



TORNITURA

TURNING / DREHEN / TOURNAGE / TORNEADO

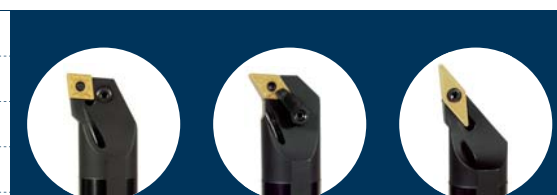


	UTENSILI PER TORNITURA ESTERNA
	EXTERNAL TURNING TOOLS
	WERKZEUGE FUER AUSSENBEARBEITUNG
	OUTILS DE TOURNAGE EXTÉRIEUR
	HERRAMIENTAS PARA TORNEADO EXTERIOR



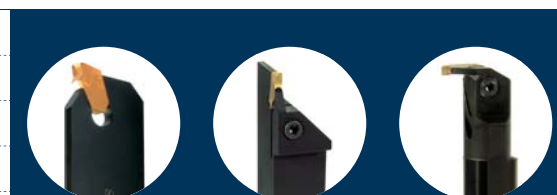
Pag. 8

	UTENSILI PER TORNITURA INTERNA
	TOOL HOLDER FOR INTERNAL USE
	WERKZEUGE FUER INNENBEARBEITUNG
	OUTILS DE TOURNAGE INTÉRIEUR
	HERRAMIENTAS PARA TORNEADO INTERIOR



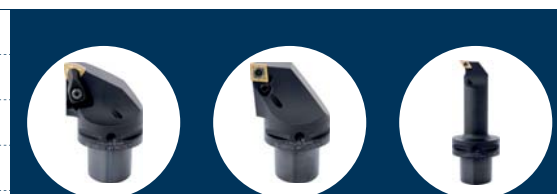
Pag. 44

	UTENSILI PER SCANALATURA E TAGLIO
	TOOLS FOR GROOVING AND PARTING
	NUTENDREHEN UND ABSTECHE
	OUTILS À RAINURER ET TRONÇONNER
	HERRAMIENTAS PARA RANURAS



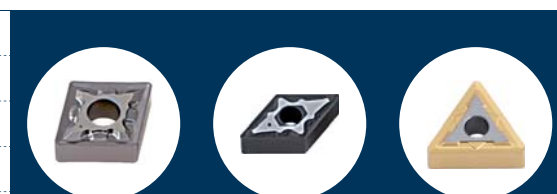
Pag. 80

	UTENSILI ISO 26623-1 PER TORNITURA ESTERNA ED INTERNA
	ISO 26623-1 INTERNAL AND EXTERNAL TURNING TOOLS
	ISO 26623-1 INNEN- UND AUSSENDREHWERKZEUGE
	OUTILS ISO 26623-1 POUR TOURNAGE EXTERNE ET INTERNE
	HERRAMIENTAS ISO 26623-1 PARA TORNEADO EXTERIOR E INTERIOR



Pag. 100

	INSERTI PER TORNITURA
	TURNING INSERTS
	WENDEPLATTEN ZUM DREHEN
	PLAQUÉTTES DE TOURNAGE
	PLAQUITAS DE TORNEADO



Pag. 121

	INSERTI PER SCANALATURA
	GROOVING INSERTS
	WENDEPLATTEN ZUM NUTENDREHEN
	PLAQUÉTTES DE GORGES
	PLAQUITAS DE RANURAS



Pag. 157

**INDICAZIONI DI LETTURA
READING INSTRUCTIONS
HINWEISE ZUR ABLESUNG
INDICATIONS DE LECTURE**



- 1 = ARTICOLO + GAMMA DI STELI
- 2 = LAVORAZIONI CONSIGLIATE
- 3 = INSERTI
- 4 = SISTEMA DI BLOCCAGGIO
- 5 = INSERTI SAU DISPONIBILI
- 6 = ELENCO ARTICOLI
- 7 = MISURE, DATI, INDICAZIONI
- 8 = GRANDEZZA INSERTI CONSIGLIATI
- 9 = RICAMBI IN DOTAZIONE
- 10 = ACCESSORI E RICAMBI OPZIONALI A RICHIESTA
- 11 = SCHEMA DI MONTAGGIO
- 12 = DATI TECNICI E CONSIGLI D'USO



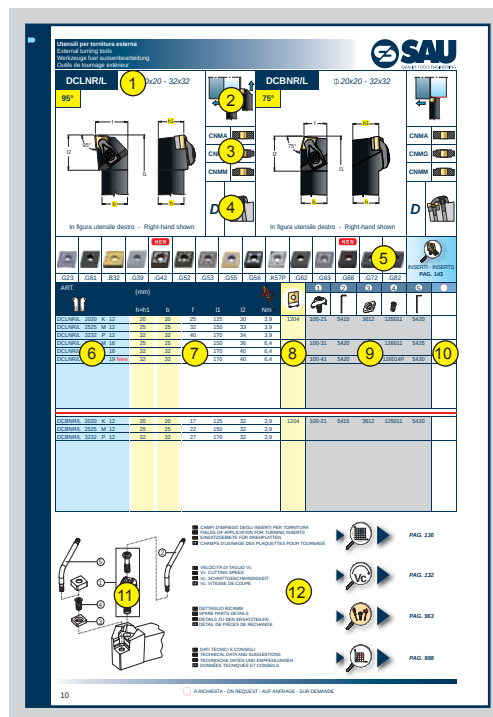
- 1 = ITEM + SHAFT RANGE
- 2 = RECOMMENDED MACHINING TYPES
- 3 = INSERTS
- 4 = CLAMPING SYSTEM
- 5 = AVAILABLE SAU INSERTS
- 6 = ITEM LIST
- 7 = MEASURES, DATA, INDICATIONS
- 8 = RECOMMENDED INSERTS SIZES
- 9 = SPARE PARTS EQUIPMENT
- 10 = OPTIONAL ACCESSORIES AND SPARE PARTS ON REQUEST
- 11 = ASSEMBLY DIAGRAM
- 12 = TECHNICAL DATA AND SUGGESTIONS



- 1 = ARTIKEL + SCHAFTPALETTE
- 2 = EMPFOHLENE BEARBEITUNGEN
- 3 = WENDEPLATTEN
- 4 = SPANNSYSTEM
- 5 = LIEFERBARE SAU-WENDESCHNEIDPLATTEN
- 6 = AUFLISTUNG DER ARTIKEL
- 7 = ABMESSUNGEN, DATEN, HINWEISE
- 8 = EMPFOHLENE PLATTENGROSSEN
- 9 = ZUBEHÖREERSATZTEILE
- 10 = OPTIONALZUBEHÖR UND -ERSATZTEILE AUF ANFRAGE
- 11 = MONTAGEPLAN
- 12 = TECHNISCHE DATEN UND TIPPS



- 1 = ARTICLE + GAMME DE QUEUES
- 2 = USINAGES CONSEILLÉS
- 3 = PLAQUETTES
- 4 = SYSTÈME DE BLOCAGE
- 5 = PLAQUETTES SAU DISPONIBLES
- 6 = LISTE DES ARTICLES
- 7 = DIMENSIONS, DONNÉES, INDICATIONS
- 8 = DIMENSIONS DE LES PLAQUETTES CONSEILLÉES
- 9 = RECHANGE EN DOTATION
- 10 = ACCESSOIRES ET RECHANGE OPTIONNEL SUR DEMANDE
- 11 = SCHÉMA DE MONTAGE
- 12 = DONNÉES TECHNIQUES ET CONSEILS D'USAGE



TIPI DI BLOCCAGGIO



KLEMMTYPEN



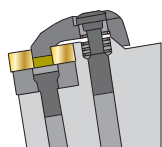
CLAMPING TYPES



TYPES DE BLOCAGE

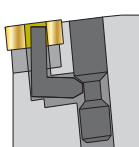
TIPO-TYPE-TYP-TYPE

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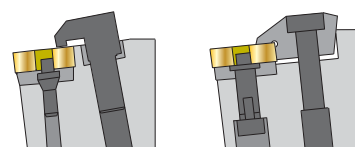
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P



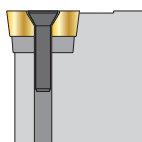
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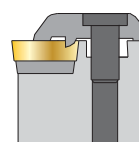
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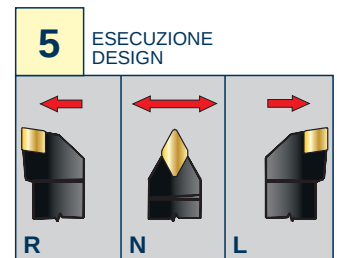
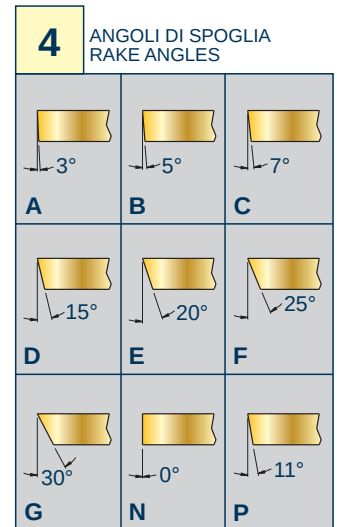
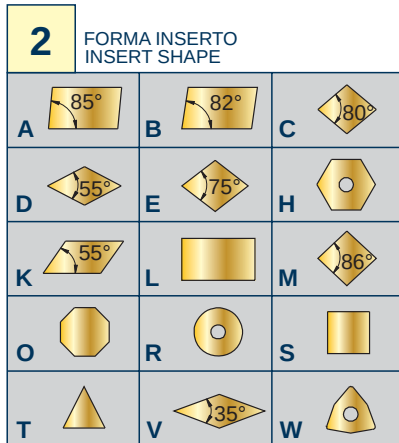
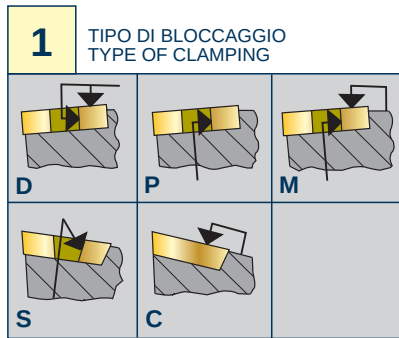
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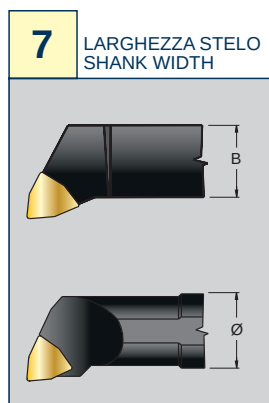
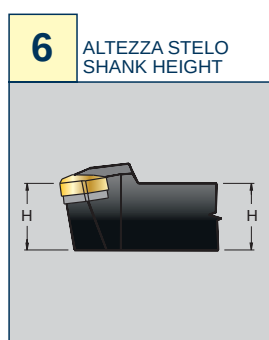
TIPO-TYPE-TYP-TYPE

C



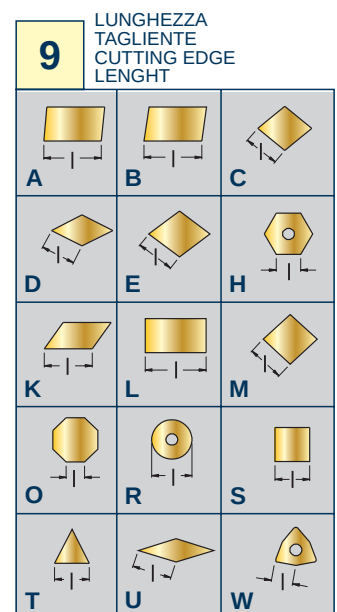


P	C	L	N	R	32	25	P	12	
1	2	3	4	5	6	7	8	9	10



8 LUNGHEZZA UTENSILE
TOOL LENGTH

L1 mm	ISO
32	A
40	B
50	C
60	D
70	E
80	F
90	G
100	H
110	J
125	K
140	L
150	M
160	N
170	P
180	Q
200	R
250	S
300	T
350	U
400	V
450	W
500	Y
SPECIALE SPECIAL	X



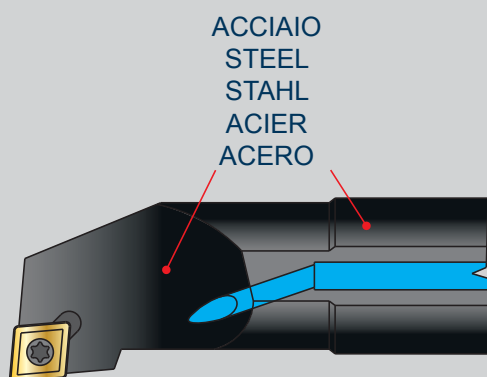
S	20	S	C	T	F	P	R	16	
11	7	8	1	2	3	4	5	9	10

11 STELO
SHANK

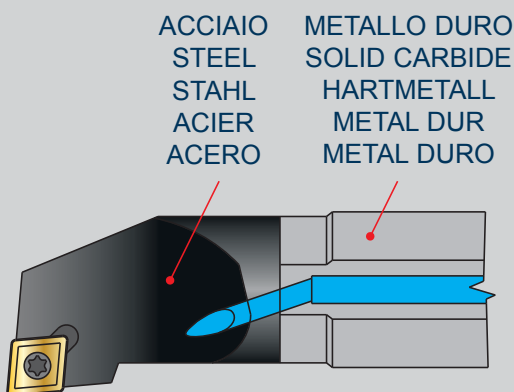
S = Stelo in acciaio
A = Stelo in acciaio + foro refrigerante
B = Stelo in acciaio + dispositivo antivibrante
C = Stelo in metallo duro con testa in acciaio
D = Stelo in acciaio + dispositivo antivibrante + foro refrigerante
E = Stelo in metallo duro con testa in acciaio + foro refrigerante
F = Stelo in metallo duro con testa in acciaio + dispositivo antivibrante
G = Stelo in metallo duro con testa in acciaio + dispositivo antivibrante + foro refrigerante
H = Stelo in metallo pesante
J = Stelo in metallo pesante + foro refrigerante

S = Steel shank
A = Steel shank + coolant hole
B = Steel shank + anti-vibration device
C = carbide shank with steel head
D = Steel shank + anti-vibration device + coolant hole
E = carbide shank with steel head + coolant hole
F = carbide shank with steel head + anti-vibration device
G = carbide shank with steel head + anti-vibration device + coolant hole
H = Heavy metal shank
J = Heavy metal shank + coolant hole

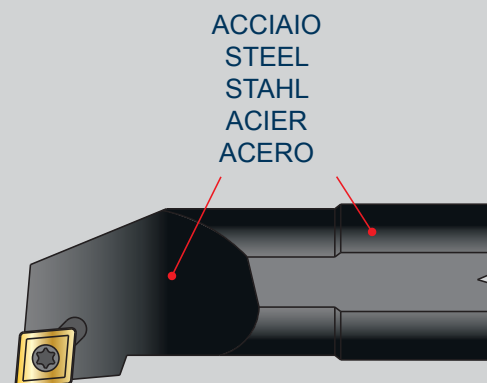
A...

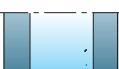


E...



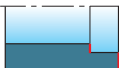
S...



TORNITURA ESTERNA EXTERNAL TURNING		FORMA DELL'INSERTO - INSERT SHAPE							
		C	D	K	R	S	T	V	W
									
TIPO DI LAVORAZIONE - TYPE OF MACHINING	Tornitura Assiale / Sfacciatura Axial Turning / Facing		●	○	○	○	○	○	○
	Profilatura Profiling			●	○		○	○	
	Sfacciatura Facing		○	○	○	○	●	○	○
	Tornitura a tuffo Plunge turning				●		○		

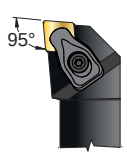
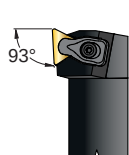
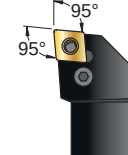
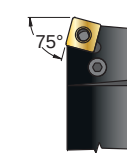
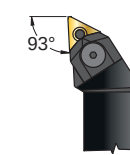
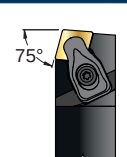
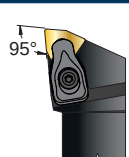
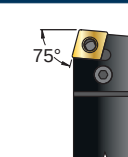
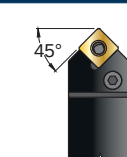
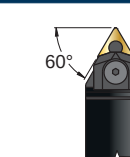
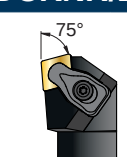
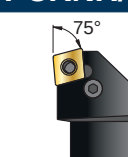
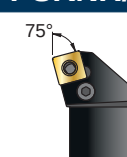
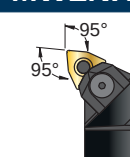
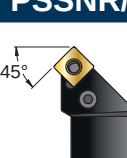
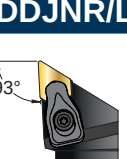
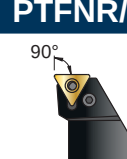
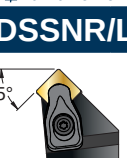
● FORMA CONSIGLIATA - RECOMMENDED SHAPE

○ FORMA POSSIBILE - POSSIBLE SHAPE

TORNITURA INTERNA INTERNAL TURNING		FORMA DELL'INSERTO - INSERT SHAPE							
		C	D	K	R	S	T	V	W
									
TIPO DI LAVORAZIONE - TYPE OF MACHINING	Tornitura Assiale / Sfacciatura Axial Turning / Facing		○	○		○	○	●	○
	Profilatura Profiling			●	●		○	○	
	Sfacciatura Facing		●	○		○	○		○

● FORMA CONSIGLIATA - RECOMMENDED SHAPE

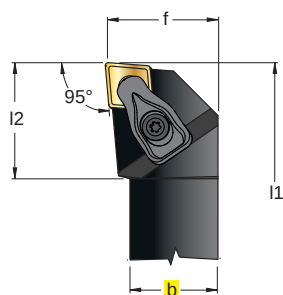
○ FORMA POSSIBILE - POSSIBLE SHAPE

D 		D 		P 		P 		M 	
DCLNR/L Pag.10		DTJNR/L Pag.14		PCLNR/L Pag.16		PSBNR/L Pag.19		MTJNR/L Pag.23	
 95° ⌀ 20x20 - 32x32	 CNM. 1204.. 1606.. 1906..	 93° ⌀ 20x20 - 32x32	 TNM. 1604.. 2204..	 95° ⌀ 16x16 - 40x40	 CNM. 0903.. 1204.. 1606.. 1906..	 75° ⌀ 20x20 - 40x40	 SNM. 1204.. 1506.. 1906..	 93° ⌀ 20x20 - 32x32	 TNM. 1604.. 2204..
DCBNR/L Pag.10		DWLNRL Pag.15		PCBNR/L Pag.16		PSDNN Pag.19		MTENN Pag.23	
 75° ⌀ 20x20 - 32x32	 CNM. 1204..	 95° ⌀ 20x20 - 25x25	 WNM. 0804..	 75° ⌀ 20x20 - 40x40	 CNM. 1204.. 1606.. 1906..	 45° ⌀ 20x20 - 32x32	 SNM. 1204.. 1906..	 60° ⌀ 20x20 - 32x32	 TNM. 1604.. 2204..
DCKNR/L Pag.11				PCKNR/L Pag.17		PSKNR/L Pag.20		MWLNRL Pag.24	
 75° ⌀ 20x20 - 32x32	 CNM. 1204..			 75° ⌀ 20x20 - 40x40	 CNM. 1204.. 1906..	 75° ⌀ 20x20 - 40x40	 SNM. 1204.. 1506.. 1906..	 95° ⌀ 20x20 - 32x32	 WNM. 0604.. 0804..
DCSNR/L Pag.11				PCSNR/L Pag.17		PSSNR/L Pag.20			
 45° ⌀ 20x20 - 32x32	 CNM. 1204..			 45° ⌀ 20x20 - 32x32	 CNM. 1204.. 1606.. 1906..	 45° ⌀ 20x20 - 40x40	 SNM. 1204.. 1506.. 1906..		
DDJNR/L Pag.12				PDJNR/L Pag.18		PTFNR/L Pag.21			
 93° ⌀ 20x20 - 25x25	 DNM. 1506..			 93° ⌀ 16x16 - 32x32	 DNM. 1104.. 1506..	 90° ⌀ 20x20 - 32x32	 TNM. 1604.. 2204..		
DSKNR/L Pag.13				PDNNR/L Pag.18		PTGNR/L Pag.21			
 75° ⌀ 20x20 - 32x32	 SNM. 1204.. 1506..			 63° ⌀ 20x20 - 32x32	 DNM. 1506..	 90° ⌀ 20x20 - 32x32	 TNM. 1604.. 2204..		
DSSNR/L Pag.13						PWLNRL Pag.22			
 45° ⌀ 20x20 - 25x25	 SNM. 1204..					 95° ⌀ 16x16 - 32x32	 WNM. 0604.. 0804..		

