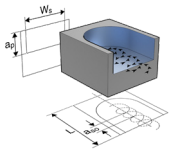
Diametro fresa DC	Diametro del foro
1-2,5	1,4 x DC
3-6	1,3 x DC
8-12	1,2 x DC
16-32	1,15 x DC



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™

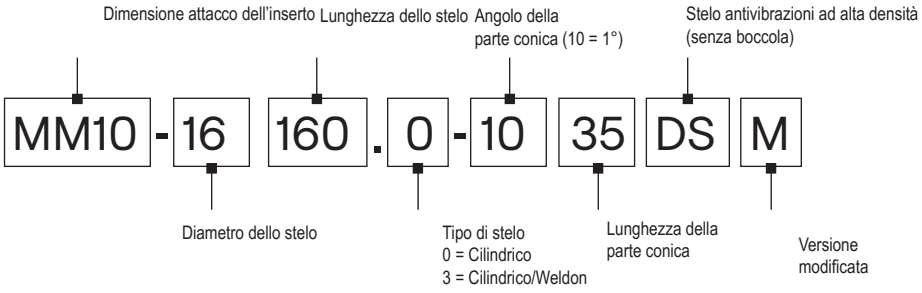
Minimaster™ è un sistema di fresatura esclusivo e versatile in grado di combinare differenti soluzioni offrendo ottima accessibilità in combinazione con le massime stabilità e sicurezza.

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.

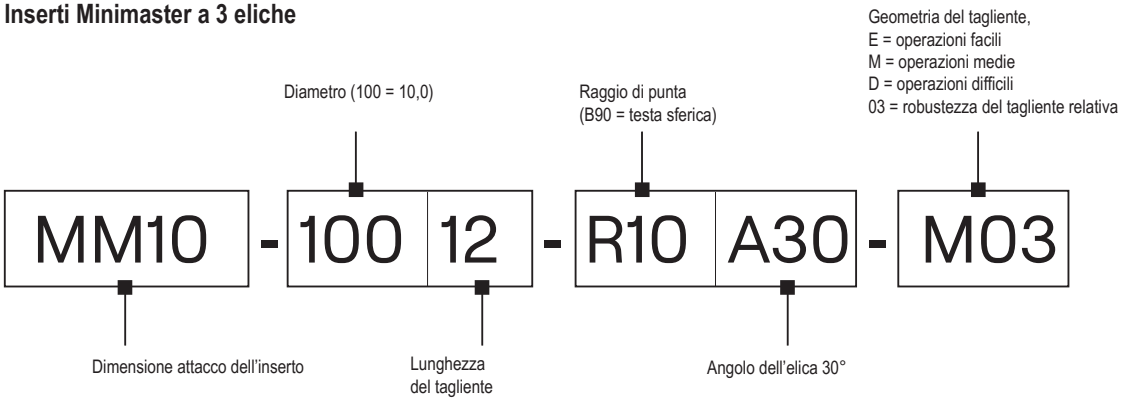
- Gamma a spallamento retto: 6-20 mm (0,25 - 0,75 pollici)
- Gamma a testa sferica: 6-20 mm (0,25 - 0,75 pollici)
- Gamma per centraggio/smussatura: 6-19,05 mm (0,25 - 0,750 pollici)
- Gamma a elevato avanzamento: 8-12 mm (0,375 - 0,625 pollici)
- Gamma per penetrazione assiale: 6-16 mm (0,25 - 0,625 pollici)
- Gamma per raggio concavo: 12 mm (0,472 pollici)

Chiavi di codifica

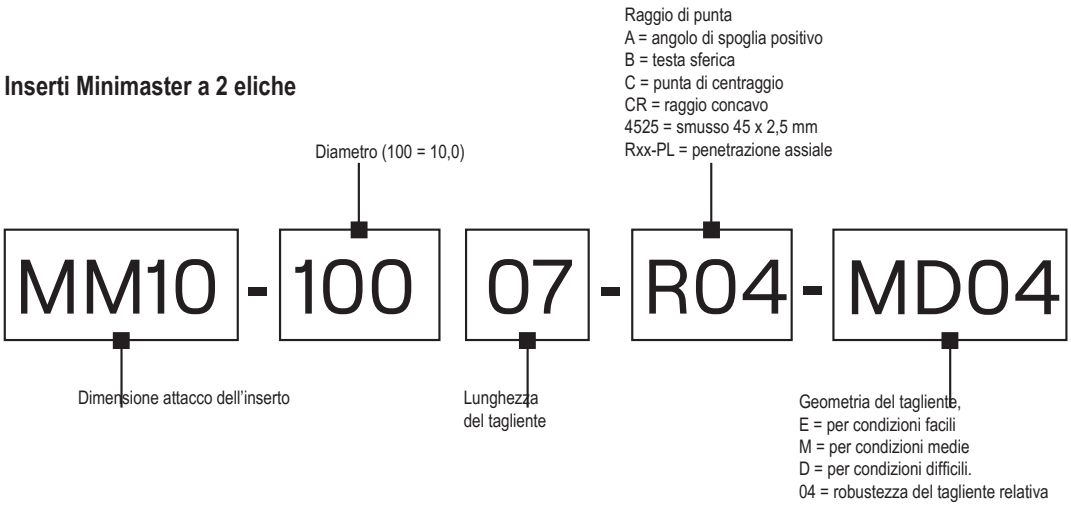
Steli



Inserti Minimaster a 3 eliche



Inserti Minimaster a 2 eliche



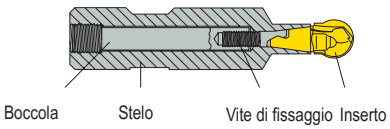
Nota: le parti del codice possono variare in base ai diversi tipi di inserto o di stelo

Adduzione refrigerante interna

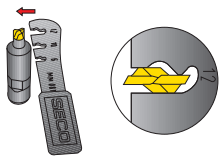


Istruzioni di montaggio per Minimaster a 2 eliche

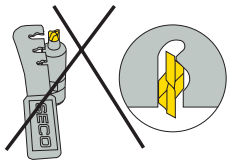
Chiave dinamometrica



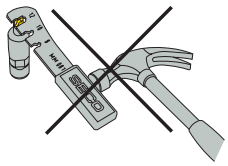
La boccola deve essere serrata saldamente nello stelo prima di montare la vite di fissaggio e l'inserto.
Se non è possibile utilizzare la chiave per sostituire l'inserto (se l'inserto è rotto o incastrato nello stelo), è possibile rilasciare la boccola, che a sua volta libera l'inserto.
Utilizzare la 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).



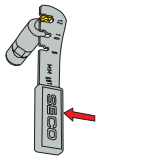
Assicurarsi che la chiave sia utilizzata correttamente



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 802 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

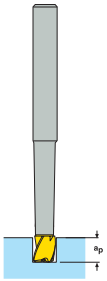


Figura 2

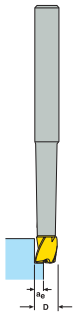


Figura 3

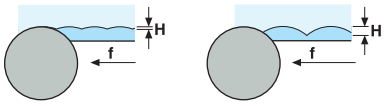


Figura 4

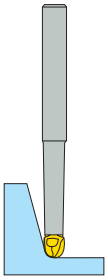


Figura 5

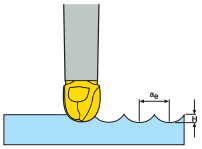
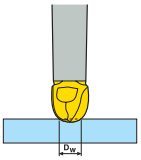
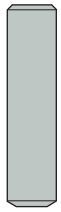
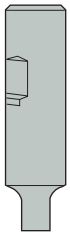
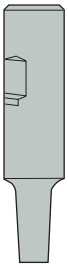
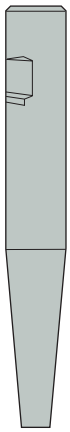
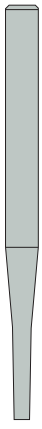