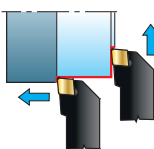
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MCLNR/L Pag.25		MVJNR/L Pag.28		SCLCR/L Pag.30		STFCR/L Pag.35		SVVBN Pag.38	
 CNM. 1204.. 1606.. 1906.. □ 20x20 - 32x32		 VNM. 1604.. □ 20x20 - 32x25		 CC.. 0602.. 09T3.. 1204.. □ 08x08 - 25x25		 TC.. 0902.. 1102.. 16T3.. □ 08x08 - 25x25		 VB.. 1604.. □ 20x20 - 32x25	
MDJNR/L Pag.26		MVVNN Pag.28		SCRCR/L Pag.30		STGCR/L Pag.35		C	
 DNM. 1506.. □ 20x20 - 32x32		 VNM. 1604.. □ 20x20 - 32x25		 NEW CC.. 0602.. 09T3.. 1204.. □ 08x08 - 25x25		 TC.. 0902.. 1102.. 16T3.. □ 08x08 - 25x25		CKJNR/L Pag.39	
 DNM. 1506.. □ 25x25		 VNM. 1604.. □ 20x20 - 32x25		 DC.. 0702.. 11T3.. □ 10x10 - 25x25		 VC.. 1103.. 1604.. □ 16x16 - 32x25		 KNUX 1604.. □ 20x20 - 32x32	
MDQNR/L Pag.26		MVPNR/L Pag.29		SDHCR/L Pag.31		SVHCR/L Pag.36		TTS - TOOLS	
MSSNR/L Pag.27				SDJCR/L Pag.31		SVJCR/L Pag.36		PCLNR/L..TTS Pag.40	
 SNM. 1204.. 1906.. □ 20x20 - 40x40				 DC.. 0702.. 11T3.. □ 08x08 - 25x25		 VC.. 1103.. 1604.. □ 12x12 - 32x25		 NEW CNM. 1204.. □ 20x20 - 32x32	
MSBNR/L Pag.27				SDNCN Pag.32		SVXCR/L Pag.37		PDJNR/L..TTS Pag.41	
 SNM. 1906.. □ 32x32 - 40x40				 DC.. 0702.. 11T3.. □ 08x08 - 25x25		 VC.. 1604.. □ 20x20 - 25x25		 NEW DNM. 1506.. □ 20x20 - 32x32	
				SRDCN Pag.33		SVVCN Pag.37		SCLCR/L..TTS Pag.42	
				 RC.. 0602M0.. 0803M0.. 1003M0.. □ 12x12 - 25x25		 VC.. 1103.. 1604.. □ 16x16 - 32x25		 NEW CC.. 1204.. □ 20x20 - 25x25	
				SSSCR/L Pag.34		SVJBR/L Pag.38		SDJCR/L..TTS Pag.43	
				 SC.. 09T3.. 1204.. □ 12x12 - 32x25		 VB.. 1604.. □ 16x16 - 32x25		 NEW DC.. 11T3.. □ 20x20 - 25x25	

20x20 - 32x32

95°



In figura utensile destro - Right-hand shown



CNMA



CNMG

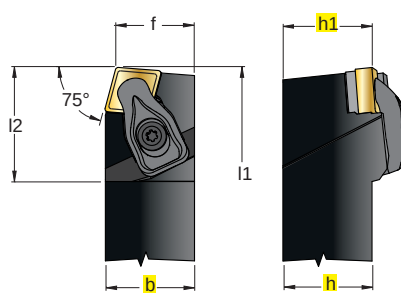


CNMM

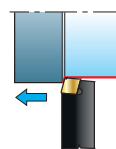


20x20 - 32x32

75°



In figura utensile destro - Right-hand shown



CNMA



CNMC

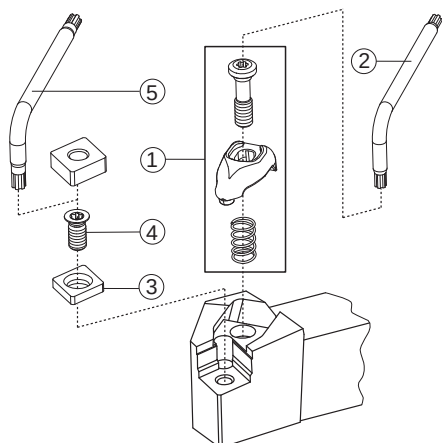


CNMM



INSERTI - INSERTS
PAG. 143

ART.											①	②	③	④	⑤		
R L (mm)																	
				h=h1	b	f	I1	I2	Nm								
DCLNR/L	2020	K	12	20	20	25	125	30	3,9	1204	100-21	5415	3612	125011	5420		
DCLNR/L	2525	M	12	25	25	32	150	33	3,9								
DCLNR/L	3232	P	12	32	32	40	170	34	3,9								
DCLNR/L	2525	M	16	25	25	32	150	36	6,4	1606	100-31	5420	3616	126011	5425		
DCLNR/L	3232	P	16	32	32	40	170	40	6,4								
DCLNR/L	3232	P	19 New	32	32	40	170	40	6,4								
DCBNR/L	2020	K	12	20	20	17	125	32	3,9	1204	100-21	5415	3612	125011	5420		
DCBNR/L	2525	M	12	25	25	22	150	32	3,9								
DCBNR/L	3232	P	12	32	32	27	170	32	3,9								

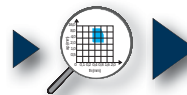


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

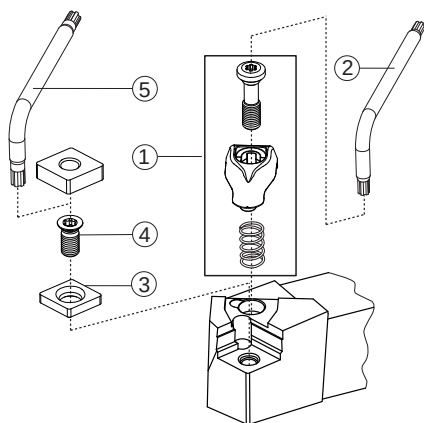


PAG. 967



PAG. 992

DCKNR/L $\varnothing 20 \times 20 - 32 \times 32$										DCSNR/L $\varnothing 20 \times 20 - 32 \times 32$									
75°										45°									
In figura utensile destro - Right-hand shown										In figura utensile destro - Right-hand shown									
CNMA										CNMA									
CNMG										CNMG									
CNMM										CNMM									
D										D									
NEW										NEW									
.G23 .G61 .B32 .G39 .G42 .G52 .G53 .G55 .G56 .K57P .G62 .G63 .G68 .G72 .G82										.G23 .G61 .B32 .G39 .G42 .G52 .G53 .G55 .G56 .K57P .G62 .G63 .G68 .G72 .G82									
ART. (mm)										1 2 3 4 5									
h=h1 b f l1 l2 Nm										100-21 5415 3612 125011 5420									
DCKNR/L 2020 K 12										1204									
DCKNR/L 2525 M 12										1204									
DCKNR/L 3232 P 12										1204									
DCSNR/L 2020 K 12										1204									
DCSNR/L 2525 M 12										1204									
DCSNR/L 3232 P 12										1204									



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
Vc. CUTTING SPEED
Vc. SCHNITTGESCHWINDIGKEIT
Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
SPARE PARTS DETAILS
DETAILS ZU DEN ERSATZTEILEN
DÉTAIL DE PIÉCES DE RECHANGE

DATI TECNICI E CONSIGLI
TECHNICAL DATA AND SUGGESTIONS
TECHNISCHE DATEN UND EMPFEHLUNGEN
DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



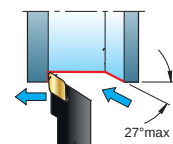
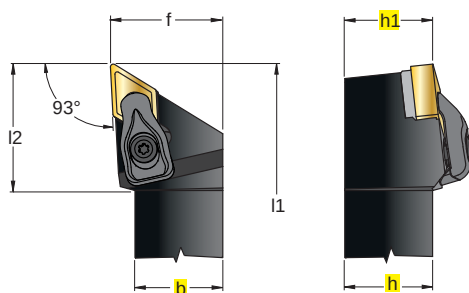
PAG. 967



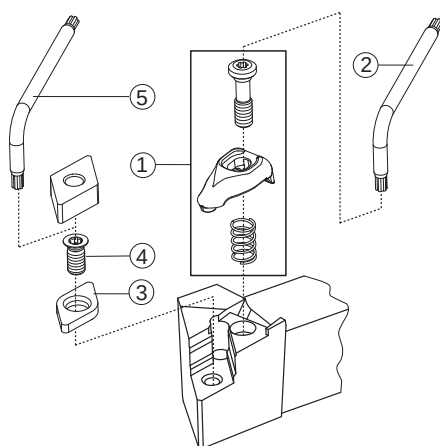
PAG. 992

20x20 - 32x32

93°



D

[illegible]

 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO V_c
 V_c. CUTTING SPEED
 V_c. SCHNITTGESCHWINDIGKEIT
 V_c. VITESSE DE COUPE

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 **DATI TECNICI E CONSIGLI**
 TECHNICAL DATA AND SUGGESTIONS
 **TECHNISCHE DATEN UND EMPFEHLUNGEN**
 **DONNÉES TECHNIQUES ET CONSEILS**



PAG. 136



PAG. 132



PAG. 967

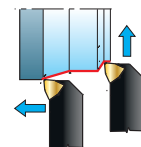
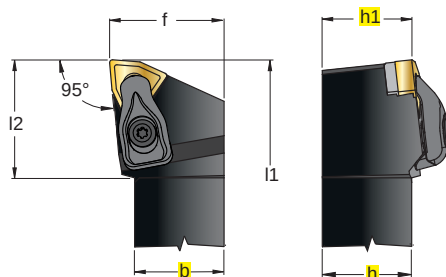


PAG. 992

DWLNRL/L

∅ 20x20 - 25x25

93°



WNMA



WNMG



WNMM

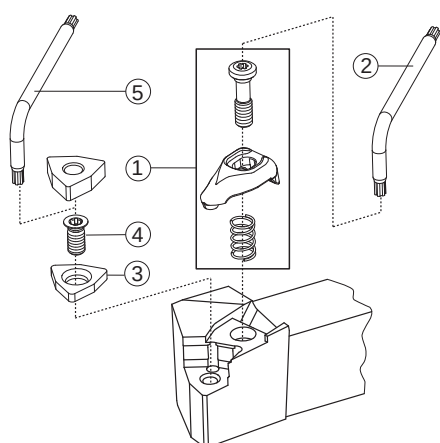


D



In figura utensile destro - Right-hand shown

.G23	.G61	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63							INSERTI - INSERTS PAG. 148
ART.		(mm)														
		h=h1		b	f	l1	l2	Nm			1	2	3	4	5	
DWLNRL/L 2020 K 08		20		20	25	125	30	3,9	0804		100-21	5415	3308M	125011	5420	
DWLNRL/L 2525 M 08		25		25	32	150	33	3,9								



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÉCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967



PAG. 992

PCLNR/L $\varnothing 16 \times 16 - 40 \times 40$

95°

In figura utensile destro - Right-hand shown

PCBNR/L $\varnothing 20 \times 20 - 40 \times 40$

75°

In figura utensile destro - Right-hand shown

CNMA

CNMG

CNMM

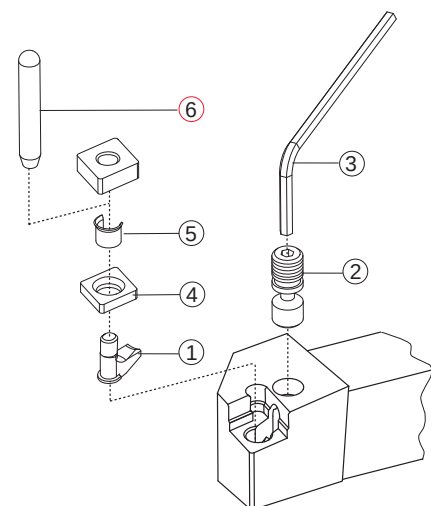
P

P



ART.	(mm)		1	2	3	4	5	6
			h=h1	b	f	l1	l2	
PCLNR/L 1616 H 09			16	16	20	100	22	0903
PCLNR/L 2020 K 09			20	20	25	125	26	
PCLNR/L 2525 M 09			25	25	32	150	25	
PCLNR/L 2020 K 12			20	20	25	125	28	1204
PCLNR/L 2525 M 12			25	25	32	150	33	
PCLNR/L 3225 P 12			32	25	32	170	28	
PCLNR/L 3232 P 12			32	32	40	170	30	
PCLNR/L 2525 M 16			25	25	32	150	33	1606
PCLNR/L 3225 P 16			32	25	32	170	33	
PCLNR/L 3232 P 16			32	32	40	170	33	
PCLNR/L 2525 M 19			25	25	32	150	36	1906
PCLNR/L 3232 P 19			32	32	40	170	40	
PCLNR/L 4040 S 19			40	40	50	250	40	

PCBNR/L 2020 K 12	20	20	17	125	28	1204	8012	1608	5003	3612	4112	0012
PCBNR/L 2525 M 12	25	25	22	150	29							
PCBNR/L 3225 P 12	32	25	22	170	32							
PCBNR/L 2525 M 16	25	25	22	150	29	1606	8016	1618	5003	3616	4115	0015
PCBNR/L 3225 P 16	32	25	22	170	32							
PCBNR/L 3232 P 16	32	32	27	170	35							
PCBNR/L 3232 P 19	32	32	27	170	35	1906	8019	1610	5004	3619	4119	0019
PCBNR/L 4040 S 19	40	40	35	250	37							

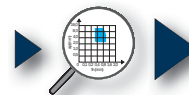


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
Vc. CUTTING SPEED
Vc. SCHNITTGESCHWINDIGKEIT
Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
SPARE PARTS DETAILS
DETAILS ZU DEN ERSATZTEILEN
DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
TECHNICAL DATA AND SUGGESTIONS
TECHNISCHE DATEN UND EMPFEHLUNGEN
DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967



PAG. 992

PCKNR/L

20x20 - 40x40

75°

In figura utensile destro - Right-hand shown

PCSNR/L

20x20 - 32x32

45°

In figura utensile destro - Right-hand shown

CNMA

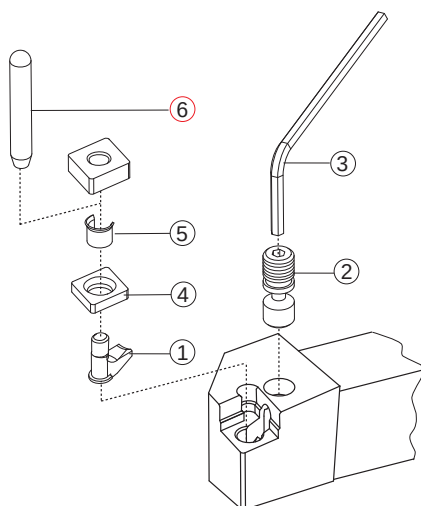
CNMG

CNMM

P

P

															 INSERTI - INSERTS PAG. 143	
.G23	.G61	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82		
ART. (mm)																
			h=h1	b	f	l1	l2									
PCKNR/L	2020	K 12	20	20	25	125	26		1204	8012	1608	5003	3612	4112	0012	
PCKNR/L	2525	M 12	25	25	32	150	30		1606	8016	1618	5003	3616	4115	0015	
PCKNR/L	2525	M 16	25	25	32	150	33			8019	1610	5004	3619	4119	0019	
PCKNR/L	3232	P 16	32	32	40	170	34									
PCKNR/L	3232	P 19	32	32	40	170	36		1906	8019	1610	5004	3619	4119	0019	
PCKNR/L	4040	S 19	40	40	50	250	45									
PCKNR/L	2020	K 12	20	20	25	125	26		1204	8012	1608	5003	3612	4112	0012	
PCKNR/L	2525	M 12	25	25	32	150	30		1606	8016	1618	5003	3616	4115	0015	
PCKNR/L	2525	M 16	25	25	32	150	33			8019	1610	5004	3619	4119	0019	
PCKNR/L	3232	P 16	32	32	40	170	34									
PCKNR/L	3232	P 19	32	32	40	170	40		1906	8019	1610	5004	3619	4119	0019	
PCSNR/L	2020	K 12	20	20	25	125	28		1204	8012	1608	5003	3612	4112	0012	
PCSNR/L	2525	M 12	25	25	32	150	30		1606	8016	1618	5003	3616	4115	0015	
PCSNR/L	2525	M 16	25	25	32	150	33			8019	1610	5004	3619	4119	0019	
PCSNR/L	3232	P 16	32	32	40	170	34									
PCSNR/L	3232	P 19	32	32	40	170	40		1906	8019	1610	5004	3619	4119	0019	



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

PAG. 136

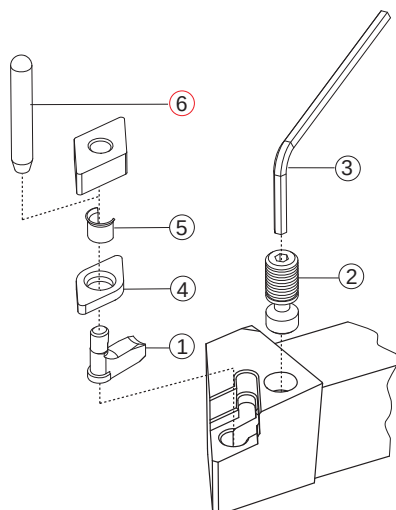
Vc **PAG. 132**

PAG. 967

PAG. 992

PDJNR/L $\varnothing 16 \times 16 - 32 \times 32$										PDNNR/L $\varnothing 20 \times 20 - 32 \times 32$									
93°										63°									
DNMA DNMG DNMM P										DNMA DNMG DNMM P									
In figura utensile destro - Right-hand shown										In figura utensile destro - Right-hand shown									
ART. (mm) 																			
h=h1 b f l1 l2																			
PDJNR/L 1616 H 11										1104									
PDJNR/L 2020 K 11										8411 1606 5025 3710 4108 0009									
PDJNR/L 2525 M 11																			
PDJNR/L 2020 K 15										1506									
PDJNR/L 2525 M 15										8415 1638 5003 3715 4112 0012									
PDJNR/L 3225 P 15																			
PDJNR/L 3232 P 15																			
PDNNR/L 2020 K 15										1506									
PDNNR/L 2525 M 15										8415 1638 5003 3715 4112 0012									
PDNNR/L 3225 P 15																			
PDNNR/L 3232 P 15																			

INSERTI - INSERTS
PAG. 145

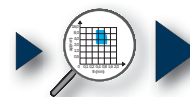


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
Vc. CUTTING SPEED
Vc. SCHNITTGESCHWINDIGKEIT
Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
SPARE PARTS DETAILS
DETAILS ZU DEN ERSATZTEILEN
DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
TECHNICAL DATA AND SUGGESTIONS
TECHNISCHE DATEN UND EMPFEHLUNGEN
DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

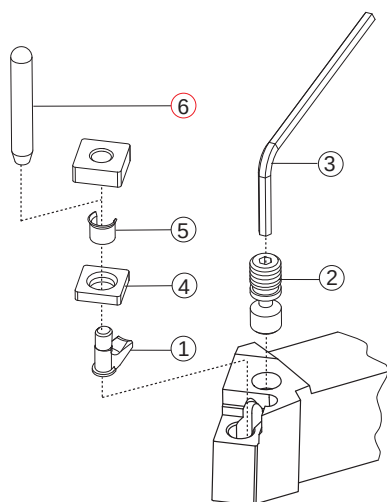


PAG. 967



PAG. 992

PSBNR/L										PSDNN									
Ø 20x20 - 40x40										Ø 20x20 - 32x32									
75°										45°									
In figura utensile destro - Right-hand shown																			
.G61 .G52 .G53 .G55 .G56 .G62 .G54 .G72 .G82										INSERTI - INSERTS PAG. 146									
ART. (mm)																			
PSBNR/L 2020 K 12										1204									
PSBNR/L 2525 M 12										8012 1608 5003 3512 4112 0012									
PSBNR/L 2525 M 15										8016 1618 5003 3515 4115 0015									
PSBNR/L 3232 P 15										1906 8019 1610 5004 3519 4119 0019									
PSBNR/L 3232 P 19																			
PSBNR/L 4040 S 19																			
PSDNN 2020 K 12										1204									
PSDNN 2525 M 12										8012 1608 5003 3512 4112 0012									
PSDNN 3232 P 19										1906 8019 1610 5004 3519 4119 0019									



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÉCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967



PAG. 992

PSKNR/L $\varnothing 20 \times 20 - 40 \times 40$

75°

In figura utensile destro - Right-hand shown

PSSNR/L $\varnothing 20 \times 20 - 40 \times 40$

45°

In figura utensile destro - Right-hand shown

SNMA

SNMG

SNMM

P

SNMA

SNMG

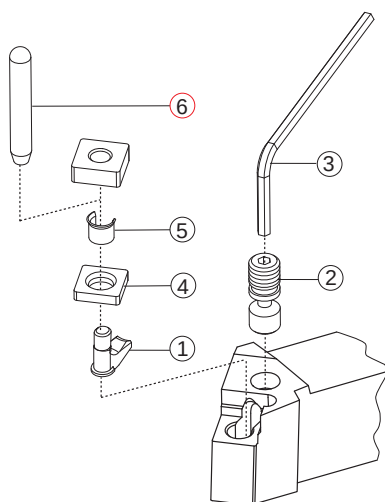
SNMM

P



ART. (mm)										①	②	③	④	⑤	⑥
		h=h1		b	f	l1	l2								
PSKNR/L	2020 K 12	20	20	25	125	26		1204	8012	1608	5003	3512	4112	0012	
PSKNR/L	2525 M 12	25	25	32	150	26		1506	8016	1618	5003	3515	4115	0015	
PSKNR/L	2525 M 15	25	25	32	150	30			8016	1618	5003	3515	4115	0015	
PSKNR/L	3232 P 15	32	32	40	170	34		1906	8019	1610	5004	3519	4119	0019	
PSKNR/L	3232 P 19	32	32	40	170	34			8019	1610	5004	3519	4119	0019	
PSKNR/L	4040 S 19	40	40	50	250	38									

PSSNR/L	2020	K	12	20	20	25	125	29	1204	8012	1608	5003	3512	4112	0012
PSSNR/L	2525	M	12	25	25	32	150	29	1506	8016	1618	5003	3515	4115	0015
PSSNR/L	3225	P	12	32	25	32	170	29		8016	1618	5003	3515	4115	0015
PSSNR/L	2525	M	15	25	25	32	150	36	1906	8019	1610	5004	3519	4119	0019
PSSNR/L	3232	P	15	32	32	40	170	40		8019	1610	5004	3519	4119	0019
PSSNR/L	3232	P	19	32	32	40	170	40							
PSSNR/L	4040	S	19	40	40	50	250	40							



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

PAG. 136

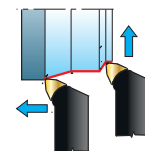
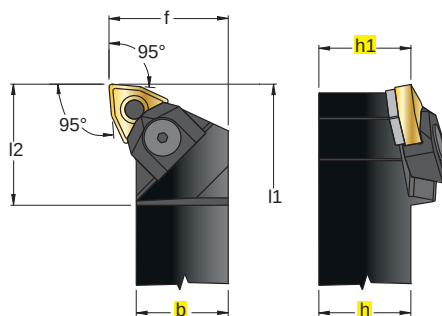
PAG. 132

PAG. 967

PAG. 992

20x20 - 32x32

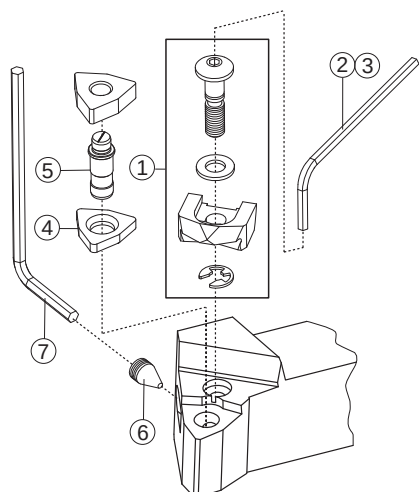
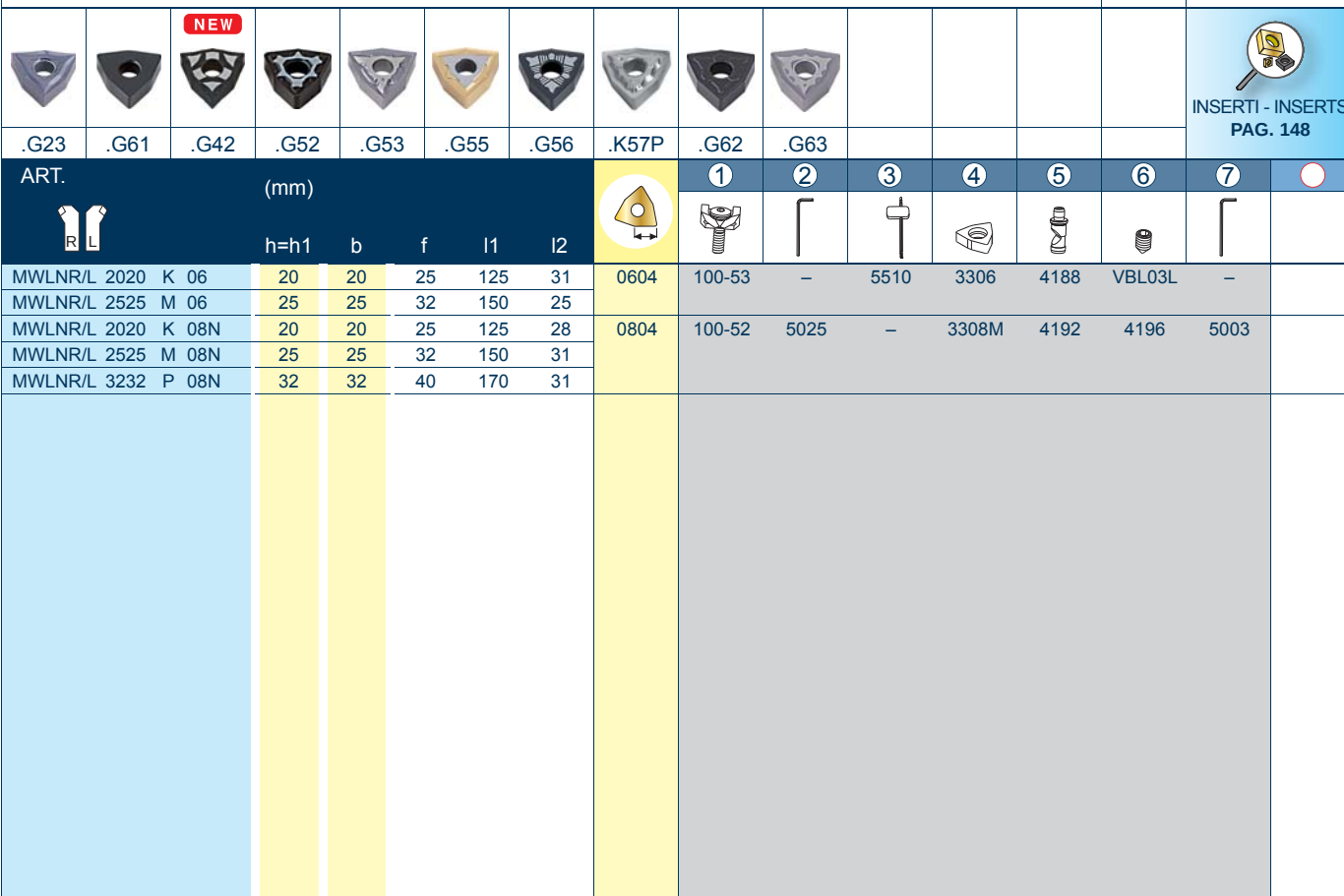
95°



M



INSERTI - INSERTS
PAG. 148



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
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 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967

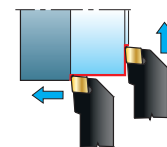
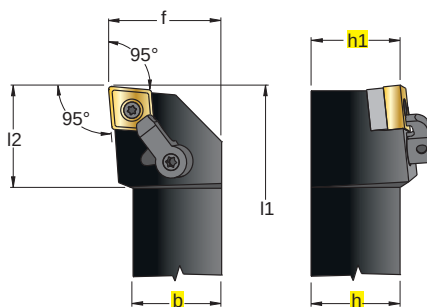


PAG. 992

MCLNR/L

20x20 - 40x40

95°



CNMA



CNMG



CNMM



M



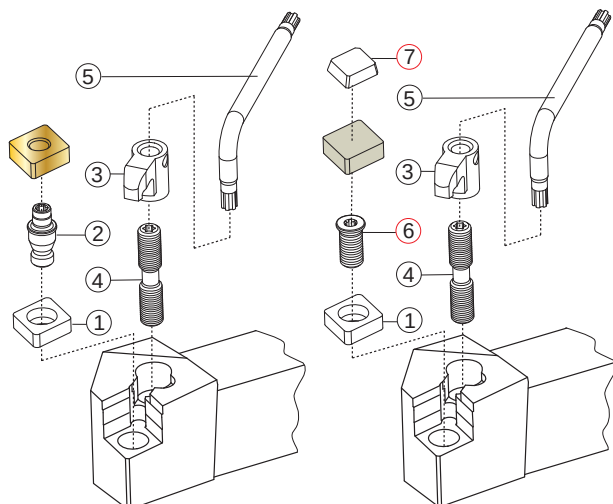
In figura utensile destro - Right-hand shown

															 INSERTI - INSERTS PAG. 143	
.G23	.G61	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82		
ART. (mm) 										①	②	③	④	⑤	⑥	⑦
																
MCLNR/L 2020 K 12			20	20	25	125	28	1204	KCN433	KLM 46	CKM 21	STCM20	5415	KMS 4	RCN1225	
MCLNR/L 2525 M 12			25	25	32	150	33	1606	KCN533	KLM 58	CKM 21	STCM20	5415	KMS 5	-	
MCLNR/L 3225 P 12			32	25	32	170	28									
MCLNR/L 3232 P 12			32	32	40	170	30									
MCLNR/L 2525 M 16			25	25	32	150	33									
MCLNR/L 3225 P 16			32	25	32	170	33	1906	KCN633	KLM 68	CKM 12	STCM4	5425	KMS 6	-	
MCLNR/L 3232 P 16			32	32	40	170	33									
MCLNR/L 3232 P 19			32	32	40	170	40									
MCLNR/L 4040 S 19			40	40	50	250	40									

ART.	DIMENSIONI MEASURES ABMESSUNGEN DIMENSIONS	INSERTO INSERT WENDEPLATTEN PLAQUETTES
RCN 1225		
	L 10,7	
	H 2,5	
	R 2,3	

- VITE DI FISSAGGIO DEL SOTTOPLACCHETTA PER INSERTI SENZA FORO
 - SHIM CLAMPING SCREW FOR INSERTS WITHOUT BORE
 - UNTERLEGPLATTENBEFESTIGUNGSSCHRAUBE FÜR WENDEPLATTEN OHNE BOHRUNG
 - VIS DE FIXAGE DE SOUS-PLAQUETTE POUR PLAQUETTES SANS TROU

- ROMPIRUCIOLO PER INSERTI CERAMICI E SENZA FORO
 - CHIP BREAKER FOR CERAMIC INSERTS AND FOR INSERTS WITHOUT BORE
 - SPANBRECHER FÜR KERAMISCHE WENDEPLATTEN UND FÜR WENDEPLATTEN OHNE KUEHLMITTELBOHRUNG
 - BRISE-CPEAUX POUR PLAQUETTES CERAMIQUES ET POUR PLAQUETTES SANS TROU



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967



PAG. 992

25x25

107.5°



In figura utensile destro - Right-hand shown



INSERTI - INSERTS
PAG. 145

(mm)

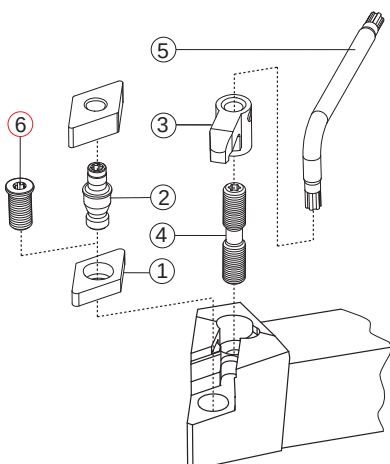


MDJNR/L	2020	K	15	20	20	25	125	35	1506	KDN433	KLM 46L	CKM 22	STCM20	5415	KMS 4
MDJNR/L	2525	M	15	25	25	32	150	35							
MDJNR/L	3225	P	15	32	25	32	170	36							
MDJNR/L	3232	P	15	32	32	40	170	36							

- - VITE DI FISSAGGIO DEL SOTTOPLACCHETTA PER INSERTI SENZA FORO
-  - SHIM CLAMPING SCREW FOR INSERTS WITHOUT BORE
-  - UNTERLEGPLATTENBEFESTIGUNGSSCHRAUBE FÜR WENDEPLATTEN OHNE BOHRUNG
- - VIS DE FIXAGE DE SOUS-PLAQUETTE POUR PLAQUETTES SANS TROU

MDQNR/L 2525 M 15	25	25	32	150	36	1506	KDN433	KLM 46L	CKM 22	STCM20	5415	KMS 4
-------------------	----	----	----	-----	----	------	--------	---------	--------	--------	------	-------

-  - VITE DI FISSAGGIO DEL SOTTOPLACCHETTA PER INSERTI SENZA FORO
-  - SHIM CLAMPING SCREW FOR INSERTS WITHOUT BORE
-  - UNTERLEGPLATTENBEFESTIGUNGSSCHRAUBE FÜR WENDEPLATTEN OHNE BOHRUNG
-  - VIS DE FIXAGE DE SOUS-PLAQUETTE POUR PLAQUETTES SANS TROU

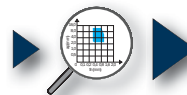


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 **DATI TECNICI E CONSIGLI**
 TECHNICAL DATA AND SUGGESTIONS
 **TECHNISCHE DATEN UND EMPFEHLUNGEN**
 **DONNÉES TECHNIQUES ET CONSEILS**



PAG. 136



PAG. 132

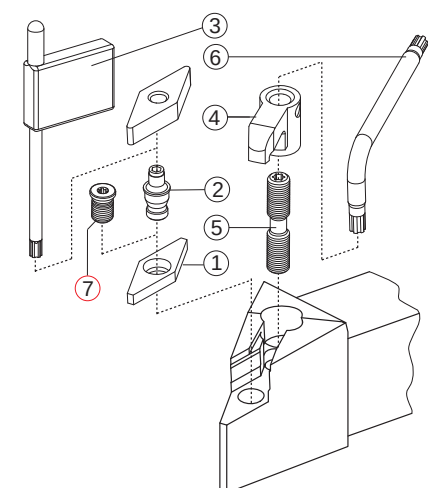


PAG. 967



PAG. 992

MVJNR/L										ϕ 20x20 - 32x25		MVVNN										ϕ 20x20 - 32x25	
93°												72,5°											
In figura utensile destro - Right-hand shown																							
																						INSERTI - INSERTS PAG. 147	

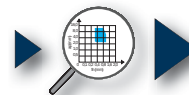


CAMPI D'IMPIEGIO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



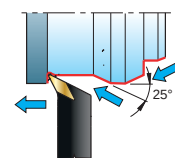
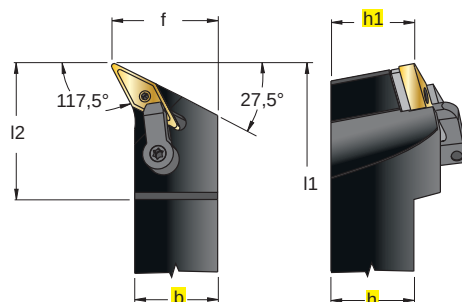
PAG. 967



PAG. 992

Ø 20x20 - 32x25

117,5°



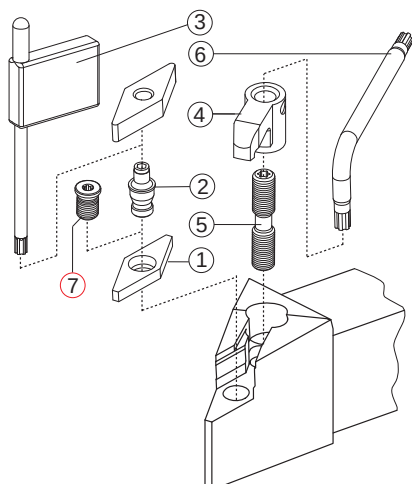
VNMG

M



INSERTI - INSERTS
PAG. 147

.G23	.G42	.G52	.G53	.G55													INSERTI - INSERTS PAG. 147	
ART.								(mm)										
MV	PNR/L	2020 K 16	20	20	25	125	41	1604	KVN323	KLM34L	5508	CKM22	STCM20	5415	KMS 3			
MV	PNR/L	2525 M 16	25	25	32	150	41											
MV	PNR/L	3225 P 16	32	25	32	170	32											



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÉCES DE RECHANGE

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



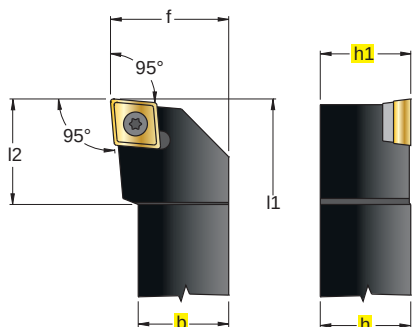
PAG. 967



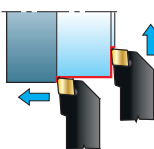
PAG. 992

08x08 - 25x25

95°



In figura utensile destro - Right-hand shown



CC.T



CC.W



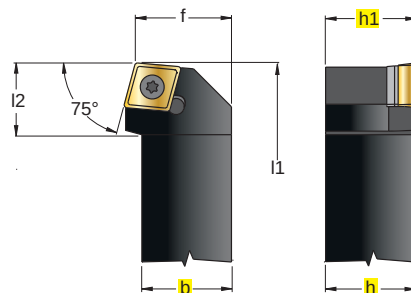
S



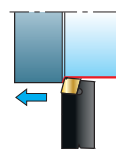
Ø 08x08 - 25x25

75°

NEW



In figura utensile destro - Right-hand shown



CC.1



CC.V



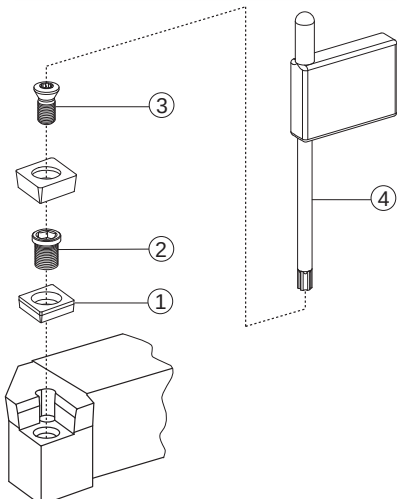
S



INSERTI - INSERTS
PAG. 149

- - PER UTENSILE R MONTARE INSERTO CCET..R.B22 , PER UTENSILE L MONTARE INSERTO CCET..L.B22
- - FOR R TOOL FIT INSERT CCET..R.B22, FOR L TOOL FIT INSERT CCET..L.B22
-  - FÜR DAS WERKZEUG R DIE WENDEPLATTE CCET..R.B22 EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE CCET..L.B22...
-  - DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE CCET..R.B22. DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE CCET..L.B22

-  - PER UTENSILE R MONTARE INSERTO CCET..R.B22 , PER UTENSILE L MONTARE INSERTO CCET..L.B22
-  - FOR R TOOL FIT INSERT CCET..R.B22, FOR L TOOL FIT INSERT CCET..L.B22
-  - FÜR DAS WERKZEUG R DIE WENDEPLATTE CCET..R.B22 EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE CCET..L.B22...
-  - DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE CCET..R.B22. DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE CCET..L.B22



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO V_c
 V_c. CUTTING SPEED
 V_c. SCHNITTGESCHWINDIGKEIT
 V_c. VITESSE DE COUPE

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

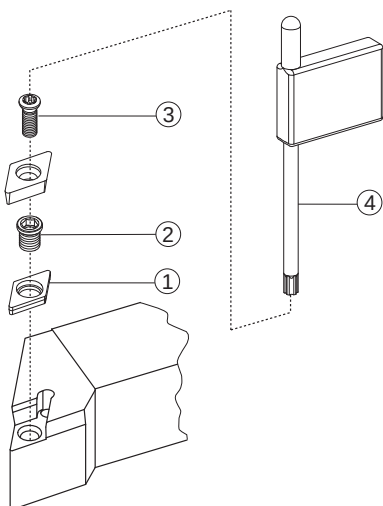


PAG. 967



PAG. 992

SDHCR/L $\varnothing 10 \times 10 - 25 \times 25$							SDJCR/L $\varnothing 08 \times 08 - 25 \times 25$						
107,5°							93°						
DC.T							DC.T						
DC.W							DC.W						
S							S						
In figura utensile destro - Right-hand shown							In figura utensile destro - Right-hand shown						
.G13 .B53 .G57P .Z57 .G39 .G42 .G52							INSERTI - INSERTS PAG. 150						
ART. (mm)													
h=h1 b f l1 l2 Nm													
SDHCR/L 1010 E 07							0702						
SDHCR/L 1212 F 07							11T3						
SDHCR/L 1616 H 11							3711 BCL7 123511P 5515P						
SDHCR/L 2020 K 11													
SDHCR/L 2525 M 11													
SDJCR/L 0808 D 07							0702						
SDJCR/L 1010 E 07							11T3						
SDJCR/L 1212 F 07							3711 BCL7 123511P 5515P						
SDJCR/L 1616 H 11													
SDJCR/L 2020 K 11													
SDJCR/L 2525 M 11													



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÉCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



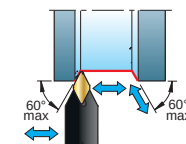
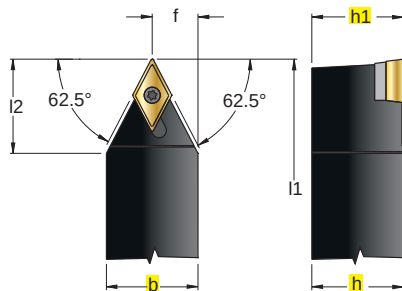
PAG. 967



PAG. 992

Ø 08x08 - 25x25

63°



A cross-sectional diagram of a dovetail joint. It shows a central yellow rectangular piece (the pin) fitting into a wider, grey-hatched rectangular piece (the tail). The top surface of the yellow piece is tapered, and the angle of this taper is indicated by a dimension line and labeled as 7° .

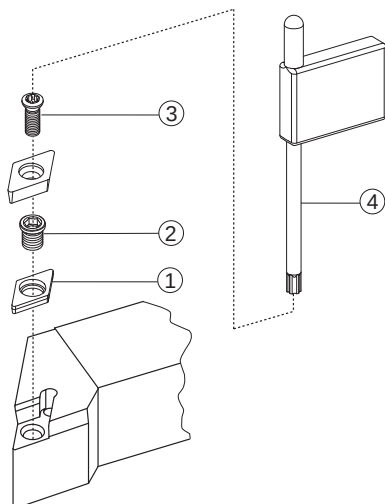
A diagram of a dovetail joint. It shows a cross-section of a wooden joint with a central yellow dovetail pin and two gray dovetail tails on either side. The angle of the dovetail tails is indicated as 7° .

S



INSERTI - INSERTS
PAG. 150

ART. (mm)											1	2	3	4	
			h=h1	b	f	l1	l2	Nm							
SDNCN	0808	D 07	8	8	4,0	60	9	1,1+1,3	0702	—	—	12256P	5508P		
SDNCN	1010	E 07	10	10	5,0	70	11	1,1+1,3							
SDNCN	1212	F 07	12	12	6,0	80	13	1,1+1,3	11T3	—	—	12409P	5515P		
SDNCN	1212	F 11	12	12	6,0	80	12	3,8+5,0		—	—	12409P	5515P		
SDNCN	1616	H 11	16	16	8,0	100	16	3,0+3,5	11T3	3711	BCL7	123511P	5515P		
SDNCN	2020	K 11	20	20	10,0	125	20	3,0+3,5							
SDNCN	2525	M 11	25	25	12,5	150	25	3,0+3,5							

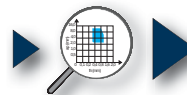


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 **DATI TECNICI E CONSIGLI**
 TECHNICAL DATA AND SUGGESTIONS
 **TECHNISCHE DATEN UND EMPFEHLUNGEN**
 **DONNÉES TECHNIQUES ET CONSEILS**



PAG. 136



PAG. 132



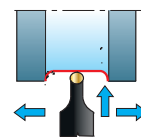
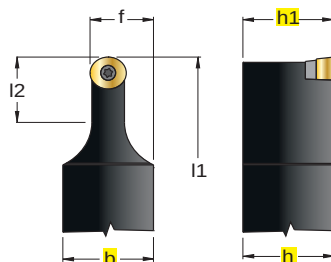
PAG. 967



PAG. 992

SRDCN

Ø 12x12 - 25x25



RC.T



RC.W



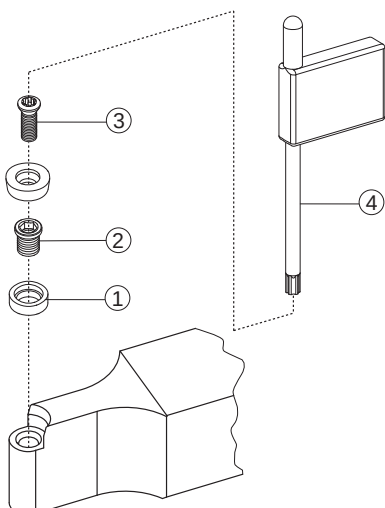
S



.Z57 .G52

INSERTI - INSERTS
PAG. 151

ART.		(mm)									1	2	3	4	
		h=h1	b	f	l1	l2	Nm								
SRDCN	1212 F 06	12	12	9,0	80	12,5	1,1+1,3	0602M0	—	—	12256P	5508P			
SRDCN	1616 H 06	16	16	11,0	100	12,5	1,1+1,3								
SRDCN	2020 K 06	20	20	13,0	125	12,5	1,1+1,3								
SRDCN	2525 M 06	25	25	15,5	150	12,5	1,1+1,3								
SRDCN	1616 H 08	16	16	12,0	100	16,5	1,2+1,5	0803M0	—	—	123008P	5508P			
SRDCN	2020 K 08	20	20	14,0	125	16,5	1,2+1,5								
SRDCN	2525 M 08	25	25	16,5	150	16,5	1,2+1,5								
SRDCN	1616 H 10	16	16	13,0	100	20,5	3,0+3,5								
SRDCN	2020 K 10	20	20	15,0	125	20,5	3,0+3,5	1003M0	3810	BCL7	123511P	5515P			
SRDCN	2525 M 10	25	25	17,5	150	20,5	3,0+3,5								



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
Vc. CUTTING SPEED
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DETTAGLIO RICAMBI
SPARE PARTS DETAILS
DETAILS ZU DEN ERSATZTEILEN
DÉTAIL DE PIÉCES DE RECHANGE

DATI TECNICI E CONSIGLI
TECHNICAL DATA AND SUGGESTIONS
TECHNISCHE DATEN UND EMPFEHLUNGEN
DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



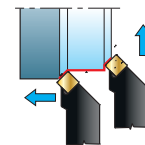
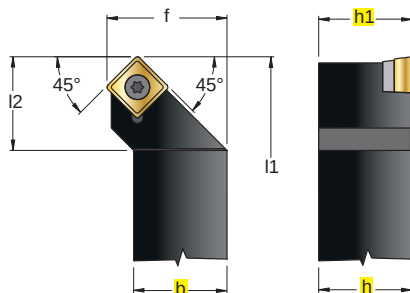
PAG. 967



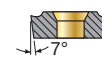
PAG. 992

Ø 12x12 - 25x25

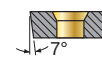
45°



SC.T



SC.W



S



												
.G57P	.Z57	.G52										

 INSERTI - INSERTS
PAG. 151

ART.

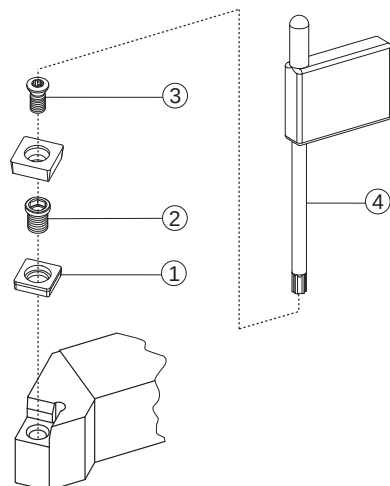
(mm)



Nm



														
h=h1									Nm					
SSSCR/L 1212 F 09				12	12	16	80	19	3,8+5,0	09T3	—	—	12409P	5515P
SSSCR/L 1616 H 09				16	16	20	100	22	3,0+3,5	09T3	3509	BCL7	123511P	5515P
SSSCR/L 2020 K 09				20	20	25	125	23	3,0+3,5					
SSSCR/L 1616 H 12				16	16	20	100	22	4,0+5,0	1204	3511	BCL15	124513P	5520P
SSSCR/L 2020 K 12				20	20	25	125	23	4,0+5,0					
SSSCR/L 2525 M 12				25	25	32	150	27	4,0+5,0					



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO Vc
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 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

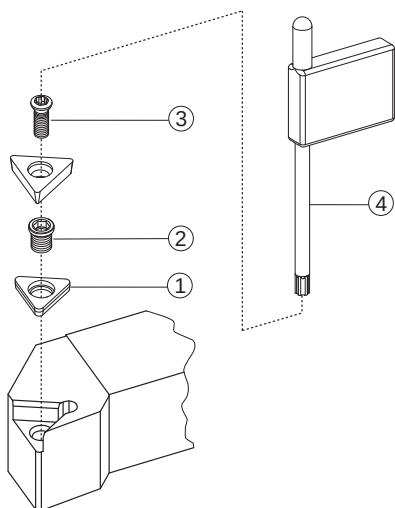


PAG. 967



PAG. 992

STFCR/L $\varnothing 08 \times 08 - 25 \times 25$										STGCR/L $\varnothing 08 \times 08 - 25 \times 25$									
90°										90°									
In figura utensile destro - Right-hand shown										In figura utensile destro - Right-hand shown									
 										 INSERTI - INSERTS PAG. 152									
ART. (mm)										 1 2 3 4									
 h=h1 b f l1 l2 Nm										 1 2 3 4									
STFCR/L 0808 D 09										STFCR/L 0808 D 09									
STFCR/L 1010 E 09										STFCR/L 1010 E 09									
STFCR/L 1212 F 11										STFCR/L 1212 F 11									
STFCR/L 1616 H 11										STFCR/L 1616 H 11									
STFCR/L 1616 H 16										STFCR/L 1616 H 16									
STFCR/L 2020 K 16										STFCR/L 2020 K 16									
STFCR/L 2525 M 16										STFCR/L 2525 M 16									
STGCR/L 0808 D 09										STGCR/L 0808 D 09									
STGCR/L 1010 E 09										STGCR/L 1010 E 09									
STGCR/L 1212 F 11										STGCR/L 1212 F 11									
STGCR/L 1616 H 11										STGCR/L 1616 H 11									
STGCR/L 1616 H 16										STGCR/L 1616 H 16									
STGCR/L 2020 K 16										STGCR/L 2020 K 16									
STGCR/L 2525 M 16										STGCR/L 2525 M 16									