Figura 6

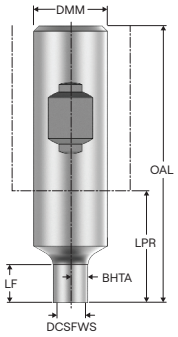


Design dello stelo

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

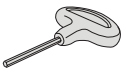




Codice di ordinazione	Codice prodotto	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Disegno	CSP	RPMX	Attacco	Peso	Codice ricambio
		mm	mm	mm	mm	mm						kg	
MM06-10040.0-0007	00094747	5,75	10,0	7,0	7,0	40,0	0,0	2	■	80000	Cylindrical	0,1	2
MM06-10050.0-0007DS	02580666	5,75	10,0	7,0	7,0	50,0	0,0	2	■	80000	Cylindrical Densimet	0,1	3
MM06-10075.0-3041DS	02580701	5,75	10,0	40,5	35,0	75,0	3,0	4	■	80000	Cylindrical Densimet	0,1	3
MM06-10100.0-1035DS	02580713	5,75	10,0	35,0	60,0	100,0	1,0	3	■	80000	Cylindrical Densimet	0,1	3
MM06-12070.3-0005	75080695	5,75	12,0	5,0	25,0	70,0	0,0	2	■	80000	Weldon	0,1	1
MM06-12065.0-0000	75080694	5,7	12,0	0,0	15,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM06-12120.0-1050DS	02580714	5,75	12,0	50,0	75,0	120,0	1,0	3	■	80000	Cylindrical Densimet	0,2	3
MM06-16075.3-3009	75080696	5,75	16,0	9,0	27,0	75,0	3,0	3	■	80000	Weldon	0,1	1
MM06-16110.3-5058	75080697	5,75	16,0	58,6	62,0	110,0	5,0	4	■	80000	Weldon	0,2	4
MM06-16140.0-1020M	00027102	5,75	16,0	20,0	92,0	140,0	1,0	3	■	80000	Cylindrical	0,2	5
MM06-16140.0-1035M	00027103	5,75	16,0	35,0	92,0	140,0	1,0	3	■	80000	Cylindrical	0,2	6
MM06-16140.0-1050M	00094748	5,75	16,0	50,0	92,0	140,0	1,0	3	■	80000	Cylindrical	0,2	6
MM06-16090.0-0012DS	02580670	5,75	16,0	12,0	42,0	90,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM06-16095.0-0024DS	02580673	5,75	16,0	24,0	47,0	95,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM06-16140.0-1050DS	02580717	5,75	16,0	50,0	92,0	140,0	1,0	3	■	80000	Cylindrical Densimet	0,3	3
MM06-16140.0-1035DS	02580716	5,75	16,0	35,0	92,0	140,0	1,0	3	■	80000	Cylindrical Densimet	0,4	3
MM06-20250.0-1035DS	02580718	5,75	20,0	35,0	190,0	250,0	1,0	5	■	80000	Cylindrical Densimet	0,9	3

Parti di ricambio, comprese nella fornitura

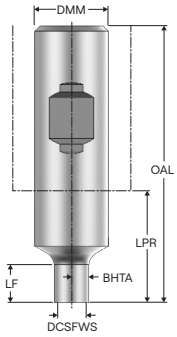
Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
1	MM-035046	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
3	–	MM06-03518	–
4	MM-035091	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4

Chiave a brugola H05-4 per boccola da ordinare separatamente.
Per i tipi di chiave, vedere le pagine sugli inserti

MM06 Stelo – pollici

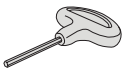




Codice di ordinazione	Codice prodotto	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Disegno	CSP	RPMX	Attacco	Peso	Codice ricambio
		inch	inch	inch	inch	inch						lb	
MM06-0.38-1.6-0-0002	00096107	0.224	0.375	0.276	0.276	1.575	0,0	2	■	80000	Cylindrical	0.220	2
MM06-0.50-2.8-3-0002	00096108	0.224	0.500	0.197	0.984	2.756	0,0	2	■	80000	Weldon	0.220	1
MM06-0.50-2.6-0-0000	00096106	0.224	0.500	0	0.787	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM06-0.62-3.0-3-3003	00096116	0.224	0.625	0.354	1.063	2.953	3,0	1	■	80000	Weldon	0.220	1
MM06-0.62-4.3-3-5022	00096117	0.224	0.625	2.291	2.441	4.331	5,0	2	■	80000	Weldon	0.440	4
MM06-0.62-5.5-0-1007	00096111	0.224	0.625	0.787	3.622	5.512	1,0	3	■	80000	Cylindrical	0.440	5
MM06-0.62-5.5-0-1013	00096112	0.224	0.625	1.378	3.622	5.512	1,0	3	■	80000	Cylindrical	0.440	6
MM06-0.62-5.5-0-1019	00096114	0.224	0.625	1.969	3.622	5.512	1,0	3	■	80000	Cylindrical	0.440	6
MM06-0.62-3.5-0-0004DS	02593394	0.224	0.625	0.472	1.654	3.543	0,0	2	■	80000	Cylindrical Densimet	0.660	3
MM06-0.62-3.7-0-0009DS	02593395	0.224	0.625	0.945	1.850	3.740	0,0	2	■	80000	Cylindrical Densimet	0.660	3
MM06-0.62-5.5-0-1013DS	02593396	0.224	0.625	1.378	3.622	5.512	1,0	3	■	80000	Cylindrical Densimet	0.880	3
MM06-0.62-5.5-0-1019DS	02593397	0.224	0.625	1.969	3.622	5.512	1,0	3	■	80000	Cylindrical Densimet	0.660	3
MM06-0.75-10.0-0-1013DS	02593399	0.224	0.750	1.378	7.874	9.843	1,0	5	■	80000	Cylindrical Densimet	1.760	3

Parti di ricambio, comprese nella fornitura

Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
1	MM-035046	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
3	–	MM06-03518	–
4	MM-035091	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4

Chiave a brugola H05-4 per boccola da ordinare separatamente.
Per i tipi di chiave, vedere le pagine sugli inserti

Scanalatura/fresatura a spallamento retto

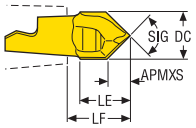


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*	–	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*	–	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*	–	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



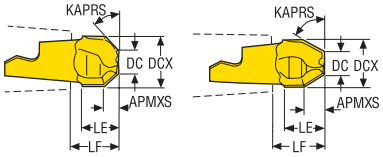


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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 799

Codice di ordinazione	DCX	DC	APMXS	RE	LE	LF	KAPRS°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	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*	0,2 *0.008*	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*	0,2 *0.008*	4,6 *0.181*	5,75 *0.226*	60,0	2	MM0612	■			

Doppia smussatura

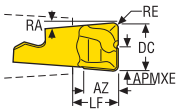


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

Codice di ordinazione	DCX	DC	APMXS	DN	LF	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*	6,0 *0.236*	8,5 *0.335*	90,0	45,0	2	MM0612		■		

Penetrazione assiale

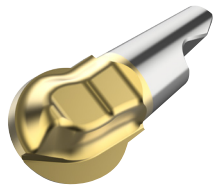




—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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 799

Codice di ordinazione	DC	APMXS	RE	LE	DN	LF	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*	6,0 *0.236*	8,73 *0.344*	263,0	2	MM0612		■		
MM06-08008-B120P-M03	8,0 *0.315*	4,0 *0.157*	4,0 *0.157*	8,0 *0.315*	6,0 *0.236*	8,73 *0.344*	263,0	2	MM0612			■	

Copiatura



—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*		2	MM0612		■		■	
MM06-06006-B90PF-M01	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*		2	MM0612			■		
MM06-06006-B90P-M02	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*		2	MM0612				■	
MM06-06006-B90S-E02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*		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*		2	MM0612				■	
MM06-06406-B90S-E02	6,35 *0.250*	6,3 *0.248*	3,175 *0.125*	7,24 *0.285*		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