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

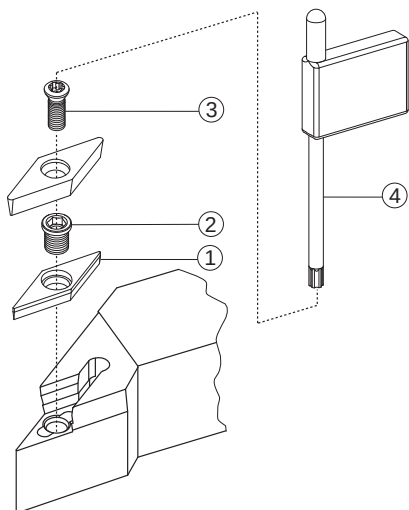
PAG. 136

PAG. 132

PAG. 967

PAG. 992

SVHCR/L					SVJCR/L				
16x16 - 32x25					12x12 - 32x25				
107,5°					93°				
VC.T					VC.T				
VC.W					VC.W				
S					S				
In figura utensile destro - Right-hand shown					In figura utensile destro - Right-hand shown				
					INSERTI - INSERTS PAG. 153				
ART. (mm)									
h=h1					b				
f					l1				
l2					Nm				
SVHCR/L 1616 H 11					16 16 20 100 15 1,1+1,3 1103				
SVHCR/L 2020 K 11					20 20 25 125 18 1,1+1,3				
SVHCR/L 2525 M 11					25 25 32 150 25 1,1+1,3				
SVHCR/L 2020 K 16					20 20 25 125 17 3,0+3,5				
SVHCR/L 2525 M 16					25 25 32 150 23 3,0+3,5				
SVHCR/L 3225 P 16					32 25 32 170 23 3,0+3,5				
SVJCR/L 1212 F 11					12 12 16 80 21 1,1+1,3 1103				
SVJCR/L 1616 H 11					16 16 20 100 24 1,1+1,3				
SVJCR/L 2020 K 11					20 20 25 125 23 1,1+1,3				
SVJCR/L 2525 M 11					25 25 32 150 27 1,1+1,3				
SVJCR/L 2020 K 16					20 20 25 125 30 3,0+3,5				
SVJCR/L 2525 M 16					25 25 32 150 33 3,0+3,5				
SVJCR/L 3225 P 16					32 25 32 170 33 3,0+3,5				



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

VELOCITÀ DI TAGLIO Vc
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 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

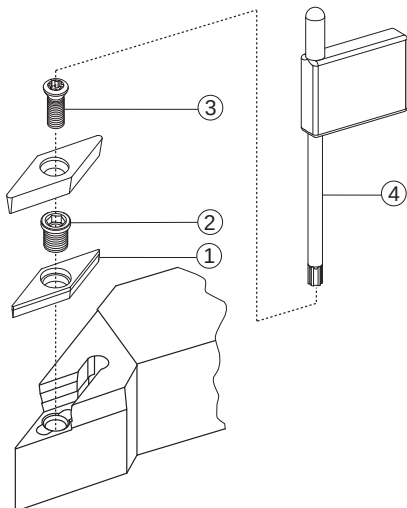


PAG. 967



PAG. 992

SVXCR/L					Ø 20x20 - 25x25					SVVCN					Ø 16x16 - 32x25																																												
In figura utensile destro - Right-hand shown					VC.T					VC.T																																																	
VC.W					VC.W					VC.W																																																	
S					S					S																																																	
.G13					.G57P					.Z57					.G42					.G52																																							
ART.					(mm)					Nm					1604					3716					BCL7					123511P					5515P																								
h=h1					b					f					l1					l2					1					2					3					4					5														
SVXCR/L 2020 K 16					20					20					25					125					25					3,0+3,5					1604					3716					BCL7					123511P					5515P				
SVXCR/L 2525 M 16					25					25					32					150					25					3,0+3,5					1604					3716					BCL7					123511P					5515P				
SVVCN 1616 H 11					16					16					8,0					100					26					1,1+1,3					1103					-					-					12256P					5508P				
SVVCN 2020 K 11					20					20					10,0					125					32					1,1+1,3					1103					-					-					12256P					5508P				
SVVCN 2525 M 11					25					25					12,5					150					40					1,1+1,3					1103					-					-					12256P					5508P				
SVVCN 2020 K 16					20					20					10,0					125					34					3,0+3,5					1604					3716					BCL7					123511P					5515P				
SVVCN 2525 M 16					25					25					12,5					150					42					3,0+3,5					1604					3716					BCL7					123511P					5515P				
SVVCN 3225 P 16					32					25					12,5					170					42					3,0+3,5					1604					3716					BCL7					123511P					5515P				



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
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 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967

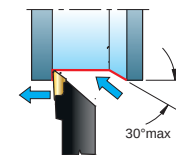
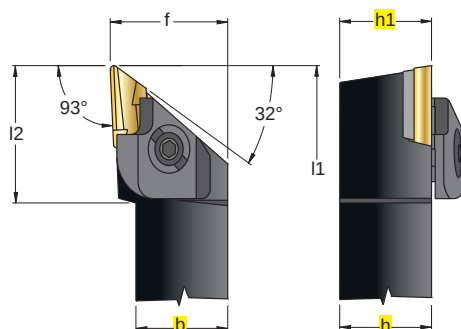


PAG. 992

CKJNR/L

⌀ 20x20 - 32x32

93°



KNUX



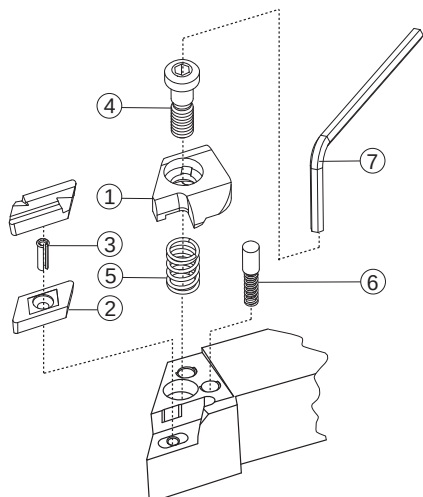
C



In figura utensile destro - Right-hand shown

																INSERTI - INSERTS PAG. 146	
ART. (mm)																	
CKJNR	2020	K	16	20	20	30	125	32	1604...R	2316	3226	4012	1614	4295	4204	5004	
CKJNR	2525	M	16	25	25	32	150	32									
CKJNR	3232	P	16	32	32	40	170	32									
CKJNL	2020	K	16	20	20	30	125	32	1604...L	2326	3236	4012	1614	4295	4204	5004	
CKJNL	2525	M	16	25	25	32	150	32									
CKJNL	3232	P	16	32	32	40	170	32									

PER UTENSILE R MONTARE INSERTO R, PER UTENSILE L MONTARE INSERTO L
 FOR R TOOL FIT INSERT R, FOR L TOOL FIT INSERT L
 FÜR DAS WERKZEUG R DIE WENDEPLATTE R EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE L
 DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE R, DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE L



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
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DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967



PAG. 992

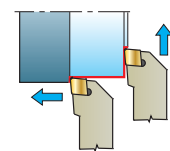
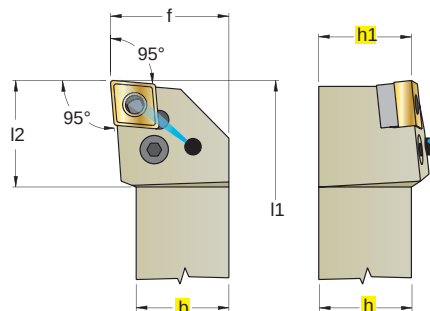
PCLNR/L..TTS

20x20 - 32x32

95°

NEW

RANGE DI
UTILIZZO
15÷80 bar
APPLICATION
RANGE
15÷80 bar



CNMA



CNMG



CNMM



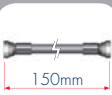
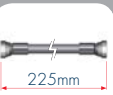
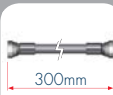
P

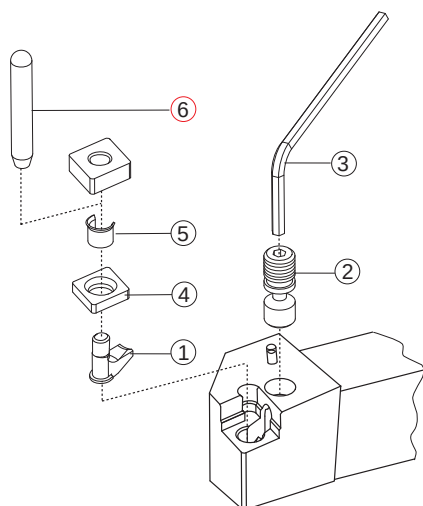


In figura utensile destro - Right-hand shown

															 INSERTI - INSERTS PAG. 143	
.G23	.G61	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82		
ART.										(mm)						
																
PCLNR/L	2020	K	12	TTS	20	20	25	125	28	1204	8012	1608	5003	3612	4112	0012
PCLNR/L	2525	M	12	TTS	25	25	32	150	33							
PCLNR/L	3225	P	12	TTS	32	25	32	170	28							
PCLNR/L	3232	P	12	TTS	32	32	40	170	30							

Accessori per connessione Utensili TTS - Accessories for tool connection - Zubeh r zur werkzeugverbindung - Accessoires pour connexion outils TTS

 150mm	• Tubo dritto raccordato <i>Fitted hose, straight</i> PAG. 965	 225mm	• Tubo dritto raccordato <i>Fitted hose, straight</i> PAG. 965	 300mm	• Tubo dritto raccordato <i>Fitted hose, straight</i> PAG. 965
 • Raccordo dritto <i>Straight fitting</i> PAG. 965	 • Riduzione <i>Adapter</i> PAG. 966	 • Raccordo 90° <i>90° Fitting</i> PAG. 966	 • B-SEAL M10 PAG. 966		



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE F R DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

VELOCIT  DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 D TAIL DE PI CES DE RECHANGE

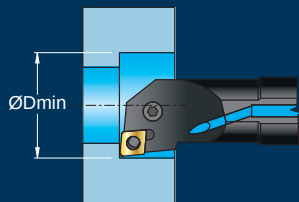
DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONN ES TECHNIQUES ET CONSEILS

PAG. 136

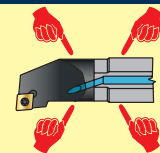
PAG. 132

PAG. 967

PAG. 992



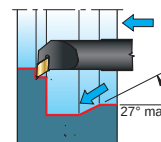
UTENSILI CON STELO IN METALLO DURO
 TOOLS WITH CARBIDE SHAFT
 WERKZEUGE MIT HM-SCHAFT
 OUTILS AVEC QUEUE EN METAL DUR



S	S	S	S	S
A..SCLCR/L Pag.61	A..SDUCR/L Pag.65	A..SDQCR/L Pag.70	A..SVOCR/L Pag.75	A..SSKCR/L Pag.79
ØDmin 8,5	ØDmin 12,5	ØDmin 16,0	ØDmin 16,0	ØDmin 20,0
CC.. 0602..	DC.. 0702..	DC.. 0702.. 11T3..	VC.. 1103.. 1604..	SC.. 09T3.. 1204..
S..SCLCR/L Pag.61	S..SDUCR/L Pag.65	E..SDQCR/L Pag.70	A..SVUCR/L Pag.76	
ØDmin 8,5	ØDmin 12,5	ØDmin 12,0	ØDmin 21,0	
CC.. 0602..	DC.. 0702..	DC.. 0702.. 11T3..	VC.. 1103.. 1604..	
A..SCLCR/L Pag.62	A..SDUCR/L Pag.66	A..SDNCR/L Pag.71	E..SVUCR/L Pag.76	
ØDmin 10,0	ØDmin 13,0	ØDmin 20,0	ØDmin 21,0	
CC.. 0602.. 09T3.. 1204..	DC.. 0702.. 11T3..	DC.. 0702.. 11T3..	VC.. 1103..	
E..SCLCR/L Pag.63	E..SDUCR/L Pag.67	A..SDXCR/L Pag.72	A..SVXCR/L Pag.77	
ØDmin 11,0	ØDmin 12,0	ØDmin 16,0	ØDmin 20,0	
CC.. 0602.. 09T3.. 1204..	DC.. 0702.. 11T3..	DC.. 0702.. 11T3..	VC.. 1103.. 1604..	
B..SCLCR/L Pag.64	B..SDUCR/L Pag.68	A..STUCR/L Pag.73	A..SVQCR/L Pag.77	
ØDmin 09,0	ØDmin 13,0	ØDmin 16,0	ØDmin 20,0	
CC.. 0602.. 09T3..	DC.. 0702.. 11T3..	TC.. 1102.. 16T3..	VC.. 1103.. 1604..	
	A..SDQCR/L Pag.69	A..STFCR/L Pag.73	A..SVQBR/L Pag.78	
	ØDmin 12,5	ØDmin 12,0	ØDmin 32,0	
	DC.. 0702..	TC.. 0902.. 1102.. 16T3..	VB.. 1604..	
	S..SDQCR/L Pag.69	E..STFCR/L Pag.74	A..SVJBR/L Pag.78	
	ØDmin 12,5	ØDmin 14,0	ØDmin 32,0	
	DC.. 0702..	TC.. 0902.. 1102.. 16T3..	VB.. 1604..	

Ø32 - Ø50

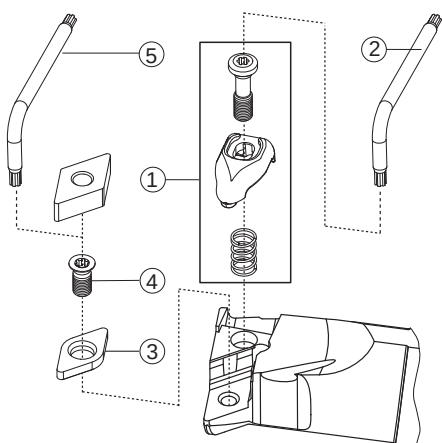
Technical drawing of a 3-flute end mill. The side view shows a cutting edge with a 93° angle, a flute depth f , and a total length l_1 . The end view shows the outer diameter $\varnothing D_{min}$ and the inner diameter $\varnothing d$ with a tolerance of g_6 . The section line is labeled SEZ.A-A.



D



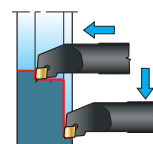
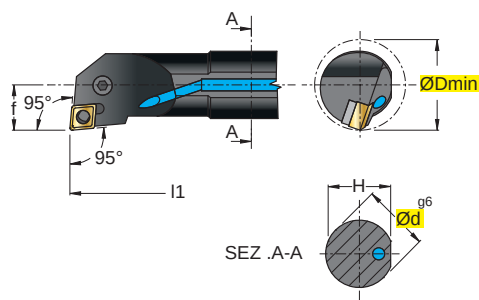
														 INSERTI - INSERTS PAG. 145	
.G23	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.G62	.G63	.G68	.G72				
ART.		(mm)							 	①	②	③	④	⑤	⑥
		ØDmin	Ød	f	H	l1	Nm								
A32S	DDUNR/L 15	40	32	22	31,0	250	3,9	1506		100-21	5415	3715	125011	5420	
A40T	DDUNR/L 15	50	40	27	38,5	300	3,9								
A50U	DDUNR/L 15	63	50	35	48,0	350	3,9								



A..PCLNR/L

Ø20 - Ø50

95°



CNMA



CNMG



CNMM

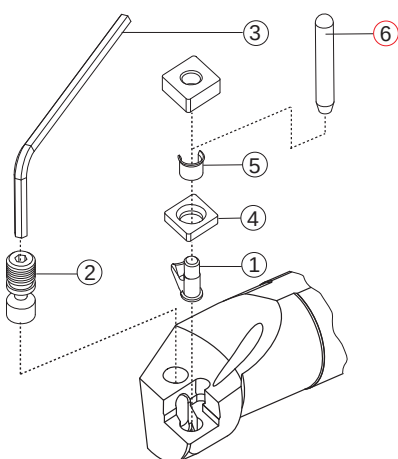


P



in figura utensile destro - right-hand shown

															 INSERTI - INSERTS PAG. 143	
.G23	.G61	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82		
ART.		(mm)							①	②	③	④	⑤	⑥		
		ØDmin	Ød	f	H	l1										
A20Q	PCLNR/L 09	25	20	13	19,0	180	0903	8010	1605	5002	—	—	—			
A25R	PCLNR/L 09	32	25	17	24,0	200	0903	8410	1604	5025	3610	4108	0009			
A25R	PCLNR/L 12	32	25	17	24,0	200	1204	8012	1648	5003	3612	4112	0012			
A32S	PCLNR/L 12	40	32	22	31,0	250	1204	8012	1608	5003	3612	4112	0012			
A40T	PCLNR/L 12	50	40	27	38,5	300										
A50U	PCLNR/L 12	63	50	35	48,0	350										
A40T	PCLNR/L 16	50	40	27	38,5	300	1606	8016	1618	5003	3616	4115	0015			
A50U	PCLNR/L 16	63	50	35	48,0	350										
A50U	PCLNR/L 19	63	50	35	48,0	350								1906	8019	1610



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

VELOCITÀ DI TAGLIO Vc
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DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967

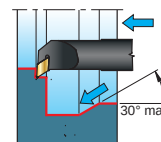
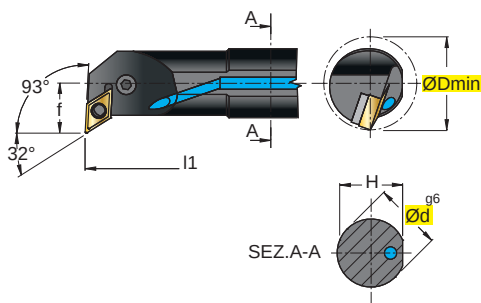


PAG. 992

A..PDUNR/L

Ø20 - Ø50

93°



DNMA



DNMG



DNMM

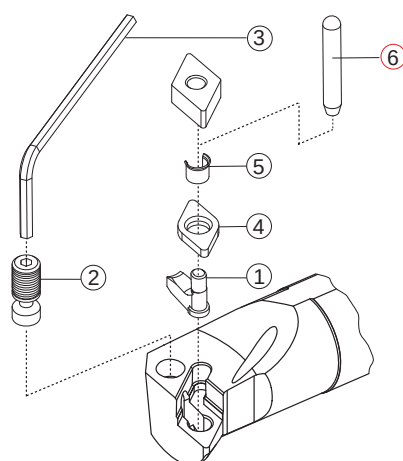


P



In figura utensile destro - Right-hand shown

														 INSERTI - INSERTS PAG. 145	
.G23	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.G62	.G63	.G68	.G72				
ART. (mm)										①	②	③	④	⑤	⑥
		ØDmin	Ød	f	H	l1									
A20Q	PDUNR/L	11	27	20	16	18,0	180	1104	8410	1604	5025	—	—	—	
A25R	PDUNR/L	11	32	25	17	23,0	200	1104	8411	1606	5025	3710	4108	0009	
A32S	PDUNR/L	11	40	32	22	31,0	250	1506	8415	1638	5003	3715	4112	0012	
A32S	PDUNR/L	15	40	32	22	31,0	250								
A40T	PDUNR/L	15	50	40	27	38,5	300								
A50U	PDUNR/L	15	63	50	35	48,0	350								



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE



PAG. 136

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE



PAG. 132

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE



PAG. 967

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

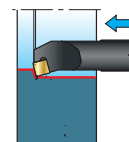
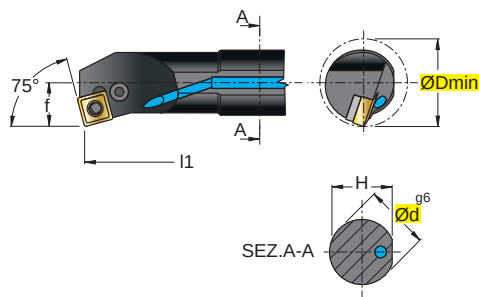


PAG. 992

A..PSKNR/L

Ø25 - Ø40

75°



SNMA



SNMG



SNMM

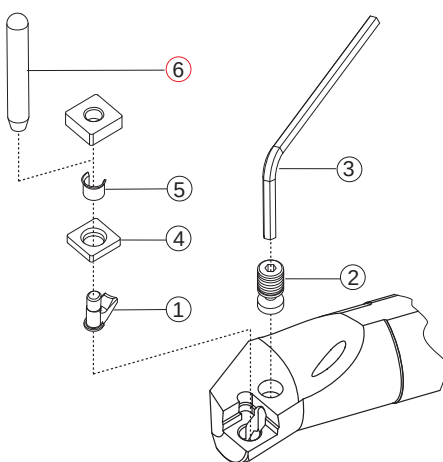


P



In figura utensile destro - Right-hand shown

														 INSERTI - INSERTS PAG. 146		
.G61	.G52	.G53	.G55	.G56	.G62	.G54	.G72	.G82								
ART. (mm)										①	②	③	④	⑤	⑥	
		ØDmin	Ød	f	H	l1										
A25R	PSKNR/L	12	32	25	17	24,0	200	1204	8012	1648	5003	3512	4112	0012		
A32S	PSKNR/L	12	40	32	22	31,0	250								0012	
A40T	PSKNR/L	12	50	40	27	38,5	300	1204	8012	1608	5003	3512	4112	0012		

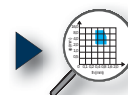


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967

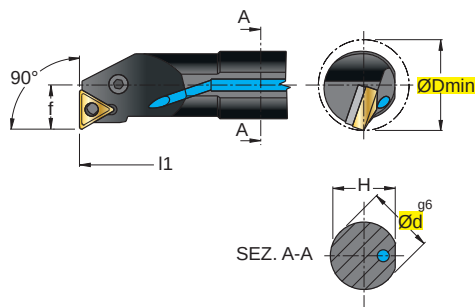


PAG. 992

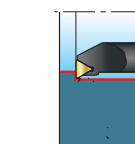
A..PTFNR/L

Ø16 - Ø40

90°



In figura utensile destro - Right-hand shown



TNMA



TNMG



TNMM

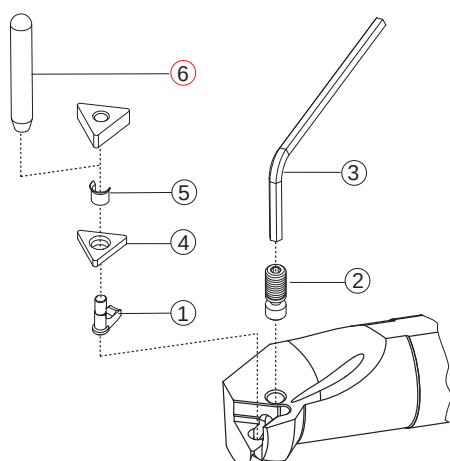


P



INSERTI - INSERTS
PAG. 147

ART.	(mm)	ØDmin	Ød	f	H	l1		1	2	3	4	5	6
A16M PTFNR/L 11		21	16	11	15,25	150	1103	8008	1603	5002	—	—	—
A20Q PTFNR/L 11		25	20	13	19,0	180	1604	8009	1606	5025	3416	4109	0009
A25R PTFNR/L 16		32	25	17	24,0	200							
A32S PTFNR/L 16		40	32	22	31,0	250							
A40T PTFNR/L 22		50	40	27	38,5	300	2204	8012	1608	5003	3422	4112	0012



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
Vc. CUTTING SPEED
Vc. SCHNITTGESCHWINDIGKEIT
Vc. VITESSE DE COUPE

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SPARE PARTS DETAILS
DETAILS ZU DEN ERSATZTEILEN
DÉTAIL DE PIÉCES DE RECHANGE

DATI TECNICI E CONSIGLI
TECHNICAL DATA AND SUGGESTIONS
TECHNISCHE DATEN UND EMPFEHLUNGEN
DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967

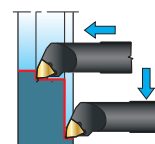
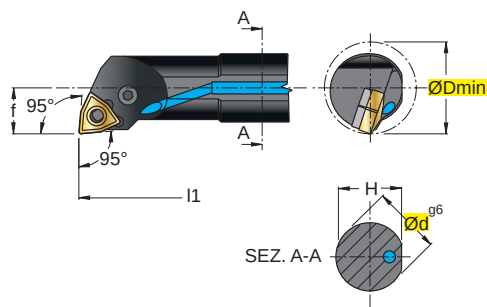


PAG. 992

A..PWLNR/L

Ø16 - Ø40

95°



WNMA



WNMG



WNMM

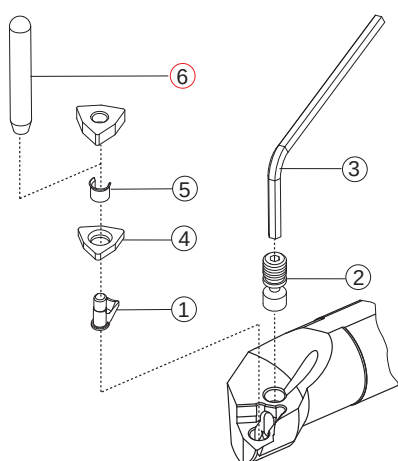


P



In figura utensile destro - Right-hand shown

										INSERTI - INSERTS PAG. 148					
.G23	.G61	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63						
ART. (mm)										1	2	3	4	5	6
A16M	PWLNR/L	06	21	16	11	15,25	150		0604	8216	1605	5002	—	—	—
A20Q	PWLNR/L	06	25	20	13	19,0	180		0604	8009	1606	5025	3306	4109	0009
A25R	PWLNR/L	06	32	25	17	24,0	200		0604	8012	1648	5003	3308M	4112	0012
A32S	PWLNR/L	06	40	32	22	31,0	250		0804	8012	1608	5003	3308M	4112	0012
A25R	PWLNR/L	08	32	25	17	24,0	200		0804	8012	1648	5003	3308M	4112	0012
A32S	PWLNR/L	08	40	32	22	31,0	250		0804	8012	1608	5003	3308M	4112	0012
A40T	PWLNR/L	08	50	40	27	38,5	300								



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
Vc. CUTTING SPEED
Vc. SCHNITTGESCHWINDIGKEIT
Vc. VITESSE DE COUPE

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SPARE PARTS DETAILS
DETAILS ZU DEN ERSATZTEILEN
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DATI TECNICI E CONSIGLI
TECHNICAL DATA AND SUGGESTIONS
TECHNISCHE DATEN UND EMPFEHLUNGEN
DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967

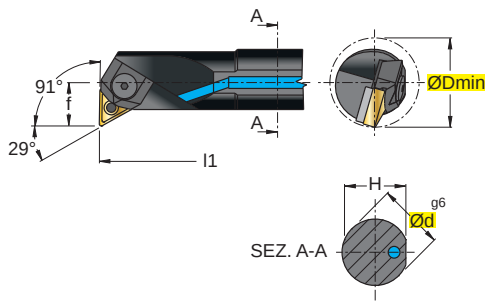


PAG. 992

A...MTFNR/L

Ø25 - Ø50

91°



27°
max

TNMA

TNMG

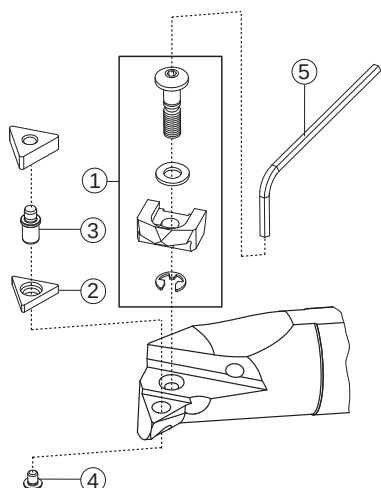
TNMM

M

in figura utensile destro - right-hand shown

INSERTI - INSERTS
PAG. 147

														 INSERTI - INSERTS PAG. 147	
.G61	.B32	.G52	.G53	.G55	.G56	.G62	.G63								
ART. (mm)															
A25R	MTFNR/L	16	32	25	17	24,0	200	1604	100-50	—	4187	100-86	5025		
A32S	MTFNR/L	16	40	32	22	31,0	250	1604	100-50	3216	4188	100-86	5025		
A40T	MTFNR/L	16	50	40	27	38,5	300								
A50U	MTFNR/L	16	63	50	35	48,0	350								
A40T	MTFNR/L	22	50	40	27	38,5	300	2204	100-51	3222	4190	100-87	5003		
A50U	MTFNR/L	22	63	50	35	48,0	350								



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
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DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967

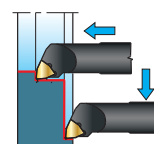
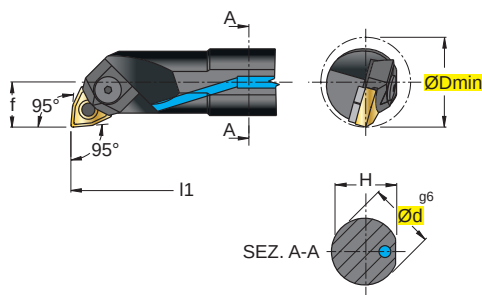


PAG. 992

A..MWLNR/L..N

Ø20 - Ø50

95°



WNMA



WNMG



WNMM

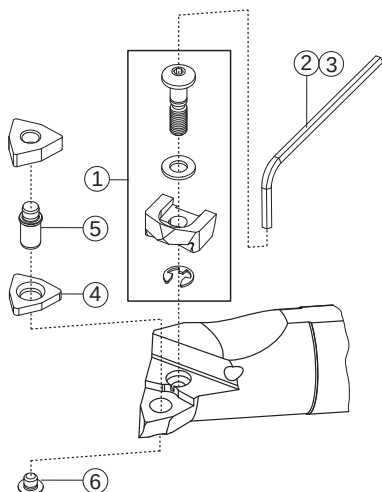


M



In figura utensile destro - Right-hand shown

																 INSERTI - INSERTS PAG. 148	
.G23	.G61	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63								
ART.		(mm)								①	②	③	④	⑤	⑥		
		ØDmin	Ød	f	H	l1											
A20Q	MWLNR/L 06	25	20	13	19,0	180	0604	100-53	5510	—	—	4184	—				
A25R	MWLNR/L 06	32	25	17	24,0	200	0604	100-53	5510	—	3306	4188	—				
A32S	MWLNR/L 06	40	32	22	31,0	250											
A25R	MWLNR/L 08N	32	25	17	24,0	200	0804	100-52	—	5025	3308M	4185	100-87				
A32S	MWLNR/L 08N	40	32	22	31,0	250	0804	100-52	—	5025	3308M	4190	100-87				
A40T	MWLNR/L 08N	50	40	27	38,5	300											
 S50U	MWLNR/L 08N	63	50	35	47,0	350	0804	100-52	—	5025	3308M	4190	100-87				
 = SENZA FORO DI REFRIGERAZIONE / WITHOUT COOLANT BORE / OHNE KUEHLMITTELBOHRUNG / SANS TROUS DE RÉFRIGÉRATION																	



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967

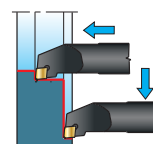
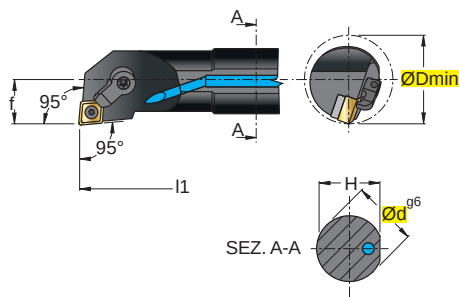


PAG. 992

A..MCLNR/L

Ø25 - Ø50

95°



CNMA



CNMG



CNMM



M



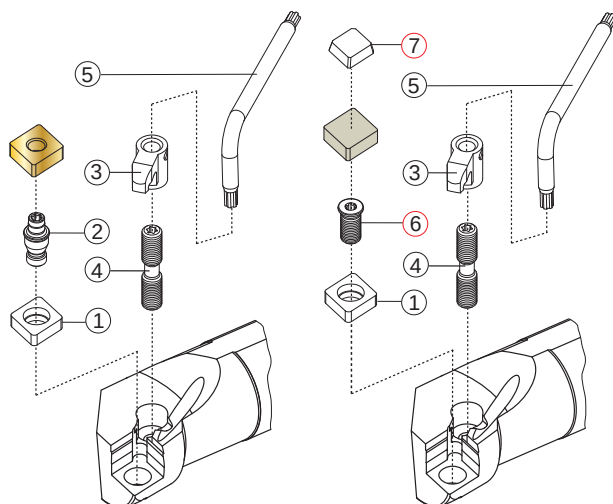
In figura utensile destro - Right-hand shown

															 INSERTI - INSERTS PAG. 143	
.G23	.G61	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82		
ART. (mm)										①	②	③	④	⑤	⑥	⑦
		ØDmin	Ød	f	H	l1										
A25R	MCLNR/L 12	32	25	17	24,0	200	1204	—		KLM 44	CKM 21	STCM 20	5415	—	—	
A32S	MCLNR/L 12	40	32	22	31,0	250	1204	KCN 433		KLM 46	CKM 21	STCM 20	5415	KMS 4	RCN1225	
A40T	MCLNR/L 12	50	40	27	38,5	300	1606	KCN 533		KLM 58	CKM 21	STCM 20	5415	KMS 5	—	
A50U	MCLNR/L 12	63	50	35	48,0	350										
A40T	MCLNR/L 16	50	40	27	38,5	300										
A50U	MCLNR/L 16	63	50	35	48,0	350										
A50U	MCLNR/L 19	63	50	35	48,0	350	1906	KCN 633	KLM 68	CKM 12	STCM 4	5425	KMS 6	—		

ART.	DIMENSIONI MEASURES ABMESSUNGEN DIMENSIONS	INSERTO INSERT WENDEPLATTEN PLAQUETTES
RCN 1225	 L 10,7 H 2,5 R 2,3	 CN.. 1204..

- VITE DI FISSAGGIO DEL SOTTOPLACCHETTA PER INSERTI SENZA FORO
 - SHIM CLAMPING SCREW FOR INSERTS WITHOUT BORE
 - UNTERLEGPLATTENBEFESTIGUNGSSCHRAUBE FÜR WENDEPLATTEN OHNE BOHRUNG
 - VIS DE FIXAGE DE SOUS-PLAQUETTE POUR PLAQUETTES SANS TROU

- ROMPIRUCIOLO PER INSERTI CERAMICI E SENZA FORO
 - CHIP BREAKER FOR CERAMIC INSERTS AND FOR INSERTS WITHOUT BORE
 - SPANBRECHER FÜR KERAMISCHE WENDEPLATTEN UND FÜR WENDEPLATTEN OHNE KUEHLMITTELBOHRUNG
 - BRISE-CPEAUX POUR PLAQUETTES CERAMIQUES ET POUR PLAQUETTES SANS TROU



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



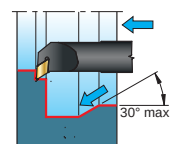
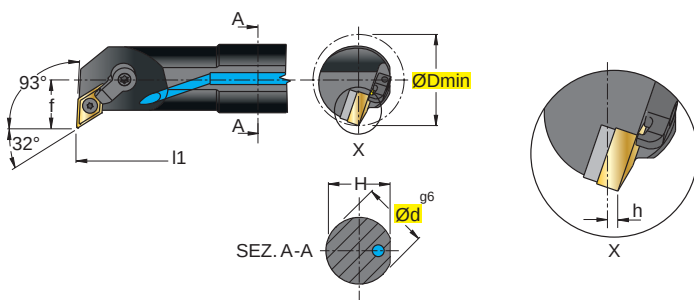
PAG. 967



PAG. 992

Ø25 - Ø40

93°



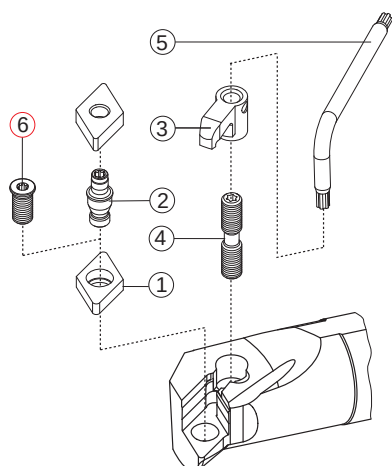
A diagram showing a cross-section of a wall. The wall is represented by a grey hatched area. In the center, there is a vertical channel or cavity, colored yellow. The channel is wider at the top and bottom and tapers slightly towards the middle.

M



														 INSERTI - INSERTS PAG. 145	
.G23	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.G62	.G63	.G68	.G72				
ART.		(mm)								①	②	③	④	⑤	⑥
		ØDmin	Ød	f	H	l1	h								
A25R	MDUNR/L	15	32	25	17	24,0	200	1,5	1506	KDN433	KLM 46	CKM 22	STCM20	5415	KMS 4
A32S	MDUNR/L	15	40	32	22	31,0	250	1,5	1506	KDN433	KLM 46L	CKM 22	STCM20	5415	KMS 4
A40T	MDUNR/L	15	50	40	27	38,5	300	0							

-  - VITE DI FISSAGGIO DEL SOTTOPLACCHETTA PER INSERTI SENZA FORO
-  - SHIM CLAMPING SCREW FOR INSERTS WITHOUT BORE
-  - UNTERLEGPLATTENBEFESTIGUNGSSCHRAUBE FÜR WENDEPLATTEN OHNE BOHRUNG
- - VIS DE FIXAGE DE SOUS-PLAQUETTE POUR PLAQUETTES SANS TROU

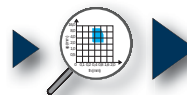


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
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 DÉTAIL DE PIÈCES DE RECHANGE

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



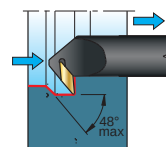
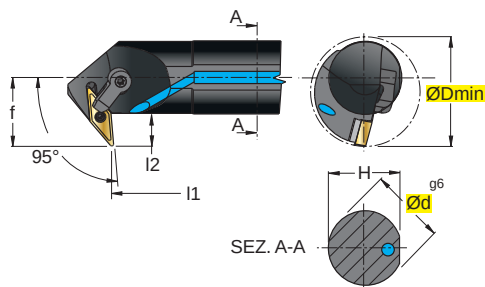
PAG. 967



PAG. 992

A..MVZNR/L

Ø32 - Ø40



VNMG



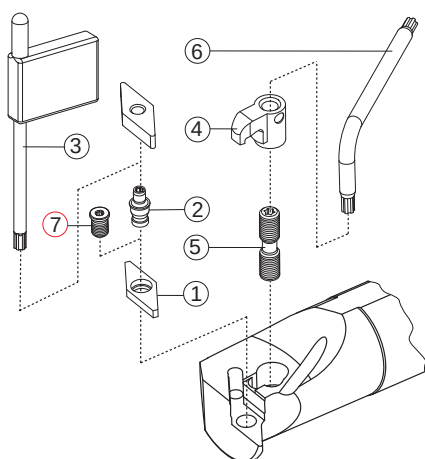
M



In figura utensile destro - Right-hand shown

NEW																	 INSERTI - INSERTS PAG. 147	
																		
.G23	.G42	.G52	.G53	.G55														
ART.					(mm)						1 	2 	3 	4 	5 	6 	7 	
A32S	MVZNR/L	16	48	32	30	31,0	250	14	1604	KVN323	KLM34L	5508	CKM22	STCM25	5415	KMS3		
A40T	MVZNR/L	16	57	40	35	38,5	300	15										
										 - VITE DI FISSAGGIO DEL SOTTOPLACCHETTA PER INSERTI SENZA FORO  - SHIM CLAMPING SCREW FOR INSERTS WITHOUT BORE  - UNTERLEGPLATTENBEFESTIGUNGSSCHRAUBE FÜR WENDEPLATTEN OHNE BOHRUNG  - VIS DE FIXAGE DE SOUS-PLAQUETTE POUR PLAQUETTES SANS TROU								

- VITE DI FISSAGGIO DEL SOTTOPLACCHETTA PER INSERTI SENZA FORO
 - SHIM CLAMPING SCREW FOR INSERTS WITHOUT BORE
 - UNTERLEGPLATTENBEFESTIGUNGSSCHRAUBE FÜR WENDEPLATTEN OHNE BOHRUNG
 - VIS DE FIXAGE DE SOUS-PLAQUETTE POUR PLAQUETTES SANS TROU

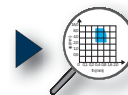


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

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 DETAILS ZU DEN ERSATZTEILEN
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DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



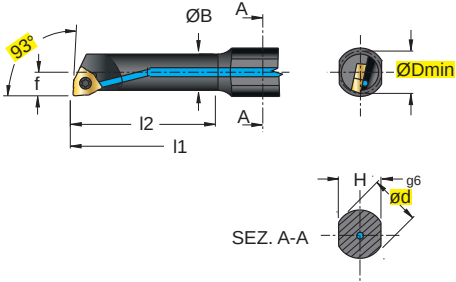
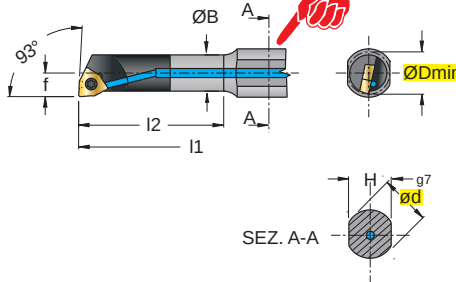
PAG. 132

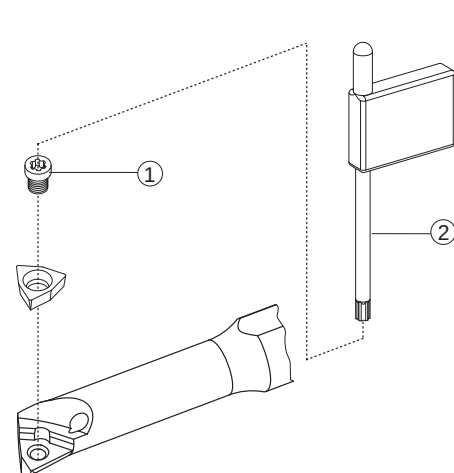


PAG. 967



PAG. 992

A..SWUCR/L $\varnothing 8$										E..SWUCR/L $\varnothing 5 - \varnothing 8$									
93°										93°									
																			
WC.T										WC.T									
S										S									
In figura utensile destro - Right-hand shown										In figura utensile destro - Right-hand shown									
  																			
.B22 .G39 .B56										INSERTI - INSERTS PAG. 154									
ART. (mm)										 									
																			
A0508H SWUCR/L 02 $\varnothing D_{min}$ 5,8 $\varnothing d$ 8 $\varnothing B$ 5 f 2,9 H 7 l1 100 l2 16 0,5+0,6 Nm 0201 12203 5506																			
A0608H SWUCR/L 02 $\varnothing D_{min}$ 7,8 $\varnothing d$ 8 $\varnothing B$ 6 f 3,9 H 7 l1 100 l2 24 0,5+0,6 Nm 0201 12203 5506																			
 PER UTENSILE R MONTARE INSERTO WCGT..L.B22 , PER UTENSILE L MONTARE INSERTO WCGT..R.B22 FOR R TOOL FIT INSERT WCGT..L.B22 , FOR L TOOL FIT INSERT WCGT..R.B22 FÜR DAS WERKZEUG R DIE WENDEPLATTE WCGT..L.B22 EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE WCGT..R.B22 DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE WCGT..L.B22 , DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE WCGT..R.B22																			
 PER UTENSILE R MONTARE INSERTO WCGT..L.B22 , PER UTENSILE L MONTARE INSERTO WCGT..R.B22 FOR R TOOL FIT INSERT WCGT..L.B22 , FOR L TOOL FIT INSERT WCGT..R.B22 FÜR DAS WERKZEUG R DIE WENDEPLATTE WCGT..L.B22 EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE WCGT..R.B22 DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE WCGT..L.B22 , DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE WCGT..R.B22																			
 UTENSILI CON STELO IN METALLO DURO TOOLS WITH CARBIDE SHAFT WERKZEUGE MIT HM-SCHAFT OUTILS AVEC QUEUE EN METAL DUR																			



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

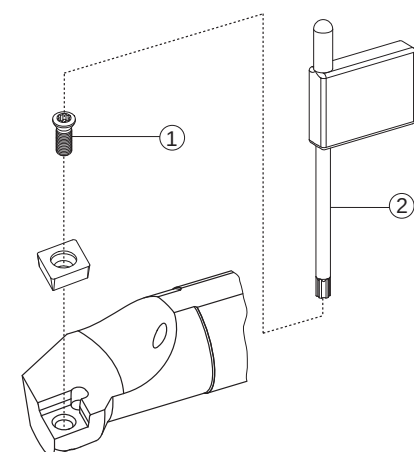

 PAG. 136


 PAG. 132


 PAG. 967


 PAG. 992

A..SCUPR/L Ø8 - Ø16										E..SCUPR/L Ø8 - Ø16									
In figura utensile destro - Right-hand shown										In figura utensile destro - Right-hand shown									
.D34 .D42 .E42										INSERTI - INSERTS PAG. 150									
ART. (mm)																			
ØDmin Ød ØB f H l1 l2 Nm										1 2									
A0608H SCUPR/L 05				8,0	8	6	4,5	7	100	20	0,9+1,0	05T1	12224	5507					
A0810J SCUPR/L 05				10,5	10	8	6,0	9	110	26	0,9+1,0								
A1012K SCUPR/L 05				12,5	12	10	7,0	11	125	32	0,9+1,0								
A1216M SCUPR/L 05				15,5	16	12	9,0	15	150	40	0,9+1,0								
E0608H SCUPR/L 05				8	8	6	4,5	7	100	30	0,9+1,0	05T1	12224	5507					
E0810J SCUPR/L 05				11	10	8	6,0	9	110	36	0,9+1,0								
E1012K SCUPR/L 05				13	12	10	7,0	11	125	44	0,9+1,0								
E1216M SCUPR/L 05				16	16	12	9,0	15	150	55	0,9+1,0								
UTENSILI CON STELO IN METALLO DURO TOOLS WITH CARBIDE SHAFT WERKZEUGE MIT HM-SCHAFT OUTILS AVEC QUEUE EN METAL DUR																			



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

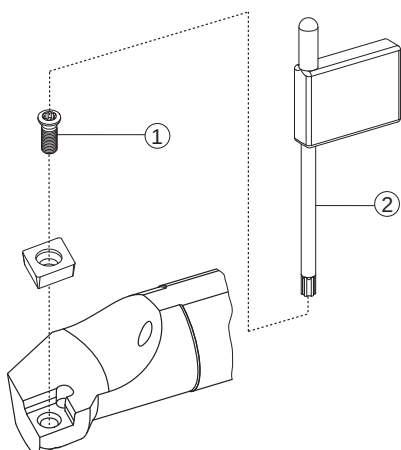


PAG. 967



PAG. 992

A..SCLCR/L										S..SCLCR/L									
Ø8 - Ø16										Ø8 - Ø16									
95°										95°									
In figura utensile destro - Right-hand shown										In figura utensile destro - Right-hand shown									
ART. (mm)										1 2									
A0608H	SCLCR/L	06	8,5	8	6	4	7	100	20	1,0+1,2	0602	12254P	5507P						
A0810J	SCLCR/L	06	10,5	10	8	6	9	110	26	1,0+1,2									
A1012K	SCLCR/L	06	12,5	12	10	7	11	125	32	1,0+1,2									
A1216M	SCLCR/L	06	15,5	16	12	9	15	150	40	1,0+1,2									
PER UTENSILE R MONTARE INSERTO CCET..L.B22 , PER UTENSILE L MONTARE INSERTO CCET..R.B22 FOR R TOOL FIT INSERT CCET..L.B22, FOR L TOOL FIT INSERT CCET..R.B22 FÜR DAS WERKZEUG R DIE WENDEPLATTE CCET..L.B22 EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE CCET..R.B22 DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE CCET..L.B22, DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE CCET..R.B22										PER UTENSILE R MONTARE INSERTO CCET..L.B22 , PER UTENSILE L MONTARE INSERTO CCET..R.B22 FOR R TOOL FIT INSERT CCET..L.B22, FOR L TOOL FIT INSERT CCET..R.B22 FÜR DAS WERKZEUG R DIE WENDEPLATTE CCET..L.B22 EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE CCET..R.B22 DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE CCET..L.B22, DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE CCET..R.B22									
PER UTENSILE R MONTARE INSERTO CCET..L.B22 , PER UTENSILE L MONTARE INSERTO CCET..R.B22 FOR R TOOL FIT INSERT CCET..L.B22, FOR L TOOL FIT INSERT CCET..R.B22 FÜR DAS WERKZEUG R DIE WENDEPLATTE CCET..L.B22 EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE CCET..R.B22 DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE CCET..L.B22, DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE CCET..R.B22										PER UTENSILE R MONTARE INSERTO CCET..L.B22 , PER UTENSILE L MONTARE INSERTO CCET..R.B22 FOR R TOOL FIT INSERT CCET..L.B22, FOR L TOOL FIT INSERT CCET..R.B22 FÜR DAS WERKZEUG R DIE WENDEPLATTE CCET..L.B22 EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE CCET..R.B22 DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE CCET..L.B22, DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE CCET..R.B22									
SENZA FORO DI ADDUZIONE REFRIGERANTE WITHOUT COOLANT FEED OHNE KÜLMITTELZUFUHR SANS ABDUCTION DU RÉFRIGÉRANTE										SENZA FORO DI ADDUZIONE REFRIGERANTE WITHOUT COOLANT FEED OHNE KÜLMITTELZUFUHR SANS ABDUCTION DU RÉFRIGÉRANTE									



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

PAG. 136

PAG. 132

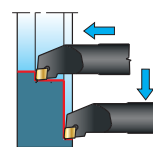
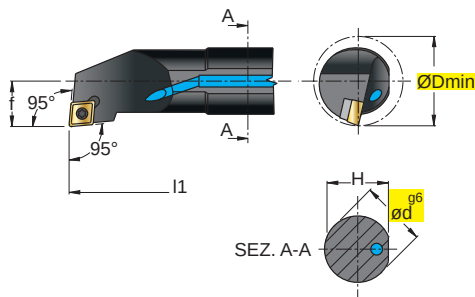
PAG. 967