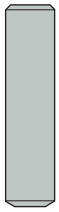
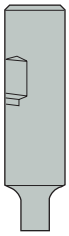
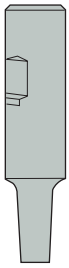
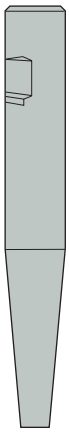
SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
P2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
P3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,032 0.0013	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)

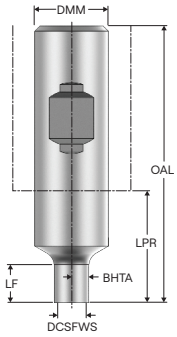
SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	325 *1075*	415 *1350*	430 *1400*	470 *1550*	465 *1525*	275 *900*	345 *1125*	375 *1225*	405 *1325*	405 *1325*	225 *740*	280 *920*	305 *1000*	330 *1075*	325 *1075*
P2	320 *1050*	400 *1300*	420 *1375*	455 *1500*	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

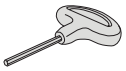




Codice di ordinazione	Codice prodotto	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Disegno	CSP	RPMX	Attacco	Peso	Codice ricambio
		mm	mm	mm	mm	mm						kg	
MM08-10040.0-0007	00083980	7,6	10,0	7,0	7,0	40,0	0,0	2	■	80000	Cylindrical	0,1	2
MM08-10050.0-0007DS	02580665	7,6	10,0	7,0	10,0	50,0	0,0	2	■	80000	Cylindrical Densimet	0,1	3
MM08-10080.0-3023DS	02580702	7,6	10,0	22,9	40,0	80,0	3,0	4	■	80000	Cylindrical Densimet	0,1	3
MM08-12065.0-0000	75034240	7,6	12,0	0,0	20,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM08-12100.0-1035DS	02580719	7,6	12,0	35,0	55,0	100,0	1,0	3	■	80000	Cylindrical Densimet	0,2	3
MM08-12120.0-1050DS	02580720	7,6	12,0	50,0	75,0	120,0	1,0	3	■	80000	Cylindrical Densimet	0,2	3
MM08-16070.3-0007	75034241	7,6	16,0	7,6	22,0	70,0	0,0	2	■	80000	Weldon	0,1	1
MM08-16075.3-3012	75034242	7,6	16,0	12,0	27,0	75,0	3,0	3	■	80000	Weldon	0,1	1
MM08-16120.3-5048M	00042863	7,6	16,0	48,0	72,0	120,0	5,0	4	■	80000	Weldon	0,2	5
MM08-16150.0-1030M	00094751	7,6	16,0	30,0	102,0	150,0	1,0	3	■	80000	Cylindrical	0,2	5
MM08-16150.0-1050M	00094752	7,6	16,0	50,0	102,0	150,0	1,0	3	■	80000	Cylindrical	0,2	4
MM08-16150.0-1070M	00094754	7,6	16,0	70,0	102,0	150,0	1,0	3	■	80000	Cylindrical	0,2	4
MM08-16085.0-0016DS	02580675	7,6	16,0	16,0	37,0	85,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM08-16100.0-0032DS	02580687	7,6	16,0	32,0	52,0	100,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM08-16150.0-1050DS	02580722	7,6	16,0	50,0	102,0	150,0	1,0	3	■	80000	Cylindrical Densimet	0,4	3
MM08-16150.0-1070DS	02580727	7,6	16,0	70,0	102,0	150,0	1,0	3	■	80000	Cylindrical Densimet	0,3	3

Parti di ricambio, comprese nella fornitura

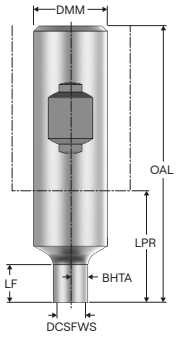
Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
1	MM-05044	MM08-0524	H05-4
2	MM-05019	MM08-0524	H05-4
3	–	MM08-0524	–
4	MM-05044	MM08-0582	H05-4
5	MM-05044	MM08-0543	H05-4

Chiave a brugola H05-4 per boccola da ordinare separatamente.
Per i tipi di chiave, vedere le pagine sugli inserti

MM08 Stelo – pollici





Codice di ordinazione	Codice prodotto	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Disegno	CSP	RPMX	Attacco	Peso	Codice ricambio
		inch	inch	inch	inch	inch						lb	
MM08-0.38-1.6-0-0002	00096119	0.299	0.375	0.276	0.276	1.575	0,0	2	■	80000	Cylindrical	0.220	3
MM08-0.50-2.6-0-0000	75054599	0.299	0.500	0	0.787	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM08-0.62-2.8-3-0003	75054600	0.299	0.625	0.299	0.866	2.756	0,0	2	■	80000	Weldon	0.220	1
MM08-0.62-3.0-3-3004	75054601	0.299	0.625	0.472	1.063	2.953	3,0	3	■	80000	Weldon	0.220	1
MM08-0.62-4.7-3-5018	75054602	0.299	0.625	1.850	2.835	4.724	5,0	4	■	80000	Weldon	0.440	2
MM08-0.62-5.9-0-1011	75054604	0.299	0.625	1.181	4.016	5.906	1,0	3	■	80000	Cylindrical	0.440	2
MM08-0.62-3.3-0-0006DS	02593402	0.299	0.625	0.630	1.457	3.346	0,0	2	■	80000	Cylindrical Densimet	0.660	4
MM08-0.62-4.0-0-0012DS	02593403	0.299	0.625	1.260	2.047	3.937	0,0	2	■	80000	Cylindrical Densimet	0.660	4
MM08-0.62-5.9-0-1019DS	02593407	0.299	0.625	1.969	4.016	5.906	1,0	3	■	80000	Cylindrical Densimet	0.880	4
MM08-0.62-5.9-0-1027DS	02593410	0.299	0.625	2.756	4.016	5.906	1,0	3	■	80000	Cylindrical Densimet	0.660	4
MM08-0.75-10.0-0-1019DS	02593413	0.299	0.750	1.969	7.874	9.843	1,0	5	■	80000	Cylindrical Densimet	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	–

Chiave a brugola H05-4 per boccola da ordinare separatamente.
Per i tipi di chiave, vedere le pagine sugli inserti

Scanalatura/fresatura a spallamento retto

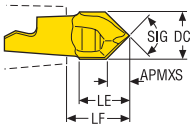


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*	–	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*	–	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



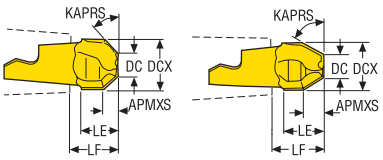


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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



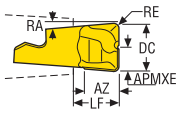


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

Codice di ordinazione	DCX	DC	APMXS	RE	LE	LF	KAPRS°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	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*	0,2 *0.008*	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*	0,24 *0.009*	6,45 *0.254*	7,66 *0.302*	60,0	2	MM0612	■			

Penetrazione assiale

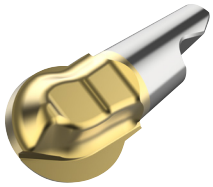




—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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 799

Codice di ordinazione	DC	APMXS	RE	LE	DN	LF	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*	8,0 *0.315*	10,97 *0.432*	254,0	2	MM0612		■		
MM08-10010-B120P-M04	10,0 *0.394*	5,0 *0.197*	5,0 *0.197*	10,0 *0.394*	8,0 *0.315*	10,97 *0.432*	254,0	2	MM0612			■	

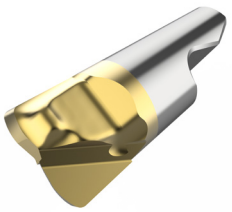
Copiatura

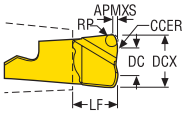


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

Codice di ordinazione	DC	APMXS	RE	LF	FHA	ZEFP	Chiave		Qualità Rivestite T60M	F15M	F30M	F40M
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*								
MM08-08008-B90-MD03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*		2	MM0612		■		■	
MM08-08008-B90PF-M01	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*		2	MM0612			■		
MM08-08008-B90P-M03	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*		2	MM0612				■	
MM08-08008-B90S-E03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*		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 799

Codice di ordinazione	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Chiave	Qualità Rivestite T60M	F15M	F30M	F40M
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*									
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

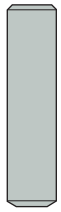
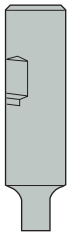
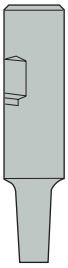
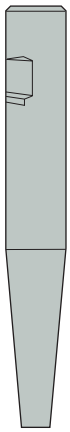
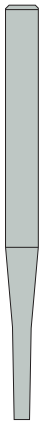
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 0.013	0,32 0.013	0,42 0.017	0,50 0.020
P2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 0.013	0,32 0.013	0,42 0.017	0,50 0.020
P3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 0.012	0,30 0.012	0,40 0.016	0,48 0.019
P4	MM08-08.40-HF-MD06 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

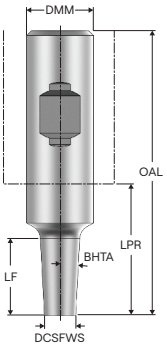
SMG	F30M			
	100%	70%	30%	20%
P1	250 *820*	305 *1000*	350 *1150*	375 *1225*
P2	245 *800*	300 *980*	345 *1125*	365 *1200*
P3	215 *710*	260 *850*	300 *980*	315 *1025*
P4	190 *620*	230 *750*	265 *870*	275 *900*
P5	180 *590*	220 *720*	255 *840*	265 *870*
P6	205 *670*	250 *820*	285 *940*	300 *980*
P7	190 *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	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Disegno	CSP	RPMX	Attacco	Peso	Codice ricambio
		mm	mm	mm	mm	mm						kg	
MM10-10045.0-0007	00083979	9,6	10,0	7,0	7,0	45,0	0,0	2	■	80000	Cylindrical	0,1	2
MM10-12060.0-0007DS	02580667	9,6	12,0	7,0	15,0	60,0	0,0	2	■	76300	Cylindrical Densimet	0,1	3
MM10-12085.0-3024DS	02580704	9,5	12,0	23,8	40,0	85,0	3,0	4	■	76300	Cylindrical Densimet	0,2	3
MM10-12100.0-1035DS	02580733	9,5	12,0	35,0	55,0	100,0	1,0	3	■	76300	Cylindrical Densimet	0,2	3
MM10-14120.0-1050DS	02580736	9,5	14,0	50,0	75,0	120,0	1,0	3	■	76300	Cylindrical Densimet	0,3	3
MM10-16065.0-0000	75004925	9,5	16,0	0,0	17,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM10-16160.0-1035M	00094757	9,5	16,0	35,0	112,0	160,0	1,0	3	■	80000	Cylindrical	0,2	6
MM10-16160.0-1055M	00094758	9,5	16,0	55,0	112,0	160,0	1,0	3	■	80000	Cylindrical	0,2	7
MM10-16160.0-1075M	00094760	9,5	16,0	75,0	112,0	160,0	1,0	3	■	80000	Cylindrical	0,2	7
MM10-16085.0-0020DS	02580688	9,5	16,0	20,0	37,0	85,0	0,0	2	■	76300	Cylindrical Densimet	0,3	3
MM10-16105.0-0040DS	02580689	9,5	16,0	40,0	57,0	105,0	0,0	2	■	76300	Cylindrical Densimet	0,3	3
MM10-16160.0-1055DS	02580748	9,5	16,0	55,0	112,0	160,0	1,0	3	■	76300	Cylindrical Densimet	0,4	3
MM10-16160.0-1075DS	02580749	9,5	16,0	75,0	112,0	160,0	1,0	3	■	76300	Cylindrical Densimet	0,4	3
MM10-20075.3-0010	75012787	9,5	20,0	10,0	25,0	75,0	0,0	2	■	80000	Weldon	0,2	4
MM10-20085.3-3023	75012788	9,5	20,0	23,0	35,0	85,0	3,0	3	■	80000	Weldon	0,2	4
MM10-20140.3-5060	75012789	9,5	20,0	60,0	90,0	140,0	5,0	4	■	80000	Weldon	0,3	5
MM10-20250.0-1055DS	02580750	9,5	20,0	55,0	200,0	250,0	1,0	5	■	76300	Cylindrical Densimet	1,0	3
MM10-32250.0-10063	75069366	9,5	32,0	63,8	190,0	250,0	10,0	4	■	80000	Cylindrical	1,3	5

Parti di ricambio, comprese nella fornitura

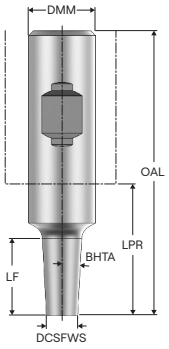
Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
1	MM-06032	MM10-0627	H06-4
2	MM-06020	MM10-0627	H05-4
3	–	MM10-061027	–
4	MM-06048	MM10-0627	H06-4
5	MM-06116	MM10-0627	H06-4
6	MM-06048	MM10-0651	H06-4
7	MM-06032	MM10-0688	H06-4

Chiave a brugola H05-4 per boccola da ordinare separatamente.
Per i tipi di chiave, vedere le pagine sugli inserti

MM10 Stelo – pollici





Codice di ordinazione	Codice prodotto	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Disegno	CSP	RPMX	Attacco	Peso	Codice ricambio
		inch	inch	inch	inch	inch						lb	
MM10-0.38-1.8-0-0002	00096126	0.360	0.375	0.276	0.276	1.772	0,0	2	■	80000	Cylindrical	0.220	2
MM10-0.62-2.6-0-0000	75005069	0.374	0.625	0	0.669	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM10-0.62-6.3-0-1021	75054608	0.360	0.625	2.165	4.409	6.299	1,0	3	■	80000	Cylindrical	0.440	7
MM10-0.75-3.0-3-0004	75015052	0.360	0.750	0.394	0.984	2.953	0,0	2	■	80000	Weldon	0.440	3
MM10-0.75-3.3-3-3009	75015053	0.374	0.750	0.906	1.378	3.346	3,0	3	■	80000	Weldon	0.440	3
MM10-0.75-5.5-3-5021	75015054	0.374	0.750	2.150	3.543	5.512	5,0	4	■	80000	Weldon	0.660	5
MM10-0.75-10.0-0-1021DS	02593420	0.360	0.750	2.165	7.874	9.843	1,0	5	■	76300	Cylindrical Densimet	1.980	4
MM10-0.75-4.1-0-0015DS	02593422	0.360	0.750	1.575	2.165	4.134	0,0	2	■	76300	Cylindrical Densimet	0.660	4
MM10-1.25-10.0-0-10024	00096132	0.374	1.250	2.484	7.480	9.843	10,0	4	■	80000	Cylindrical	2.870	5

Parti di ricambio, comprese nella fornitura

Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
1	MM-06032	MM10-0627	H06-4
2	MM-06020	MM10-0627	H05-4
3	MM-06048	MM10-0627	H06-4
4	–	MM10-061027	–
5	MM-06116	MM10-0627	H06-4
7	MM-06032	MM10-0688	H06-4

Chiave a brugola H05-4 per boccola da ordinare separatamente.
Per i tipi di chiave, vedere le pagine sugli inserti

Scanalatura/fresatura a spallamento retto

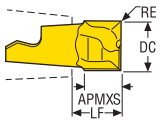


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*	–	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*	–	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



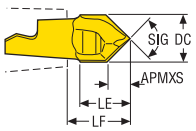


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*	–	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*	–	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