PAG. 992

A..SCLCR/L

Ø8 - Ø40

95°



CC.T



CC.W



S



In figura utensile destro - Right-hand shown

ART.								INSERTI - INSERTS PAG. 149				
(mm)								1	2	3	4	
ØDmin	Ød	f	H	l1	Nm							
.B22	.G13	.B33	.G57P	.Z57	.G39	.G42	.G52					
A08F	SCLCR/L 06	10	8	5	7,60	80	1,0+1,2	0602	—	—	12254P	5507P
A10H	SCLCR/L 06	12	10	7	9,50	100	1,1+1,3	0602	—	—	12256P	5508P
A12K	SCLCR/L 06	16	12	9	11,50	125	1,1+1,3					
A16M	SCLCR/L 09	20	16	11	15,25	150	3,8+5,0	09T3	—	—	12409P	5515P
A20Q	SCLCR/L 09	25	20	13	19,00	180	3,8+5,0					
A25R	SCLCR/L 09	32	25	17	24,00	200	3,8+5,0	09T3	—	—	1240P	5515P
A25R	SCLCR/L 12	32	25	17	24,00	200	4,0+5,0	1204	—	—	124510	5520
A32S	SCLCR/L 12	40	32	22	31,00	250	4,0+5,0	1204	3611	BCL15	124513P	5520P
A40T	SCLCR/L 12	50	40	27	38,50	300	4,0+5,0					

PER UTENSILE R MONTARE INSERTO CCET..L.B22, PER UTENSILE L MONTARE INSERTO CCET..R.B22
FOR R TOOL FIT INSERT CCET..L.B22, FOR L TOOL FIT INSERT CCET..R.B22
FÜR DAS WERKZEUG R DIE WENDEPLATTE CCET..L.B22 EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE CCET..R.B22
DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE CCET..L.B22, DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE CCET..R.B22

CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
Vc. CUTTING SPEED
Vc. SCHNITTGESCHWINDIGKEIT
Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
SPARE PARTS DETAILS
DETAILS ZU DEN ERSATZTEILEN
DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
TECHNICAL DATA AND SUGGESTIONS
TECHNISCHE DATEN UND EMPFEHLUNGEN
DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



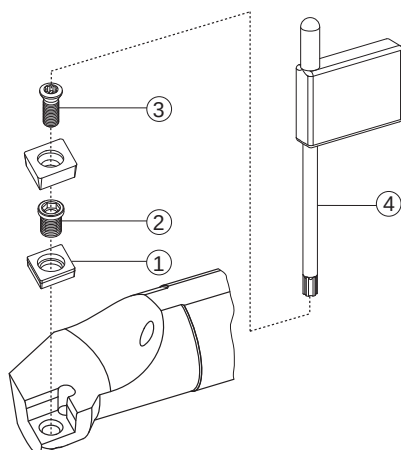
PAG. 132



PAG. 967



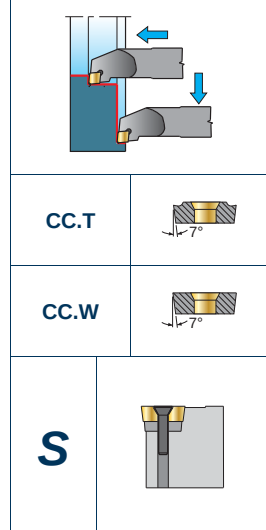
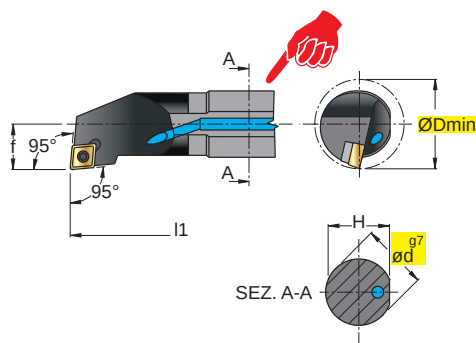
PAG. 992



E..SCLCR/L

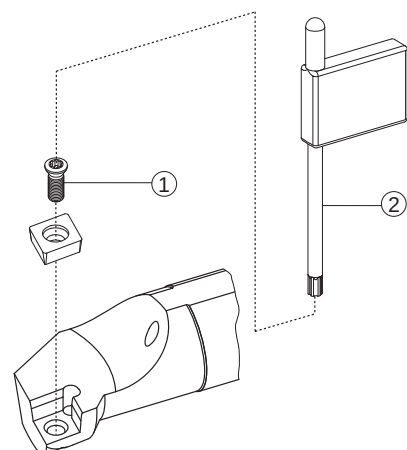
Ø8 - Ø25

95°



In figura utensile destro - Right-hand shown

														
.B22	.G13	.B33	.G57P	.Z57	.G39	.G42	.G52							INSERTI - INSERTS PAG. 149
ART.		(mm)								①	②			
		ØDmin	Ød	f	H	l1	Nm							
E08K	SCLCR/L 06	11	8	5	7,60	125	1,0÷1,2	0602	12254P	5507P				
E10K	SCLCR/L 06	13	10	7	9,50	125	1,1÷1,3	0602	12256P	5508P				
E12M	SCLCR/L 06	16	12	9	11,50	150	1,1÷1,3							
E16R	SCLCR/L 09	20	16	11	15,25	200	3,8÷5,0	09T3	12409P	5515P				
E20S	SCLCR/L 09	25	20	13	19,00	250	3,8÷5,0							
E25T	SCLCR/L 09	32	25	17	24,00	300	3,8÷5,0	09T3	1240P	5515P				
 UTENSILI CON STELO IN METALLO DURO TOOLS WITH CARBIDE SHAFT WERKZEUGE MIT HM-SCHAFT OUTILS AVEC QUEUE EN METAL DUR 														
 PER UTENSILE R MONTARE INSERTO CCET..L.B22 , PER UTENSILE L MONTARE INSERTO CCET..R.B22 FOR R TOOL FIT INSERT CCET..L.B22, FOR L TOOL FIT INSERT CCET..R.B22 FÜR DAS WERKZEUG R DIE WENDEPLATTE CCET..L.B22 EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE CCET..R.B22 DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE CCET..L.B22, DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE CCET..R.B22														



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE



VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE



DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DÉTAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÉCES DE RECHANGE

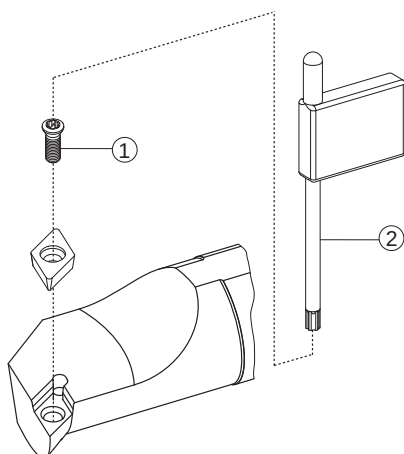


DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



A..SDUCR/L							S..SDUCR/L						
Ø10 - Ø16							Ø10 - Ø16						
93°							93°						
in figura utensile destro - right-hand shown							In figura utensile destro - Right-hand shown						
ART.							INSERTI - INSERTS PAG. 150						
(mm)							1 2						
ØDmin							12254P 5507P						
Ød													
f													
a													
H													
l1													
l2													
Nm													
0702													
A0810H SDUCR/L 07							12254P 5507P						
A1012K SDUCR/L 07													
A1216M SDUCR/L 07													
</													

SENZA FORO DI ADDUZIONE REFRIGERANTE
 WITHOUT COOLANT FEED
 OHNE KÜLMITTELZUFUHR
 SANS ABDUCTION DU RÉFRIGÉRANTE



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



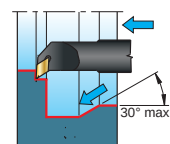
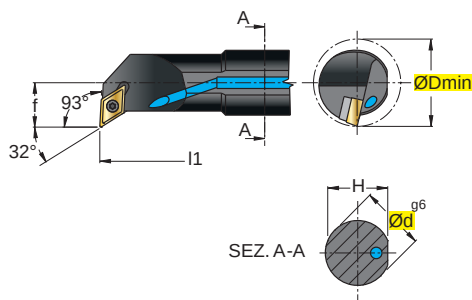
PAG. 967



PAG. 992

Ø10 - Ø40

93°



DC.T



DC.W

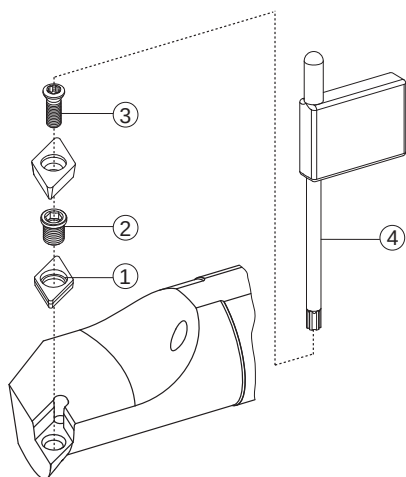


S



INSERTI - INSERTS
PAG. 150

																 INSERTI - INSERTS PAG. 150
.G13	.B53	.G57P	.Z57	.G39	.G42	.G52										
ART.		(mm)						 Nm		①	②	②	④			
		ØDmin	Ød	f	H	l1										
A10H	SDUCR/L 07	13	10	8	9,50	100	1,1+1,3	0702	—	—	12256P	5508P				
A12K	SDUCR/L 07	16	12	9	11,50	125	1,1+1,3									
A16M	SDUCR/L 07	20	16	11	15,25	150	1,1+1,3									
A20Q	SDUCR/L 07	25	20	13	19,00	180	1,1+1,3									
A20Q	SDUCR/L 11	25	20	13	19,00	180	3,8+5,0	11T3	—	—	12409P	5515P				
A25R	SDUCR/L 11	32	25	17	24,00	200	3,8+5,0	11T3	—	—	1240P	5515P				
A32S	SDUCR/L 11	40	32	22	31,00	250	3,0+3,5	11T3	3711	BCL7	123511P	5515P				
A40T	SDUCR/L 11	49	40	27	38,50	300	3,0+3,5									



PAG. 136



PAG. 132



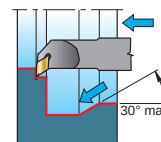
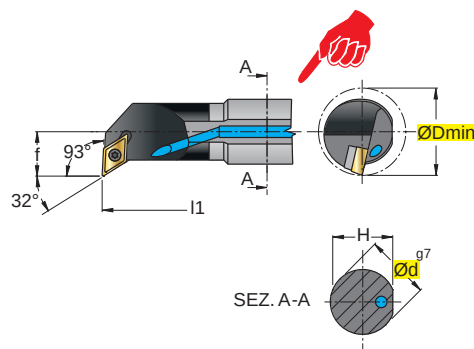
PAG. 967



PAG. 992

Ø10 - Ø20

93°



A cross-sectional diagram of a dovetail joint. It shows a wooden tenon (yellow) with a dovetail-shaped hole (grey) in a wooden board. The angle of the dovetail is labeled as 7°.

A cross-sectional diagram of a dovetail joint. A yellow rectangular pin is inserted into a gray dovetail-shaped hole. The angle of the hole's sides is indicated as 7° with a dimension line and an arrow pointing to the angle.

S



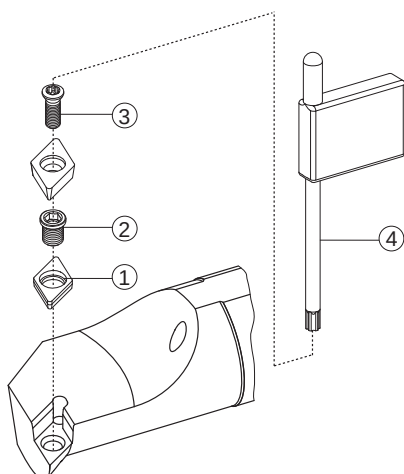
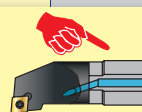
in figura utensile destro - right-hand shown



INSERTI - INSERTS
PAG. 150

ART.	(mm)			ØDmin	Ød	f	H	l1	Nm		1	2	2	4	
E10K	SDUCR/L 07	12	10	7	9,50	125	1,1+1,3	0702	—	—	12256P	5508P			
E12M	SDUCR/L 07	16	12	9	11,50	150	1,1+1,3								
E16R	SDUCR/L 07	20	16	11	15,25	200	1,1+1,3								
E20S	SDUCR/L 11	25	20	13	19,00	250	3,8÷5,0	11T3	—	—	12409P	5515P			

	UTENSILI CON STELO IN METALLO DURO
	TOOLS WITH CARBIDE SHAFT
	WERKZEUGE MIT HM-SCHAFT
	OUTILS AVEC QUEUE EN METAL DUR



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

PAG. 136

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

PAG. 132

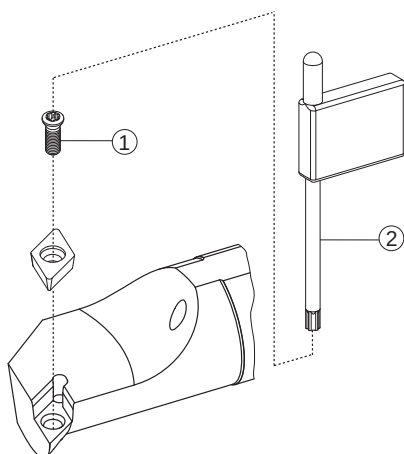
 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

PAG. 967

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

PAG. 992

A..SDQCR/L $\varnothing 10 - \varnothing 16$							S..SDQCR/L $\varnothing 10 - \varnothing 16$						
107,5°							107,5°						
In figura utensile destro - Right-hand shown							In figura utensile destro - Right-hand shown						
  							  						
      							 INSERTI - INSERTS PAG. 150						
ART. (mm)							  1 2						
A0810H	SDQCR/L	07	12,5	10	7	3	9	100	22	1,0+1,2	0702	12254P	5507P
A1012K	SDQCR/L	07	15,5	12	9	4	11	125	28	1,0+1,2			
A1216M	SDQCR/L	07	19,5	16	11	5	15	150	36	1,0+1,2			
S0810H	SDQCR/L	07	12,5	10	7	3	9	100	22	1,0+1,2	0702	12254P	5507P
S1012K	SDQCR/L	07	15,5	12	9	4	11	125	28	1,0+1,2			
S1216M	SDQCR/L	07	19,5	16	11	5	15	150	36	1,0+1,2			
 SENZA FORO DI ADDUZIONE REFRIGERANTE  WITHOUT COOLANT FEED  OHNE KÜLMITTELZUFUHR  SANS ABDUCTION DU RÉFRIGÉRANTE													



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



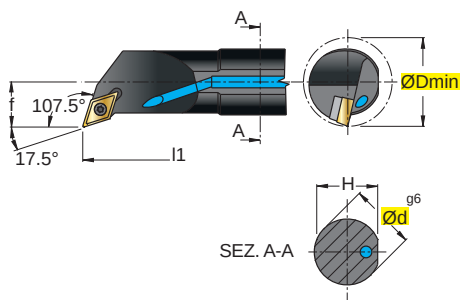
PAG. 967



PAG. 992

Ø12 - Ø32

107,5°



A diagram showing a probe tip with a 15° max angle. The tip is shown in cross-section, with a blue arrow indicating the direction of the probe's movement. The angle is labeled as 15° max.



DC.T



DC.W



S



Ø10 - Ø20

107,5°

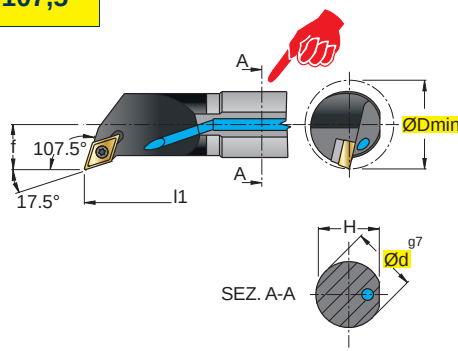


Diagram illustrating a 15° max chamfer on a part, with a blue arrow indicating the direction of force or movement.



DC.7



DC.V

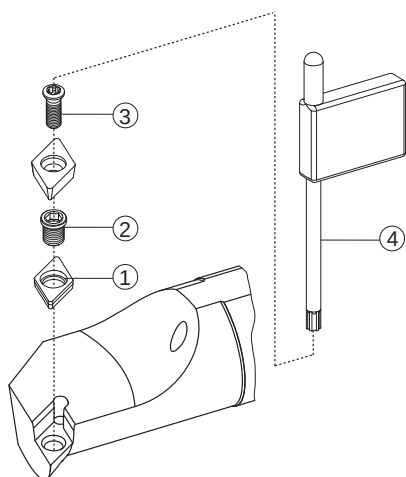
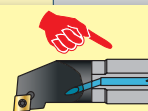
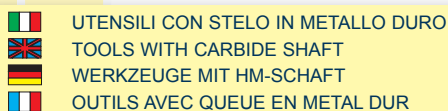
S



INSERTI - INSERTS
PAG. 150

[illegible]

E10K	SDQCR/L	07	12	10	7	9	125	1,1+1,3	0702	—	—	12256P	5508P	
E12M	SDQCR/L	07	15	12	9	11	150	1,1+1,3						
E16R	SDQCR/L	07	19	16	11	15	200	1,1+1,3						
E20S	SDQCR/L	11	23	20	13	18	250	3,8+5,0	11T3	—	—	12409P	5515P	



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

PAG. 136

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

PAG. 132

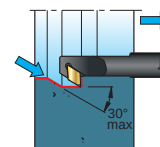
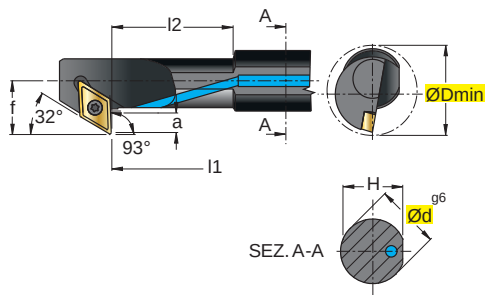
 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

PAG. 967

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

PAG. 992

Ø12 - Ø25



A cross-sectional diagram of a dovetail joint. It shows a central yellow rectangular piece (the pin) fitting into a gray dovetail-shaped hole (the tail) in a block. The angle of the dovetail's sides is indicated as 7° with a dimension line and an arrow.

A cross-sectional diagram of a dovetail joint. It shows a central yellow rectangular piece (the pin) fitting into a wider yellow rectangular piece (the tail). The joint is secured by two gray rectangular pieces (the cheeks) on either side. A dimension line with arrows indicates the angle of the dovetail's cheeks, labeled as 7° .

S

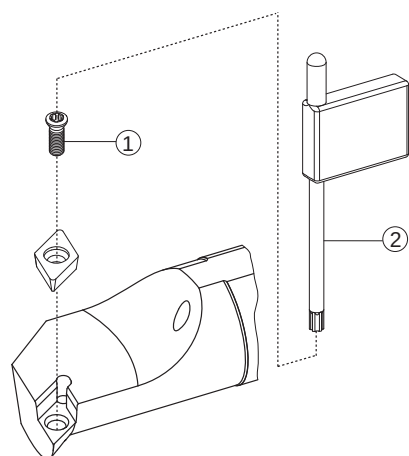


													
.G13	.B53	.G57P	.Z57	.G39	.G42	.G52							



INSERTI - INSERTS
PAG. 150

ART.												①	②	●	●
	(mm)											Nm			
	ØDmin	Ød	f	a	H	l1	l2								
A12K SDXCR/L 07	16	12	11,0	5,0	11,50	125	25	1,1+1,3	0702	12256P	5508P				
A16M SDXCR/L 07	20	16	13,0	5,0	15,25	150	35	1,1+1,3							
A20Q SDXCR/L 11	25	20	16,5	6,5	19,00	180	40	3,8+5,0	11T3	12409P	5515P				
A25R SDXCR/L 11	32	25	19,0	6,5	24,00	200	50	3,8+5,0							



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 DATI TECNICI E CONSIGLI
 **TECHNICAL DATA AND SUGGESTIONS**
 **TECHNISCHE DATEN UND EMPFEHLUNGEN**
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



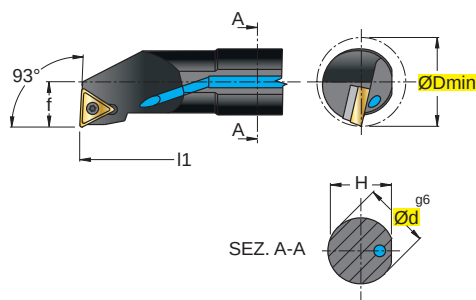
PAG. 967



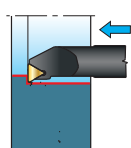
PAG. 992

Ø12 - Ø32

93°



In figura utensile destro - Right-hand shown



TC.T



TC.W

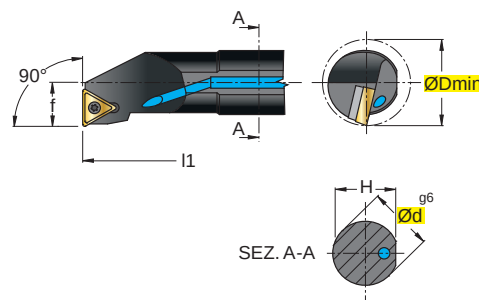


S

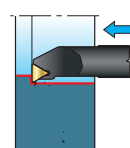


Ø10 - Ø40

90°



In figura utensile destro - Right-hand shown



TC.T



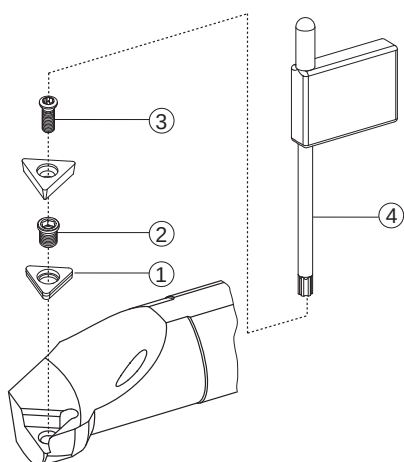
TC.W



S



INSERTI - INSERTS
PAG. 152

[illegible]

 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

PAG. 136

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

PAG. 132

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

PAG. 967

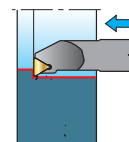
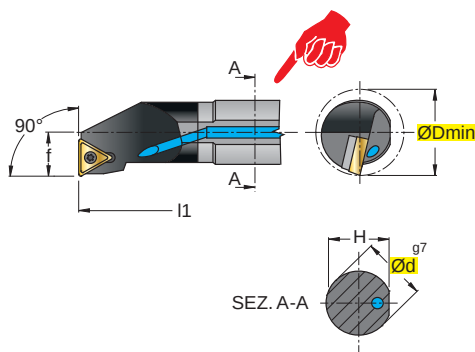
 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

PAG. 992

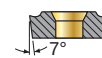
E..STFCR/L

Ø10 - Ø20

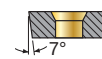
90°



TC.T



TC.W



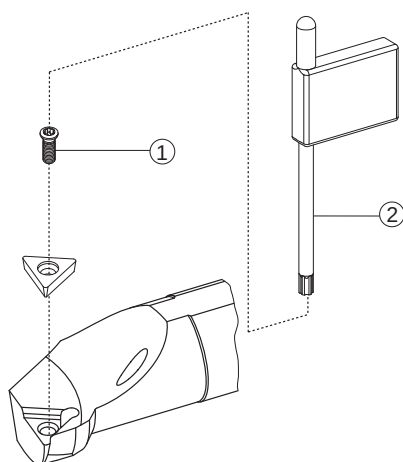
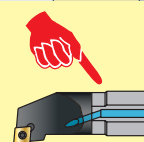
S



In figura utensile destro - Right-hand shown

												 INSERTI - INSERTS PAG. 152			
.G39	.G57P	.Z57	.G39	.S42	.G52										
ART. (mm)												 Nm			
 												 1 2			
E10M	STFCR/L	09	13	10	7	9,50	150	0,9+1,0	0902	12225P	5507P				
E12Q	STFCR/L	11	16	12	9	11,50	180	1,1+1,3	1102	12256P	5508P				
E16R	STFCR/L	11	20	16	11	15,25	200	1,1+1,3							
E20S	STFCR/L	16	25	20	13	19,00	250	3,8+5,0	16T3	1240P	5515P				