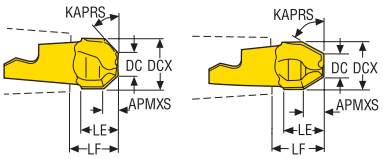


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

Codice di ordinazione	DC	APMXS	RE	LF	SIG°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM10-10005-C90-M03	10,0 *0.394*	4,69 *0.185*	– –	11,8 *0.465*	90,0	2	MM0612	■			
MM10-10007-C120-M03	10,0 *0.394*	2,7 *0.106*	– –	11,8 *0.465*	120,0	2	MM0612	■			

Smussatura



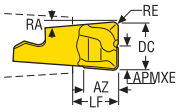


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

Codice di ordinazione	DCX	DC	APMXS	RE	LE	LF	KAPRS°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM10-10007-4525-E03	10,0 *0.394*	4,82 *0.190*	2,6 *0.102*	0,3 *0.012*	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*	0,3 *0.012*	8,05 *0.317*	9,6 *0.378*	60,0	2	MM0612	■			

Penetrazione assiale

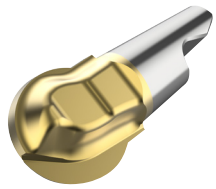




—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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 799

Codice di ordinazione	DC	APMXS	RE	LE	DN	LF	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*	10,0 *0.394*	13,2 *0.520*	247,0	2	MM0612			■	
MM10-12712-B120P-M05	12,7 *0.500*	6,35 *0.250*	6,35 *0.250*	12,4 *0.488*	10,0 *0.394*	13,56 *0.534*	256,0	2	MM1420			■	

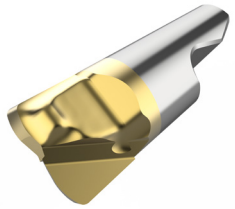
Copiatura

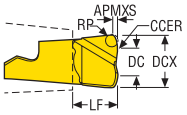


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*		2	MM0612		■		■	
MM10-10010-B90-MD04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*		2	MM0612		■		■	
MM10-10010-B90PF-M02	10,0 *0.394*	8,73 *0.344*	5,0 *0.197*	11,74 *0.462*		2	MM0612			■		
MM10-10010-B90P-M04	10,0 *0.394*	8,73 *0.344*	5,0 *0.197*	11,74 *0.462*		2	MM0612				■	
MM10-10010-B90S-E04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*		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 799

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

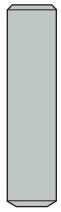
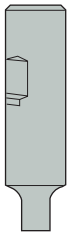
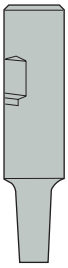
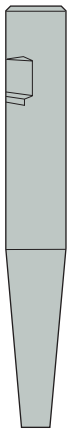
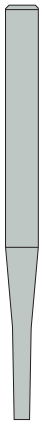
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,48 0.019	0,48 0.019	0,65 0.026	0,80 0.032
P2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 0.020	0,50 0.020	0,65 0.026	0,80 0.032
P3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 0.018	0,46 0.018	0,60 0.024	0,75 0.030
P4	MM10-10.50-HF-MD08 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)

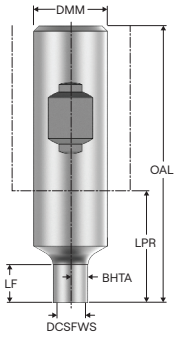
SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	—	—	—	—	230	280	325	340
	—	—	—	—	*750*	*920*	*1075*	*1125*
P2	—	—	—	—	225	270	315	330
	—	—	—	—	*740*	*890*	*1025*	*1075*
P3	—	—	—	—	195	240	275	290
	—	—	—	—	*640*	*790*	*900*	*950*
P4	—	—	—	—	170	210	240	255
	—	—	—	—	*560*	*690*	*790*	*840*
P5	—	—	—	—	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

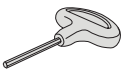




Codice di ordinazione	Codice prodotto	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Disegno	CSP	RPMX	Attacco	Peso	Codice ricambio
		mm	mm	mm	mm	mm						kg	
MM12-12055.0-0008	00083978	11,5	12,0	8,5	10,0	55,0	0,0	2	■	80000	Cylindrical	0,1	2
MM12-12070.0-0008DS	02580668	11,5	12,0	8,5	25,0	70,0	0,0	2	■	63600	Cylindrical Densimet	0,1	3
MM12-16065.0-0000	75004926	11,4	16,0	0,0	17,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM12-16170.0-1040	75034505	11,4	16,0	40,0	122,0	170,0	1,0	3	■	80000	Cylindrical	0,3	5
MM12-16170.0-1060	75034506	11,4	16,0	60,0	122,0	170,0	1,0	3	■	80000	Cylindrical	0,2	5
MM12-16170.0-1080	75034507	11,4	16,0	80,0	122,0	170,0	1,0	3	■	80000	Cylindrical	0,2	5
MM12-16095.0-0024DS	02580690	11,4	16,0	24,0	47,0	95,0	0,0	2	■	63600	Cylindrical Densimet	0,3	3
MM12-16090.0-3044DS	02580705	11,4	16,0	43,9	42,0	90,0	3,0	4	■	63600	Cylindrical Densimet	0,3	3
MM12-16120.0-1045DS	02580752	11,4	16,0	45,0	72,0	120,0	1,0	3	■	63600	Cylindrical Densimet	0,3	3
MM12-16115.0-0048DS	02580691	11,4	16,0	48,0	67,0	115,0	0,0	2	■	63600	Cylindrical Densimet	0,3	3
MM12-16170.0-1060DS	02580753	11,4	16,0	60,0	122,0	170,0	1,0	3	■	63600	Cylindrical Densimet	0,5	3
MM12-16170.0-1080DS	02580755	11,4	16,0	80,0	122,0	170,0	1,0	3	■	63600	Cylindrical Densimet	0,5	3
MM12-20080.3-0012	75012864	11,4	20,0	12,0	30,0	80,0	0,0	2	■	80000	Weldon	0,2	4
MM12-20095.3-3027	75012865	11,4	20,0	27,0	45,0	95,0	3,0	3	■	80000	Weldon	0,2	4
MM12-20150.3-5049	75012866	11,4	20,0	49,1	100,0	150,0	5,0	4	■	80000	Weldon	0,3	5
MM12-20250.0-1060DS	02580756	11,4	20,0	60,0	200,0	250,0	1,0	5	■	63600	Cylindrical Densimet	1,0	3

Parti di ricambio, comprese nella fornitura

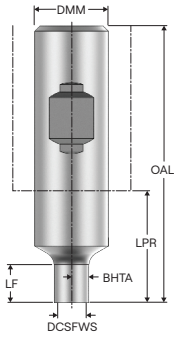
Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
1	MM-06032	MM12-0637	H06-4
2	MM-06020	MM12-0637	H05-4
3	–	MM12-061037	–
4	MM-06048	MM12-0637	H06-4
5	MM-06116	MM12-0637	H06-4

Chiave a brugola H05-4 per boccola da ordinare separatamente.
Per i tipi di chiave, vedere le pagine sugli inserti

MM12 Stelo – pollici





Codice di ordinazione	Codice prodotto	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Disegno	CSP	RPMX	Attacco	Peso	Codice ricambio
		inch	inch	inch	inch	inch						lb	
MM12-0.50-2.2-0-0003	00096133	0.453	0.500	0.335	0.394	2.165	0,0	2	■	80000	Cylindrical	0.220	2
MM12-0.62-2.6-0-0000	75005070	0.449	0.625	0	0.669	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM12-0.62-6.7-0-1015	75054728	0.449	0.625	1.575	4.803	6.693	1,0	3	■	80000	Cylindrical	0.440	5
MM12-0.62-6.7-0-1023	75054729	0.449	0.625	2.362	4.803	6.693	1,0	3	■	80000	Cylindrical	0.440	5
MM12-0.62-6.7-0-1023DS	02593423	0.449	0.625	2.362	4.803	6.693	1,0	3	■	63600	Cylindrical Densimet	1.100	4
MM12-0.62-6.7-0-1031DS	02593426	0.449	0.625	3.150	4.803	6.693	1,0	3	■	63600	Cylindrical Densimet	1.100	4
MM12-0.75-3.1-3-0004	75015055	0.449	0.750	0.472	1.181	3.150	0,0	2	■	80000	Weldon	0.440	3
MM12-0.75-3.7-3-3010	75015056	0.449	0.750	1.063	1.772	3.740	3,0	3	■	80000	Weldon	0.440	3
MM12-0.75-5.9-3-5017	75015057	0.449	0.750	1.720	3.937	5.906	5,0	4	■	80000	Weldon	0.660	5
MM12-0.75-10.0-0-1023DS	02593427	0.449	0.750	2.362	7.874	9.843	1,0	5	■	63600	Cylindrical Densimet	1.980	4
MM12-0.75-3.8-0-0009DS	02593428	0.449	0.750	0.945	1.772	3.740	0,0	2	■	63600	Cylindrical Densimet	0.880	4
MM12-0.75-4.5-0-0018DS	02593430	0.449	0.750	1.890	2.559	4.528	0,0	2	■	63600	Cylindrical Densimet	0.880	4

Parti di ricambio, comprese nella fornitura

Accessori

Per fresa	Tirante	Vite di fissaggio	Sleeve key
			
1	MM-06032	MM12-0637	H06-4
2	MM-06020	MM12-0637	H05-4
3	MM-06048	MM12-0637	H06-4
4	–	MM12-061037	–
5	MM-06116	MM12-0637	H06-4

Chiave a brugola H05-4 per boccola da ordinare separatamente.
Per i tipi di chiave, vedere le pagine sugli inserti

Scanalatura/fresatura a spallamento retto

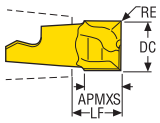


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*	–	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*	–	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



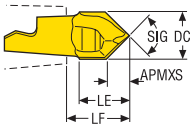


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*	–	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*	–	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*	–	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



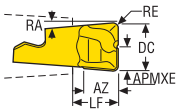


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

Codice di ordinazione	DC	APMXS	RE	LF	SIG°	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM12-12006-C90-M04	12,0 *0.472*	5,65 *0.222*	– –	14,64 *0.576*	90,0	2	MM0612	■			

Penetrazione assiale



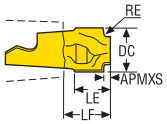


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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
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 799

Codice di ordinazione	DC	APMXS	RE	LE	LF	ZEFP	Chiave	Qualità Rivestite			
	mm *Inch*	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*	10,6 *0.417*	12,14 *0.478*	2	MM0612	■			
MM12-12010-CR20-MD05	12,0 *0.472*	2,4 *0.094*	2,0 *0.079*	10,7 *0.421*	12,25 *0.482*	2	MM0612	■			
MM12-12010-CR30-MD05	12,0 *0.472*	3,3 *0.130*	3,0 *0.118*	10,6 *0.417*	12,2 *0.480*	2	MM0612	■			

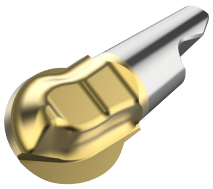
Smussatura



—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

Codice di ordinazione	DCX	DC	APMXS	DN	LF	KAPRS°	BEC°	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*	11,5 *0.453*	15,2 *0.598*	30,0	60,0	2	MM1420		■		
MM12-16016-D4520P-M02	16,0 *0.630*	1,0 *0.039*	7,5 *0.295*	11,5 *0.453*	17,2 *0.677*	45,0	90,0	2	MM1420		■		

Inserti di precisione per la semi-finitura in tutti i materiali



—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

Codice di ordinazione	DC	APMXS	RE	LE	DN	LF	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*	12,0 *0.472*	15,45 *0.608*	242,0	2	MM1420			■	
MM12-16016-B120PF-M03	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	12,0 *0.472*	17,46 *0.687*	263,0	2	MM1420		■		
MM12-16016-B120P-M07	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	12,0 *0.472*	17,46 *0.687*	263,0	2	MM1420			■	

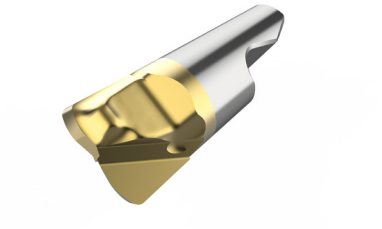
Copiatura

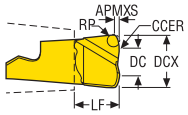


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*		2	MM0612		■		■	
MM12-12012-B90PF-M02	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*		2	MM0612			■		
MM12-12012-B90P-M05	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*		2	MM0612				■	
MM12-12012-B90S-E05	12,0 *0.472*	12,3 *0.484*	6,0 *0.236*	14,12 *0.556*		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*		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*		2	MM1420				■	

Elevato avanzamento





—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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

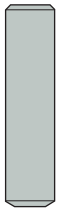
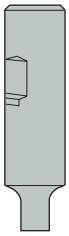
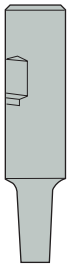
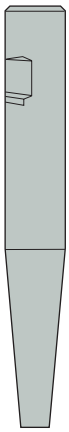
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,55 0.022	0,75 0.030	0,95 0.038
P2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,60 0.024	0,75 0.030	0,95 0.038
P3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,55 0.022	0,70 0.028	0,90 0.036
P4	MM12-12.60-HF-MD10 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)