UTENSILI CON STELO IN METALLO DURO
 TOOLS WITH CARBIDE SHAFT
 WERKZEUGE MIT HM-SCHAFT
 OUTILS AVEC QUEUE EN METAL DUR



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



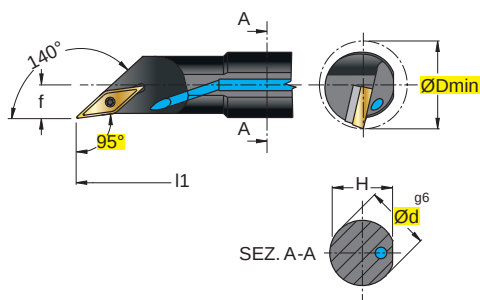
PAG. 967

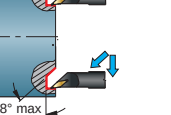
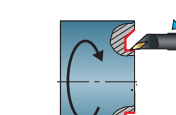
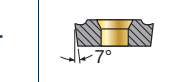
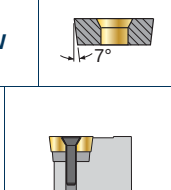
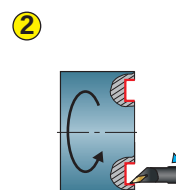


PAG. 992

Ø12 - Ø25

140°

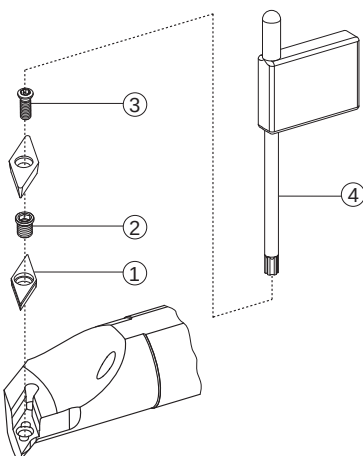


	
VC.T 	
S 	



INSERTI - INSERTS
PAG. 153

ART.		(mm)								①	②	③	④	
		ØDmin	Ød	f	H	l1	Nm							
A12K	SVOCR/L 11	16	12	9	11,5	125	1,1+1,3	1103	—	—	12256P	5508P		
A16M	SVOCR/L 11	20	16	11	15	150	1,1+1,3							
A20Q	SVOCR/L 16	23	20	12,5	19	180	3,0+3,5	1604	—	—	123509P	5515P		
A25R	SVOCR/L 16	30	25	16,5	24	200	3,0+3,5							



 **PAG. 136**

PAG. 132

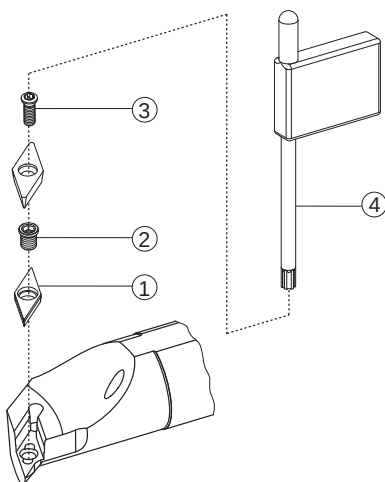


PAG. 967



PAG. 992

A..SVUCR/L					E..SVUCR/L				
Ø16 - Ø40					Ø16 - Ø20				
93°					93°				
VC.T					VC.T				
VC.W					VC.W				
S					S				
In figura utensile destro - Right-hand shown					In figura utensile destro - Right-hand shown				
.G13 .G57P .Z57 .G42 .G52					INSERTI - INSERTS PAG. 153				
ART.					1 2 3 4				
(mm)									
ØDmin Ød f H l1 Nm									
A16M SVUCR/L 11					1103				
A20Q SVUCR/L 11					1103				
A25R SVUCR/L 16					1604				
A32S SVUCR/L 16					1604				
A40T SVUCR/L 16					1604				



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967

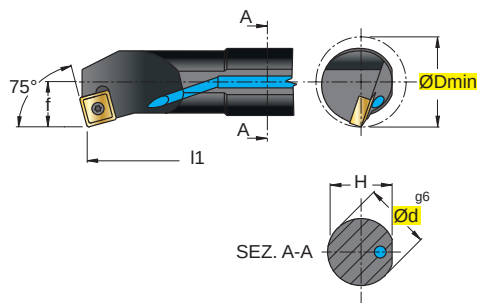


PAG. 992

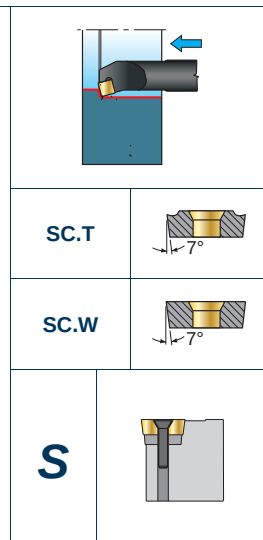
A..SSKCR/L

Ø16 - Ø25

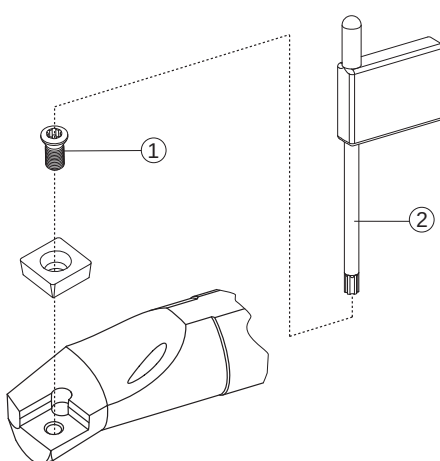
75°



In figura utensile destro - Right-hand shown



.G57P .Z57 .G52													INSERTI - INSERTS PAG. 151			
ART.			(mm)										1	2		
			ØDmin	Ød	f	H	l1	Nm								
A16M	SSKCR/L	09	20	16	11	15,25	150	3,8+5,0	09T3	12409P	5515P					
A20Q	SSKCR/L	09	25	20	13	19,00	180	3,8+5,0	09T3	12409P	5515P					
A25R	SSKCR/L	12	32	25	17	24,00	200	4,0+5,0	1204	124510	5520					



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
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DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967

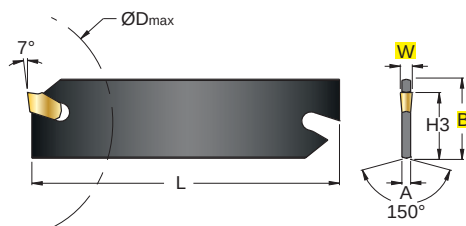
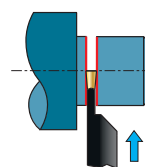


PAG. 992

LGIH Pag.82		TRL Pag.84		TMSDR/L Pag.86		STGR/L Pag.90			
									
ØDmax = 50 - 120		ØDmax = 70 - 100		□ 16x16 - 25x25		□ 20x20 - 25x25			
	STN W=2,2-6,4		TRL..N W=3,0-4,0		GX16 W=3-5		154.. W=1,1-4,15		
				TMSIR/L Pag.86		A..STIR/L Pag.90			
									
				ØDmin = 20,5 - 42		ØDmin = 20 - 40			
					GX16 W=2-5		154.. W=1,1-4,15		
				TMSDR/L Pag.88					
									
				□ 25x25					
					GX24 W=2-6				
				TMSIR/L Pag.88					
									
				ØDmin = 42 - 57					
					GX24 W=3-6				

LGIH

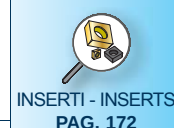
26 - 32



STN



.L52



ART.

(mm)



1



STN..

		W +/-0,1	B	A	ØDmax	L	H3				
LGIH	26-2	2,2-2,4	26	1,6	50	110	21,4	2	SESG-1		
LGIH	26-3	3,1	26	2,4	75	110	21,4	3	SESG-1		
LGIH	26-4	4,1	26	3,2	80	110	21,4	4	SESG-1		
LGIH	26-5	4,8-5,1	26	4,0	80	110	21,4	5	SESG-1		
LGIH	32-2	2,2-2,4	32	1,6	40	150	25,0	2	SESG-1		
LGIH	32-3	3,1	32	2,4	100	150	25,0	3	SESG-1		
LGIH	32-4	4,1	32	3,2	100	150	25,0	4	SESG-1		
LGIH	32-5	4,8-5,1	32	4,0	120	150	25,0	5	SESG-1		

**IN ESAURIMENTO
END OF STOCK
AUSLAUFEND
EN ÉPUISEMENT**

CAMPI D'IMPIEGO DEGLI INSERTI PER TAGLIO-SCANALATURA
FIELDS OF APPLICATION FOR PARTING AND GROOVING INSERTS
EINSATZBEREICH FÜR ABSTECH- UND NUTENDREHWELENDEPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TRONÇONNAGE-GORGES



PAG. 166

VELOCITÀ DI TAGLIO Vc
Vc. CUTTING SPEED
Vc. SCHNITTGESCHWINDIGKEIT
Vc. VITESSE DE COUPE



PAG. 164

DETTAGLIO RICAMBI
SPARE PARTS DETAILS
DETAILS ZU DEN ERSATZTEILEN
DÉTAIL DE PIÈCES DE RECHANGE

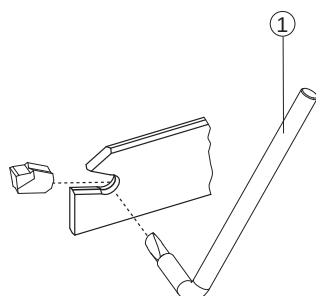


PAG. 967

DATI TECNICI E CONSIGLI
TECHNICAL DATA AND SUGGESTIONS
TECHNISCHE DATEN UND EMPFEHLUNGEN
DONNÉES TECHNIQUES ET CONSEILS

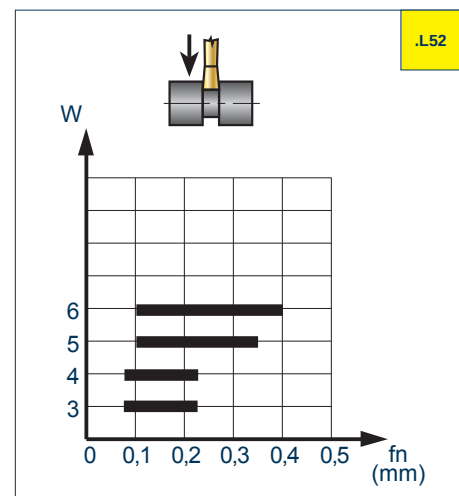


PAG. 995



SCELTA VELOCE - QUICK PICK																		HT		HW	HC				±0,1 W r																		
																		CERMET	NON RIV. CEMENTED CARBIDE GRADES			RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																					
COD.	P			M			K			N			S			H			T518M				T533		W	r	a°																
	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R																									
STN 2 .L52	●			●									●							■					2,21	0,2	0°																
STN 3 .L52	●			●				●					●										■		3,1	0,2	0°																
STN 4 .L52	●			●				●					●							■				■		4,1	0,24	0°															
STN 5 .L52	●			●				●					●							■				■		5,1	0,28	0°															
IN ESAURIMENTO END OF STOCK AUSLAUFEND EN ÉPUISEMENT																																											
CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY																														●			●										
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY																																											

MATERIALI - MATERIALS		VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	Vc m/min Pag. 164			
Pag. 1063				T518M	T533		
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1--5	125-300	190	190		
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6--9	180-350	160	160		
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	135	135		
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	155	155		
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	140	140		
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	150			
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	150			
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	160			
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21--25	60-130				
	RAME E SUE LEGHE - COPPER	26--28	90-110				
	NON METALLICI - PLASTICS	29-30	/				
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31--35	200-320	30	25		
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ³⁾		100		
H	ACCIAIO TEMPRATO - HARDENED STEEL	38--41	45-60 ²⁾				



= SCANALATURA - GROOVING

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

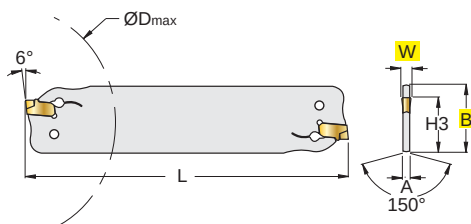
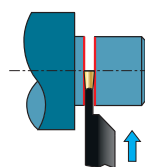
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

$$n = \frac{Vc \cdot 1000}{\phi D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

$$Vf = fn \cdot n = \text{mm/min}$$

26 - 32

NEW



TRLN..



.G52

.G56

.G57P

(mm)

 $W \pm 0,1$

B

A

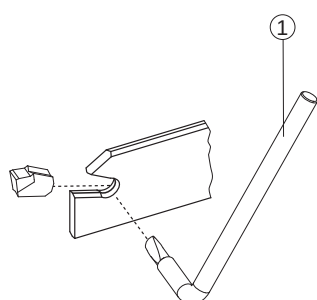
 $\varnothing D_{max}$

L

H3

TRL	26-30	3,0	26	2,4	70	110	21,4	3,0	SESG-1			CH-TRL30-40
TRL	26-40	4,0	26	3,2	80	110	21,4	4,0	SESG-1			CH-TRL30-40
TRL	32-30	3,0	32	2,4	100	150	25,0	3,0	SESG-1			CH-TRL30-40
TRL	32-40	4,0	32	3,2	100	150	25,0	4,0	SESG-1			CH-TRL30-40

PAG. 166



PAG. 164



PAG. 967

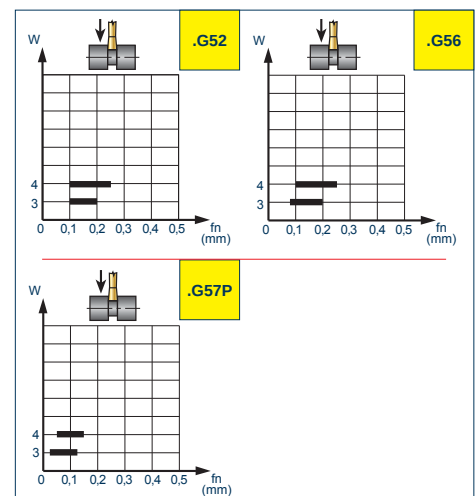
PAG. 995

Tenacità +
Toughness -

Pag. 156

Pag. 156

MATERIALI - MATERIALS Pag. 1063		VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	Vc m/min Pag. 164					
				T115	F4645	T5235			
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1--5	125-300		130	150			
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350		120	140			
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325		90	130			
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240		90	115			
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230						
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260			130			
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250			120			
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230			130			
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21--25	60-130	600					
	RAME E SUE LEGHE - COPPER	26--28	90-110	400					
	NON METALLICI - PLASTICS	29-30	/	450					
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31--35	200-320						
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ³⁾						
H	ACCIAIO TEMPRATO - HARDENED STEEL	38--41	45-60 ²⁾						



1 = SCANALATURA - GROOVING

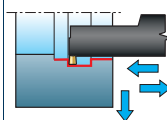
Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/(min · min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
f = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

$$n = \frac{V_c \cdot 1000}{\varnothing D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

$$V_f = f_n \cdot n = \text{mm/min}$$

☐ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / ☐ NEW
☐ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Ø16 - Ø32



GX
16..

In figura utensile destro - Right-hand shown

GX 16..	
	



.Z32	.Z42	.Z52	.Z47P	.Z47P
------	------	------	-------	-------



INSERTI - INSERTS
PAG. 171

Diagram 1 illustrates the first step of assembly: attaching the handle to the base. A screw, labeled with a circled '1', is shown being inserted into the handle, which is labeled with a circled '2'. The handle is positioned vertically, and the screw is being driven into its base. Below the handle, the top of the base is visible, showing a circular hole where the screw will be inserted. A dashed line indicates the alignment of the screw with the hole in the base.

PAG. 166



PAG. 164

PAG. 967

PAG. 995

SCelta VELOCE - QUICK PICK



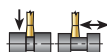
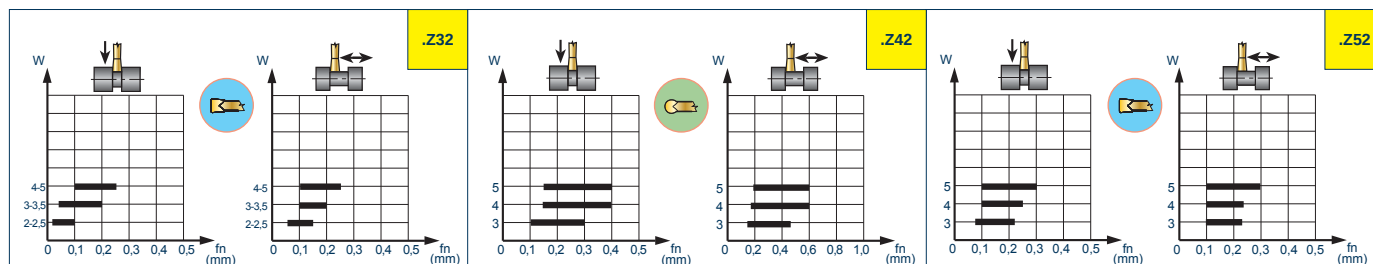
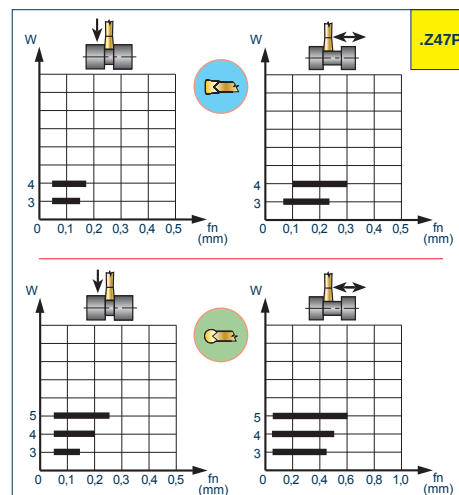
Pag. 156

HT	HW	HC									
CERMET	NON RIV. CEMENTED CARBIDE GRADES	RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS									
	T115	T5226									
	F4645										

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

MATERIALI - MATERIALS Pag. 1063		VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	Vc m/min Pag. 164		
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	T115	F4645	T5226
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350			
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325			
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240			
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230		100	120
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260			160
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250			150
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230			170
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130	440		
	RAME E SUE LEGHE - COPPER	26-28	90-110	340		
	NON METALLICI - PLASTICS	29-30	/	290		
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320		30	
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ¹⁾		30	
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ²⁾			



= SCANALATURA - GROOVING

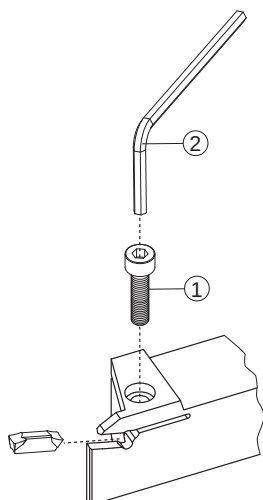
Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

$$n = \frac{Vc \cdot 1000}{\phi D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

$$Vf = fn \cdot n = \text{mm/min}$$

TMSDR/L				Ø 25x25				TMSIR/L				Ø32 - Ø40			
						GX 24..								GX 24..	
In figura utensile destro - Right-hand shown								In figura utensile destro - Right-hand shown							
.Z33	.Z42	.Z62	.Z47P											INSERTI - INSERTS PAG. 172	
ART. (mm)												1	2		
		W	h=h1	b	f	Tmax	l1	l2	Nm						
TMSDR/L	2525-24.2	3-3,5	25	25	25,5	22	143	43	5,5+7,0	GX24.2	SM 620	5005			
TMSDR/L	2525-24.3	4-5	25	25	25,5	22	143	43	5,5+7,0	GX24.3	SM 620	5005			
TMSDR/L	2525-24.4	6	25	25	26	22	143	43	5,5+7,0	GX24.4	SM 620	5005			
ART. (mm)												1	2		
		W	Ød	Ødmin	f	H	Tmax	l1	l2	Nm					
TMSIR/L	32-24-2	3	32	42	27,5	31,0	11,0	250	50	5,0+6,0	GX24.2	SM 522	5520		
TMSIR/L	32-24-3	4-5	32	42	27,5	31,0	11,0	250	50	5,0+6,0	GX24.3	SM 522	5520		
TMSIR/L	32-24-4	6	32	47	30,4	31,0	17,5	250	50	5,0+6,0	GX24.4	SM 522	5520		
TMSIR/L	40-24-3	4-5	40	53	32,5	38,5	12,0	300	60	5,0+6,0	GX24.3	SM 522	5520		
TMSIR/L	40-24-4	6	40	57	34,4	38,5	17,5	300	60	5,0+6,0	GX24.4	SM 522	5520		

INSERTI - INSERTS
 PAG. 172



CAMPI D'IMPIEGO DEGLI INSERTI PER TAGLIO-SCANALATURA
 FIELDS OF APPLICATION FOR PARTING AND GROOVING INSERTS
 EINSATZBEREICH FÜR ABSTECH- UND NUTENDREHWEINDEPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TRONÇONNAGE-GORGES

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 166



PAG. 164



PAG. 967



PAG. 995

SCelta VELOCE - QUICK PICK

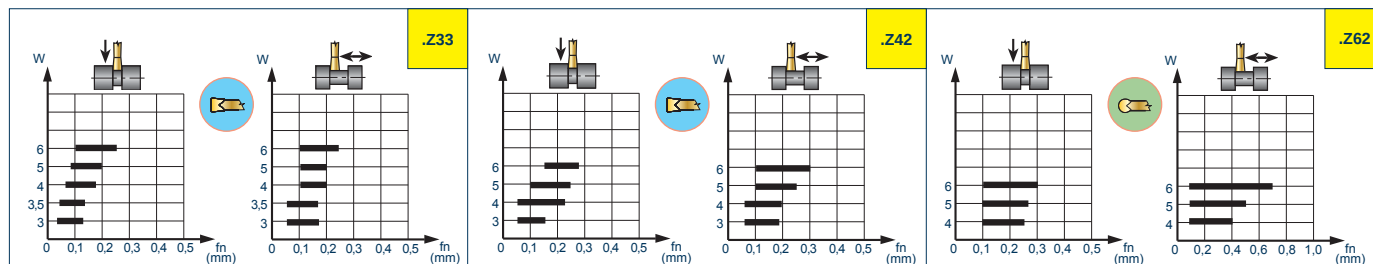
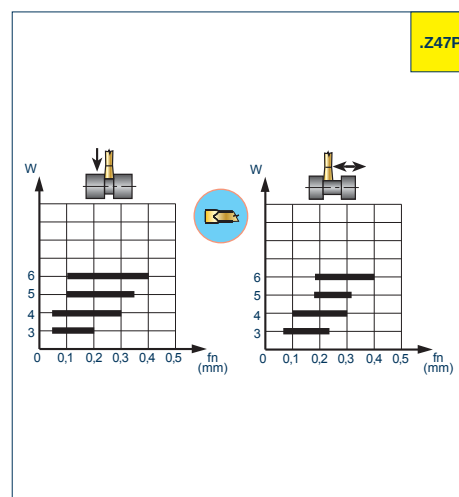


HT	HW	HC																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
CERMET	NON RIV. CEMENTED CARBIDE GRADES	RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

MATERIALI - MATERIALS Pag. 1063		VDI 3323 GR.	HB Rm ²¹ HRC ²¹	Vc m/min Pag. 164					
				T115	F4530	F4645	T5226	T5235	
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1--5	125-300		140	130	180	150	
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6--9	180-350		130	120	150	140	
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325		100	90	135	130	
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240		150	90	170	115	
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230		100	100	120	120	
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260		160		160	130	
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250		140		150	120	
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230		140		170	130	
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21--25	60-130	440	250				
	RAME E SUE LEGHE - COPPER	26--28	90-110	340	300				
	NON METALLICI - PLASTICS	29-30	/	290	180				
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31--35	200-320		30	30			
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ²¹		40	30			
H	ACCIAIO TEMPRATO - HARDENED STEEL	38--41	45-60 ²¹						



= SCANALATURA - GROOVING

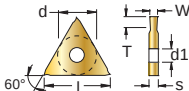
Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

$$n = \frac{Vc \cdot 1000}{\phi D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

$$Vf = fn \cdot n = \text{mm/min}$$

■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW
○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

SCELTA VELOCE - QUICK PICK																			HT		HW	HC																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																												
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-  SI POSSONO UTILIZZARE GLI INSERTI DI PRECISIONE 156... VEDI PAG 171
 PRECISION INSERTS 156... (SEE PAGE 171) CAN BE USED
 DIE PRÄZISIONSWENDESCHNEIDPLATTEN 156... (s.SEITE 171) KÖNNEN EINGESETZT WERDEN.
 ON PEUT UTILISER LES PLAQUETTES DE PRECISION 156... VOIR PAGE 171

MATERIALI - MATERIALS Pag. 1063			VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	fn mm			Vc m/min Pag. 164									
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL		1--5	125-300	0,06	0,12	0,26	N3440	F4340								
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL		6--9	180-350	0,05	0,1	0,25		190								
	ACCIAIO ALTO LEGATO - ALLOY STEEL		10-11	200-325	0,05	0,1	0,25		150								
	INOX MARTENS. - STAINLESS STEEL MART		12-13	200-240	0,05	0,1	0,25		120								
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST		14.1-14.2	180-230	0,05	0,1	0,25		120								
K	GHISA GRIGIA - GREY CAST IRON		15-16	180-260	0,06	0,12	0,25	180									
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE		17-18	160-250	0,05	0,1	0,25	150									
	GHISA MALLEABILE - MALLEABLE CAST IRON		19-20	130-230	0,05	0,1	0,25	160									
N	ALLUMINIO E SUE LEGHE - ALUMINIUM		21--25	60-130	0,06	0,1	0,25	650									
	RAME E SUE LEGHE - COPPER		26--28	90-110	0,05	0,1	0,25	500									
	NON METALLICI - PLASTICS		29-30	/	0,05	0,1	0,25	700									
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY		31--35	200-320													
	TITANIO E SUE LEGHE - TITANIUM		36-37	400-1050 ³⁾													
H	ACCIAIO TEMPRATO - HARDENED STEEL		38--41	45-60 ³⁾													



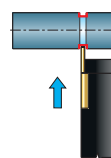
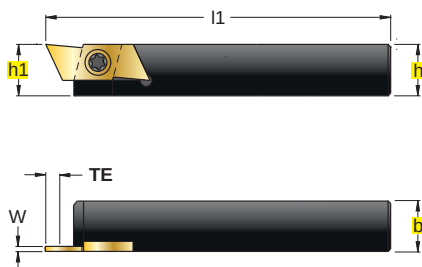
= SCANALATURA - GROOVING

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

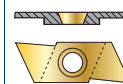
$$n = \frac{Vc \cdot 1000}{\phi D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

$$Vf = fn \cdot n = \text{mm/min}$$

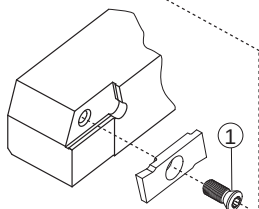
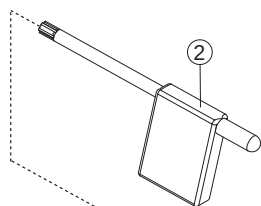
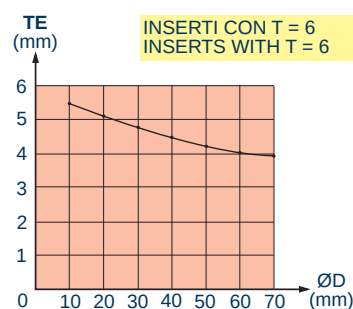
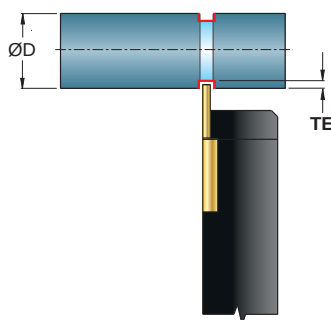
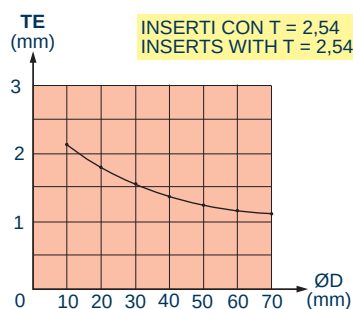
8x8 - 25x25



GIE-7-..