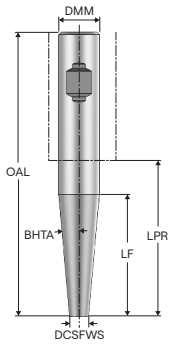
SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	—	—	—	—	225	275	315	330
	—	—	—	—	*740*	*900*	*1025*	*1075*
P2	—	—	—	—	220	265	310	320
	—	—	—	—	*720*	*870*	*1025*	*1050*
P3	—	—	—	—	190	230	270	280
	—	—	—	—	*620*	*750*	*890*	*920*
P4	—	—	—	—	165	205	235	245
	—	—	—	—	*540*	*670*	*770*	*800*
P5	—	—	—	—	165	195	225	240
	—	—	—	—	*540*	*640*	*740*	*790*
P6	—	—	—	—	185	225	255	270
	—	—	—	—	*610*	*740*	*840*	*890*
P7	—	—	—	—	170	210	240	255
	—	—	—	—	*560*	*690*	*790*	*840*
P8	—	—	—	—	160	195	225	235
	—	—	—	—	*520*	*640*	*740*	*770*
P11	—	—	—	—	165	205	235	245
	—	—	—	—	*540*	*670*	*770*	*800*
P12	—	—	—	—	110	130	150	160
	—	—	—	—	*360*	*425*	*490*	*520*
M1	—	—	—	—	175	215	250	260
	—	—	—	—	*570*	*710*	*820*	*850*
M2	—	—	—	—	145	175	205	215
	—	—	—	—	*475*	*570*	*670*	*710*
M3	—	—	—	—	120	140	165	175
	—	—	—	—	*395*	*460*	*540*	*570*
M4	—	—	—	—	95	110	125	130
	—	—	—	—	*310*	*360*	*410*	*425*
M5	—	—	—	—	80	90	105	110
	—	—	—	—	*260*	*295*	*345*	*360*
K1	185	225	260	275	175	210	245	255
	610	*740*	*850*	*900*	*570*	*690*	*800*	*840*
K2	165	200	230	245	155	185	215	225
	540	*660*	*750*	*800*	*510*	*610*	*710*	*740*
K3	140	170	195	205	130	155	180	190
	460	*560*	*640*	*670*	*425*	*510*	*590*	*620*
K4	135	160	185	195	125	150	175	185
	445	*520*	*610*	*640*	*410*	*490*	*570*	*610*
K5	80	100	115	120	75	90	105	110
	260	*330*	*375*	*395*	*245*	*295*	*345*	*360*
K6	120	140	165	175	110	130	155	160
	395	*460*	*540*	*570*	*360*	*425*	*510*	*520*
K7	105	125	145	155	95	115	135	145
	345	*410*	*475*	*510*	*310*	*375*	*445*	*475*
N1	—	—	—	—	1275	1575	1800	1875
	—	—	—	—	*4175*	*5175*	*5900*	*6150*
N2	—	—	—	—	520	630	730	750
	—	—	—	—	*1700*	*2075*	*2400*	*2450*
N3	—	—	—	—	345	420	485	500
	—	—	—	—	*1125*	*1375*	*1600*	*1650*
N11	—	—	—	—	395	480	550	570
	—	—	—	—	*1300*	*1575*	*1800*	*1875*
S1	—	—	—	—	44	50	60	60
	—	—	—	—	*145*	*165*	*195*	*195*
S2	—	—	—	—	35	41	47	50
	—	—	—	—	*115*	*135*	*155*	*165*
S3	—	—	—	—	31	36	42	44
	—	—	—	—	*100*	*120*	*140*	*145*
S11	—	—	—	—	60	70	85	90
	—	—	—	—	*195*	*230*	*280*	*295*
S12	—	—	—	—	42	50	55	60
	—	—	—	—	*140*	*165*	*180*	*195*
S13	—	—	—	—	25	29	33	35
	—	—	—	—	*80*	*95*	*110*	*115*
H5	39	46	55	55	36	43	50	55
	130	*150*	*180*	*180*	*120*	*140*	*165*	*180*
H8	41	49	55	60	38	45	50	55
	135	*160*	*180*	*195*	*125*	*150*	*165*	*180*
H11	49	60	70	70	46	55	65	65
	160	*195*	*230*	*230*	*150*	*180*	*215*	*215*
H12	75	90	100	105	70	80	95	100
	245	*295*	*330*	*345*	*230*	*260*	*310*	*330*
H21	41	49	55	60	38	45	50	55
	135	*160*	*180*	*195*	*125*	*150*	*165*	*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	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Disegno	CSP	RPMX	Attacco	Peso	Codice ricambio
		mm	mm	mm	mm	mm						kg	
MM16-16070.0-0011M	00023547	15,2	16,0	11,3	22,0	70,0	0,0	2	■	63600	Cylindrical	0,1	1
MM16-16150.0-0080DS	02580692	15,2	16,0	80,0	102,0	150,0	0,0	2	■	47600	Cylindrical Densimet	0,4	2
MM16-20115.3-3045	75014109	15,2	20,0	45,8	65,0	115,0	3,0	4	■	63600	Weldon	0,2	3
MM16-20070.0-0000	00023548	15,2	20,0	0,0	20,0	70,0	60,0	1	■	63600	Cylindrical	0,2	1
MM16-20190.0-1055M	00094766	15,2	20,0	55,0	140,0	190,0	1,0	3	■	63600	Cylindrical	0,4	5
MM16-20190.0-1075M	00094768	15,2	20,0	75,0	140,0	190,0	1,0	3	■	63600	Cylindrical	0,4	5
MM16-20190.0-1095M	00094770	15,2	20,0	95,0	140,0	190,0	1,0	3	■	63600	Cylindrical	0,4	6
MM16-20080.0-0011DS	02580669	15,2	20,0	11,3	30,0	80,0	0,0	2	■	47600	Cylindrical Densimet	0,3	2
MM16-20150.0-0038DS	02580695	15,2	20,0	38,0	100,0	150,0	0,0	2	■	47600	Cylindrical Densimet	0,6	2
MM16-20160.0-0076DS	02580699	15,2	20,0	76,0	110,0	160,0	0,0	2	■	47600	Cylindrical Densimet	0,6	2
MM16-20130.0-1045DS	02580757	15,2	20,0	45,0	80,0	130,0	1,0	3	■	47600	Cylindrical Densimet	0,5	2
MM16-20190.0-1075DS	02580758	15,2	20,0	75,0	140,0	190,0	1,0	3	■	47600	Cylindrical Densimet	0,8	2
MM16-20190.0-1095DS	02580760	15,2	20,0	95,0	140,0	190,0	1,0	3	■	47600	Cylindrical Densimet	0,8	2
MM16-25100.3-0019	75012790	15,2	25,0	19,0	40,0	100,0	0,0	2	■	63600	Weldon	0,3	3
MM16-25115.3-3035	75012791	15,2	25,0	35,0	59,0	115,0	3,0	3	■	63600	Weldon	0,3	3
MM16-25170.3-5056	75012792	15,2	25,0	56,0	114,0	170,0	5,0	4	■	63600	Weldon	0,6	4
MM16-25170.0-1060	00094767	19,0	25,0	60,0	114,0	170,0	1,0	3	■	63600	Cylindrical	0,5	5
MM16-25250.0-1075DS	02580761	15,2	25,0	75,0	194,0	250,0	1,0	5	■	47600	Cylindrical Densimet	1,5	2
MM16-32250.0-10047	75069368	15,2	32,0	47,6	190,0	250,0	10,0	4	■	63600	Cylindrical	1,3	4

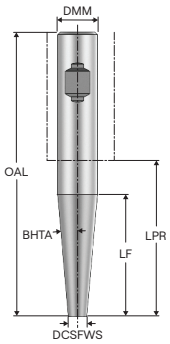
Parti di ricambio, comprese nella fornitura

Per fresa	Tirante	Vite di fissaggio
		
1	MM-10030	MM16-1045
2	–	MM16-1045
3	MM-10062	MM16-1045
4	MM-10132	MM16-1045
5	MM-10062	MM16-1093
6	MM-10062	MM16-10113

Chiave a brugola H05-4 per boccola da ordinare separatamente.
Per i tipi di chiave, vedere le pagine sugli inserti

MM16 Stelo – pollici





Codice di ordinazione	Codice prodotto	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Disegno	CSP	RPMX	Attacco	Peso	Codice ricambio
		inch	inch	inch	inch	inch						lb	
MM16-0.62-2.8-0M-0004	00037209	0.598	0.625	0.445	0.866	2.756	0,0	2	■	63600	Cylindrical	0.220	1
MM16-0.75-4.5-3-3018	75054603	0.598	0.750	1.445	2.559	4.528	3,0	3	■	63600	Weldon	0.440	4
MM16-0.75-2.8-0-0000	00037175	0.598	0.750	0	0.787	2.756	60,0	1	■	63600	Cylindrical	0.440	1
MM16-0.75-7.5-0-1021	75054731	0.598	0.750	2.165	5.512	7.480	1,0	3	■	63600	Cylindrical	0.660	6
MM16-0.75-7.5-0-1037	75054733	0.598	0.750	3.740	5.512	7.480	1,0	3	■	63600	Cylindrical	0.880	7
MM16-0.75-7.5-0-1029DS	02567719	0.598	0.750	2.953	5.512	7.480	1,0	3	■	47600	Cylindrical Densimet	1.760	3
MM16-0.75-7.5-0-1037DS	02593431	0.598	0.750	3.740	5.512	7.480	1,0	3	■	47600	Cylindrical Densimet	1.540	3
MM16-1.00-3.9-3-0007	75015058	0.598	1.000	0.748	1.732	3.937	0,0	2	■	63600	Weldon	0.660	4
MM16-1.00-4.5-3-3013	75015059	0.598	1.000	1.378	2.323	4.528	3,0	3	■	63600	Weldon	0.880	4
MM16-1.00-6.7-3-5022	75015060	0.598	1.000	2.295	4.488	6.693	5,0	4	■	63600	Weldon	1.320	5
MM16-1.00-5.9-0-0015DS	02593433	0.598	1.000	1.496	3.701	5.906	0,0	2	■	47600	Cylindrical Densimet	2.200	3
MM16-1.00-6.3-0-0030DS	02593434	0.598	1.000	2.992	4.094	6.299	0,0	2	■	47600	Cylindrical Densimet	1.980	3

Parti di ricambio, comprese nella fornitura

Per fresa	Tirante	Vite di fissaggio
		
1	MM-10030	MM16-1045
3	–	MM16-1045
4	MM-10062	MM16-1045
5	MM-10132	MM16-1045
6	MM-10062	MM16-1093
7	MM-10062	MM16-10113

Chiave a brugola H05-4 per boccola da ordinare separatamente.
Per i tipi di chiave, vedere le pagine sugli inserti

Scanalatura/fresatura a spallamento retto

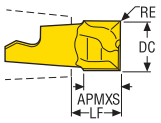


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*	–	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*	–	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



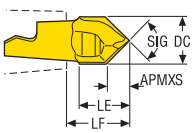


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*	–	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



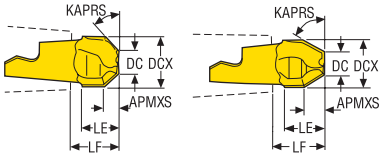


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

Codice di ordinazione	DC	APMXS	RE	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*	– –	19,2 *0.756*	90,0	2	MM1420	■			
MM16-16011-C120-M06	16,0 *0.630*	4,3 *0.169*	– –	18,9 *0.744*	120,0	2	MM1420	■			
MM16-19019-C90	19,05 *0.750*	9,6 *0.378*	– –	22,15 *0.872*	90,0	2	MM1420	■			

Smussatura



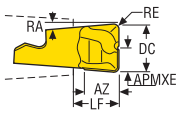


—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

										Qualità			
Codice di ordinazione	DCX	DC	APMXS	RE	LE	LF	KAPRS°	ZEFP	Chiave	Rivestite			
	mm *Inch*	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*	0,4 *0.016*	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*	0,5 *0.020*	12,9 *0.508*	15,3 *0.602*	60,0	2	MM1420	■			

Penetrazione assiale

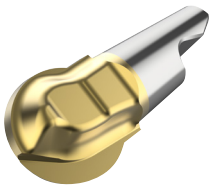




—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

									Qualità			
Codice di ordinazione	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Chiave	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 799

Codice di ordinazione	DC	APMXS	RE	LE	DN	LF	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*	15,9 *0.626*	21,94 *0.864*	254,0	2	MM1420		■		
MM16-20020-B120P-M07	20,0 *0.787*	10,0 *0.394*	10,0 *0.394*	20,0 *0.787*	15,9 *0.626*	21,94 *0.864*	254,0	2	MM1420			■	

Copiatura



—Per le chiavi dinamometriche e i valori di coppia, vedere pagina 799

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*		2	MM1420				■	
MM16-16016-B90-MD07	16,0 *0.630*	16,2 *0.638*	8,0 *0.315*	18,4 *0.724*		2	MM1420		■		■	
MM16-16016-B90PF-M03	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*		2	MM1420			■		
MM16-16016-B90P-M07	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*		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*	17,4 *0.685*	9,525 *0.375*	22,12 *0.871*		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*		2	MM1420		■		■	
MM16-20020-B90P-M07	20,0 *0.787*	17,4 *0.685*	10,0 *0.394*	22,12 *0.871*		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



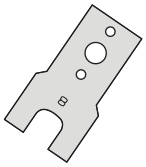
Chiave dinamometrica con valori di coppia fissi per garantire la corretta forza di serraggio durante il montaggio dell'inserto Minimaster nel relativo porta-inserto.
Le chiavi dinamometriche sono calibrate a norma ISO 6789.
Chiave di codifica: MM02-4006
MM02 = a 2 eliche (MM03 = a 3 eliche)
40 = valore 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 802 - 805.
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.

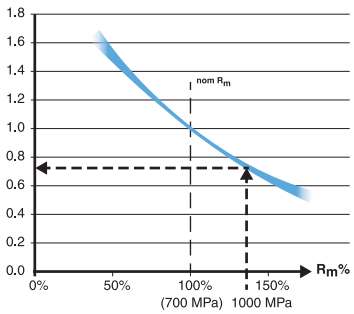
P4	Acciai da costruzione basso legati, 0,25% < C < 0,67% Acciai da bonifica basso legati	520 < R_m < 1200	C 45E R_m = 660 N/mm²
P5	Acciai da costruzione, 0,25% < C < 0,67% Acciai da bonifica	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm²

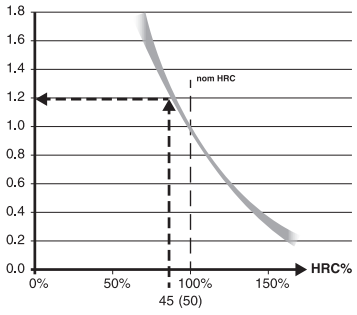
H5	Acciai bonificati	38 < HRC < 56	42 CrMo 4 50 HRC

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.

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) 806-813, 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/mm²	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/mm²	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/mm²	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/mm²	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/mm²	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/mm²	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/mm²	2160	0,17
P8	Acciai da utensili Acciai super-rapidi (HSS)	600 < R_m < 1200	X 40 CrMoV 5 1 R_m = 700 N/mm²	2400	0,20
P11	Acciai inossidabili ferritici e martensitici	415 < R_m < 1200	X 20 Cr 13 R_m = 675 N/mm²	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/mm²	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	0	
K6	Ghise austenitiche lamellari		EN-GJLA-XNiCuCr15-6-2	0	
K7	Ghise austenitiche sferoidali (nodulari)		EN-GJSA-XNiMn23-4	0	

Materiali non ferrosi

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
N1	Leghe di alluminio, Si < 9%		AW-7075	0	
N2	Leghe di alluminio, 9% < Si < 16%		AC-44200 Si = 12%	0	
N3	Leghe di alluminio, Si >16%		AlSi17Cu5	0	
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	0	
S2	Superleghe a base cobalto		Stellite 21	0	
S3	Superleghe a base nichel		Inconel 718	2530	0,21
S11	Titanio, basso legato, (α)		Ti	0	
S12	Titanio, medio legato, (α+β)		TiAl6V4	1500	0,24
S13	Titanio, alto legato, (“quasi β” e β)		Ti10V2Fe3Al	0	

Materiali ad elevata durezza

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
H3	Acciai induriti superficial-mente	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	0	
H31	Ghise bianche	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC	0	

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	0	
PM2	Materiali da metallurgia delle polveri con contenuto di elementi in lega medio		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C	0	
PM3	Materiali da metallurgia delle polveri con contenuto di elementi in lega alto Materiali per sedi valvole di scarico			0	
HF1	Leghe per riporti duri Riporto di leghe a base ferro mediante saldatura o plasma			0	
HF2	Leghe per riporti duri Riporto di leghe a base cobalto o nichel mediante saldatura o plasma			0	
CC1	Metallo duro		G50	0	

Plastiche e materiali compositi

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
TS1	Polimeri termoindurenti		Urea formaldeide (UF)	0	
TS2	Compositi di resina termoindurente rinforzata con fibra di carbonio		T300 T700 T800 HTA-S IMA - Resina epossidica (M21)...	0	
TS3	Compositi di resina termoindurente rinforzata con fibra di vetro		Resina epossidica - HX..(42..)/ vetro E (7781...)...	0	
TS4	Compositi di resina termoindurente rinforzata con fibra aramidica		Kevlar 49	0	
TP1	Polimeri termoplastici		Policarbonato (PC)	0	
TP2	Compositi di resina termoplastica rinforzata con fibra di carbonio		PPS/PEEK - T300..	0	
TP3	Compositi di resina termoplastica rinforzata con fibra di vetro		PPS/PEEK - vetro E o A...	0	
TP4	Compositi di resina termoplastica rinforzata con fibra aramidica			0	

Grafite

SMG	Descrizione	Proprietà	Riferimento	$k_{c1.1}$	m_c
GR1	Grafite		R 8500	0	

Gruppo materiale 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		

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	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

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	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
K1	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
	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	
K2	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
	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
K4	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
	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
K5										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
	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
K6	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002
	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
K7	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
	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
N1	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
	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
N2	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
N11	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
			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

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	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

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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