																	
GP/-ST	-SG	-GR	-GW														INSERTI - INSERTS PAG. 173
ART. (mm)																	
		h=h1		b	l1		Nm		w								
THE - 7 - 0808 R / L		08	08	100		1,2÷1,5		0,5-3,0		123008P		5508P					
THE - 7 - 1010 R / L		10	10	120		1,2÷1,5											
THE - 7 - 1212 R / L		12	12	120		1,2÷1,5											
THE - 7 - 1616 R / L		16	16	125		1,2÷1,5											
THE - 7 - 2020 R / L		20	20	125		1,2÷1,5											
THE - 7 - 2525 R / L		25	25	125		1,2÷1,5											
		UTENSILI PER MACCHINE A FANTINA MOBILE - TOOLS FOR SLIDING HEADSTOCK MACHINES															
THS - 7 - 0808 R / L		08	08	140		1,2÷1,5		0,5-3,0		123008P		5508P					
THS - 7 - 1010 R / L		10	10	150		1,2÷1,5											



Tenacità + ↑
Toughness - ↓

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY



= SCANALATURA - GROOVING

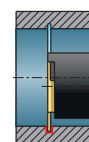
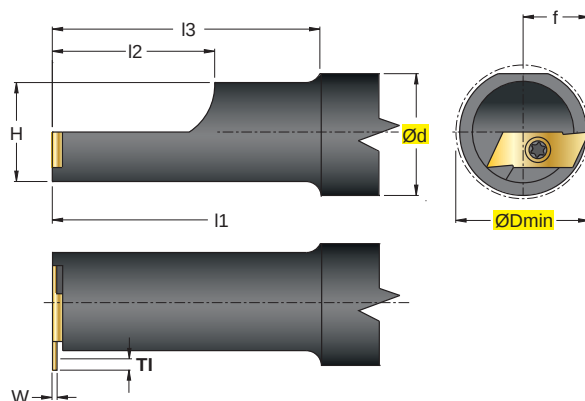
Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/(min · min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
f = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

$$n = \frac{V_c \cdot 1000}{\varnothing D \cdot 3.14} = \text{giri/min (min}^{-1}\text{)}$$

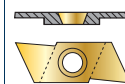
$$V_f = f_n \cdot n = \text{mm/min}$$

☐ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / ☐ NEW
☐ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

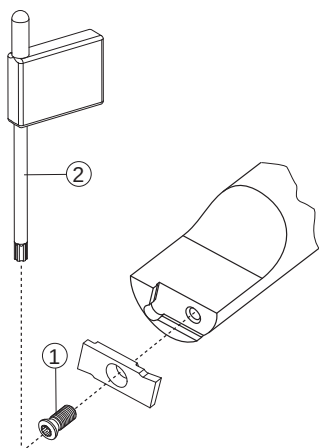
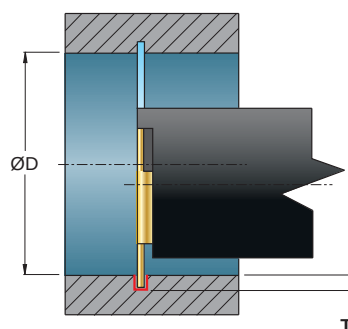
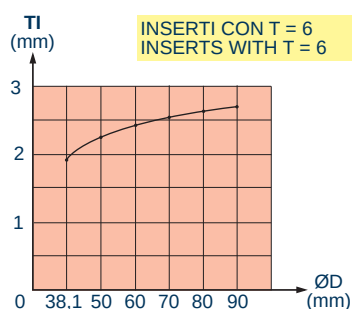
Ø20 - Ø32



GIE-7-..



-GP/-ST	-SG	-GR	-GW																
ART.																			
(mm)																			
			ØDmin	Ød	f	H	I1	I2	I3	Nm	 w								
THI - 7 - 20 R / L			38,10	20	13,34	19,05	140	25	50	1,2+1,5	0,5-3,0	123008P	5508P						
THI - 7 - 25 R / L			38,10	25	13,34	19,05	150	32	63	1,2+1,5									
THI - 7 - 32 R / L			38,10	32	13,34	19,05	150	32	63	1,2+1,5									
PER UTENSILI DESTRI (R) INSERTO SINISTRO (L) - PER UTENSILI SINISTRI (L) INSERTO DESTRO (R) FOR RIGHT TOOLS (R) LEFT INSERT (L) - FOR LEFT TOOLS (L) RIGHT INSERT (R) FÜR RECHTE WERKZEUGE (R) LINKE PLATTEN (L) - FÜR LINKE WERKZEUGE (L) RECHTE PLATTEN (R) POUR OUTILS DROITS (R) PLAQUETTE GAUCHE (L) - POUR OUTILS GAUCHES (L) PLAQUETTE DROITE (R)																			



 CAMPI D'IMPIEGO DEGLI INSERTI PER TAGLIO-SCANALATURA
 FIELDS OF APPLICATION FOR PARTING AND GROOVING INSERTS
 EINSATZBEREICH FÜR ABSTECH- UND NUTENDREHWEDELN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TRONÇONNAGE-GORGES

PAG. 166

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

PAG. 164

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

PAG. 967

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

PAG. 995

SCELTA VELOCE - QUICK PICK							Tenacità $\uparrow$ Toughness $\downarrow$		Pag. 156		HT		HW		HC		S W T H L 5° 5° GIE...GP... N L R GIE...ST...								
COD.	P	M	K	N	S	H												+0,02	W	β	R	T	H	S	L
GIE - 7 - GP - 1.0 R - N	●	●																	1,0	—	—	6,0	7	2	17
GIE - 7 - GP - 1.0 L - N	●	●																	1,0	—	—	6,0	7	2	17
GIE - 7 - GP - 1.5 R - N	●	●																	1,5	—	—	6,0	7	2	17
GIE - 7 - GP - 1.5 R - R	●	●																	1,5	—	—	6,0	7	2	17
GIE - 7 - GP - 1.5 L - N	●	●																	1,5	—	—	6,0	7	2	17
GIE - 7 - GP - 1.5 L - R	●	●																	1,5	—	—	6,0	7	2	17
GIE - 7 - GP - 1.5 L - L	●	●																	1,5	—	—	6,0	7	2	17
GIE - 7 - GP - 2.0 R - N	●	●																	2,0	—	—	6,0	7	2	17
GIE - 7 - GP - 2.0 R - R	●	●																	2,0	—	—	6,0	7	2	17
GIE - 7 - GP - 2.0 L - N	●	●																	2,0	—	—	6,0	7	2	17
GIE - 7 - ST - 3.0 R	●	●																	3,17	—	—	—	7	3,17	17
GIE - 7 - ST - 3.0 L	●	●																	3,17	—	—	—	7	3,17	17
GIE - 7 - SG - 0.5 R	●	●																	0,50	—	—	2,54	7	2	17
GIE - 7 - SG - 0.5 L	●	●																	0,50	—	—	2,54	7	2	17
GIE - 7 - SG - 0.7 R	●	●																	0,70	—	—	2,54	7	2	17
GIE - 7 - SG - 0.7 L	●	●																	0,70	—	—	2,54	7	2	17
GIE - 7 - SG - 0.8 R	●	●																	0,80	—	—	2,54	7	2	17
GIE - 7 - SG - 0.8 L	●	●																	0,80	—	—	2,54	7	2	17
GIE - 7 - SG - 0.9 R	●	●																	0,90	—	—	2,54	7	2	17
GIE - 7 - SG - 0.9 L	●	●																	0,90	—	—	2,54	7	2	17
GIE - 7 - SG - 1.1 R	●	●																	1,10	—	—	6,00	7	2	17
GIE - 7 - SG - 1.1 L	●	●																	1,10	—	—	6,00	7	2	17
GIE - 7 - SG - 1.3 R	●	●																	1,30	—	—	6,00	7	2	17
GIE - 7 - SG - 1.3 L	●	●																	1,30	—	—	6,00	7	2	17
GIE - 7 - SG - 1.6 R	●	●																	1,60	—	—	6,00	7	2	17
GIE - 7 - SG - 1.6 L	●	●																	1,60	—	—	6,00	7	2	17
GIE - 7 - SG - 1.85 R	●	●																	1,85	—	—	6,00	7	2	17
GIE - 7 - SG - 1.85 L	●	●																	1,85	—	—	6,00	7	2	17
GIE - 7 - GR - 1.0 R	●	●																	1,0	—	0,50	6	7	2	17
GIE - 7 - GR - 1.0 L	●	●																	1,0	—	0,50	6	7	2	17
GIE - 7 - GR - 1.5 R	●	●																	1,5	—	0,75	6	7	2	17
GIE - 7 - GR - 1.5 L	●	●																	1,5	—	0,75	6	7	2	17
GIE - 7 - GR - 2.0 R	●	●																	2,0	—	1,00	6	7	2	17
GIE - 7 - GR - 2.0 L	●	●																	2,0	—	1,00	6	7	2	17
GIE - 7 - GW - 60 R	●	●																	—	60°	0,10	—	7	2	17
GIE - 7 - GW - 60 L	●	●																	—	60°	0,10	—	7	2	17
GIE - 7 - GW - 55 R	●	●																	—	55°	0,12	—	7	2	17
GIE - 7 - GW - 55 L	●	●																	—	55°	0,12	—	7	2	17
CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY																									
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY																									

MATERIALI - MATERIALS Pag. 1063		VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	fn mm			Vc m/min Pag. 164									
				F	M	R	C5PV									
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1--5	125-300	0,03	0,05	0,10	140									
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6--9	180-350	0,03	0,05	0,10	105									
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,03	0,05	0,10	105									
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	0,03	0,05	0,10	120									
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,03	0,05	0,10	105									
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260													
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250													
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230													
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21--25	60-130													
	RAME E SUE LEGHE - COPPER	26--28	90-110													
	NON METALLICI - PLASTICS	29-30	/													
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31--35	200-320													
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ³⁾													
H	ACCIAIO TEMPRATO - HARDENED STEEL	38--41	45-60 ³⁾													

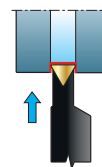
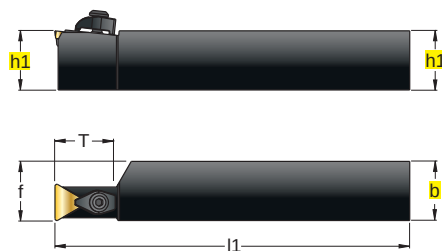


Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

$$n = \frac{Vc \cdot 1000}{\phi D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

$$Vf = fn \cdot n = \text{mm/min}$$

25x25



TPMR



C



S44



INSERTI - INSERTS
PAG. 152

ART.

(mm)



1

2

3

4

SCTFPR/L	2525	M	11
SCTFPR/L	2525	M	16

h

b

11

T

1103
1603

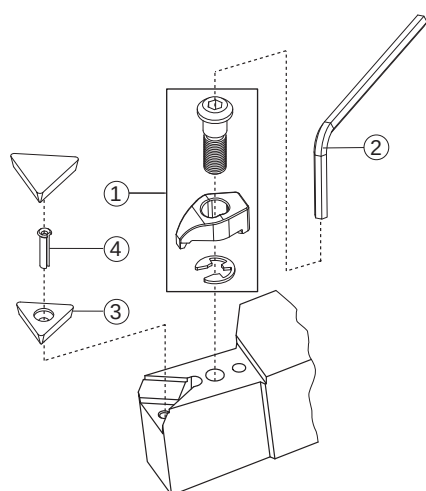
2304C

2305C

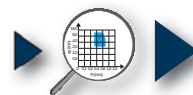
5025
5003

3116

4002



 **CAMPI D'IMPIEGO DEGLI INSERTI PER TAGLIO-SCANALATURA**
 **FIELDS OF APPLICATION FOR PARTING AND GROOVING INSERTS**
 **EINSATZBEREICH FÜR ABSTECH- UND NUTENDREHWEDELN**
 **CHAMPS D'USAGE DES PLAQUETTES POUR TRONÇONNAGE-GORGES**



PAG. 166

 VELOCITÀ DI TAGLIO V_c
 V_c. CUTTING SPEED
 V_c. SCHNITTGESCHWINDIGKEIT
 V_c. VITESSE DE COUPE



PAG. 164

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE



PAG. 967

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 995

Tenacità + ↑
Toughness - ↓

Pag. 156

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBBRIFICANTE - WITHOUT COOLANT SUPPLY

[illegible]

= SCANALATURA - GROOVING

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

I = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

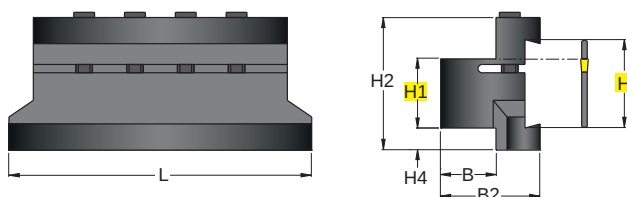
$$V_f = f_n \cdot n = \text{mm/min}$$

$$n = \frac{V_c \cdot 1000}{\varnothing D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

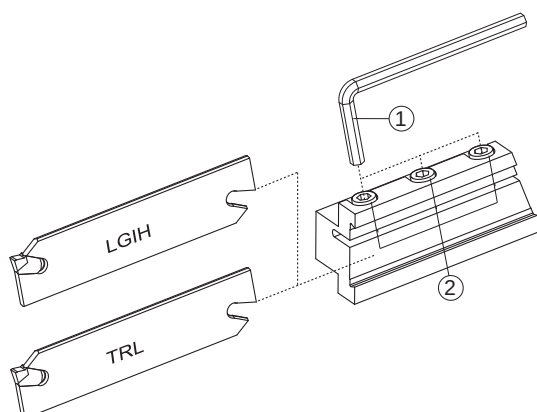
■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
●● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

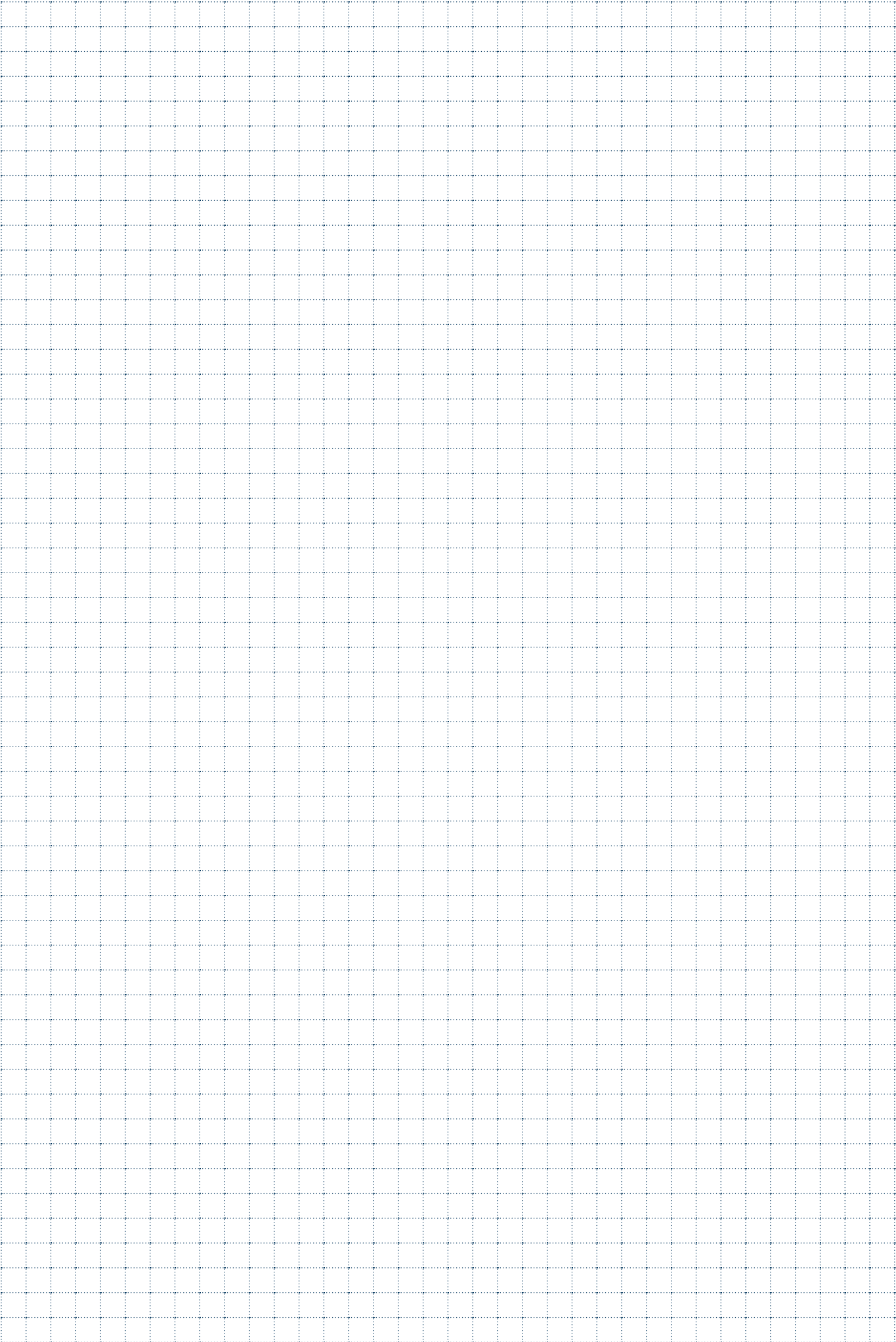
☐ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / ☐ NEW
☐ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

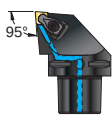
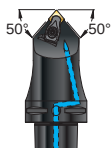
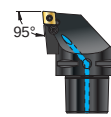
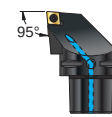
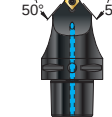
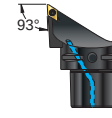
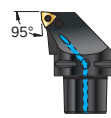
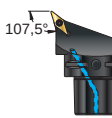
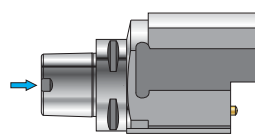
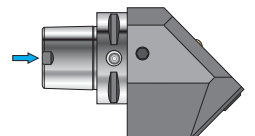
LGTBN



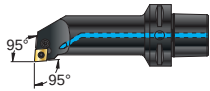
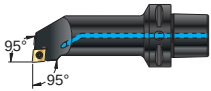
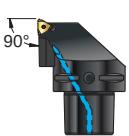
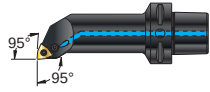
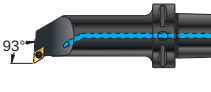
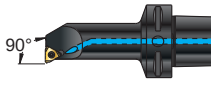
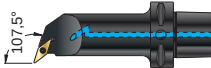
ART.	(mm)									
	H1	H	L	B	B2	H2	H4		1	2
LGTBN 20-5	20	26	87	19	33	38	8	LGIH 26 - ..	5005	VBL06
								TRL 26 - ..		
LGTBN 25-6	25	32	110	20	36	48	8	LGIH 32 - ..	5005	VBL06
LGTBN 32-6	32	32	120	28	44	48	3	TRL 32 - ..	5005	VBL06





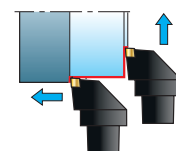
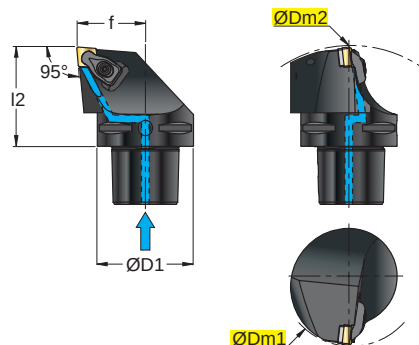
D 		D 		P 		S 		S 	
SC.. DCLNR/L Pag.102		SC63 DCMNN Pag.104		SC.. PCLNR/L Pag.106		SC.. SCLCR/L Pag.109		SC63 SCMNN Pag.113	
									
CNM. 1204..		CNM. 1204..		CNM. 1204..		CC.. 1204..		CC.. 1204..	
PSC50 - PSC63		PSC63		PSC40 - PSC50 - PSC63		PSC40 - PSC50 - PSC63		PSC63	
SC.. DWLNR/L Pag.103		SC63 DDMNL Pag.105		SC.. PDJNR/L Pag.107		SC.. SDJCR/L Pag.110		SC63 SVMBL Pag.114	
									
WNM. 0804..		DNM. 1506..		DNM. 1506..		DC.. 11T3..		VB.. 1604..	
PSC50 - PSC63		PSC63		PSC50 - PSC63		PSC40 - PSC50 - PSC63		PSC63	
				SC.. PWLNR/L Pag.108		SC.. SVHBR/L Pag.111			
									
				WNM. 0804..		VB.. 1604..			
				PSC40 - PSC50 - PSC63		PSC40 - PSC50 - PSC63			
						SC.. SVJBR/L Pag.112			
									
						VB.. 1604..			
						PSC40 - PSC50 - PSC63			
								PSC.C63.PAR/L Pag.899	
									
								PSC.C63.U45 Pag.899	
									



P 		S 				S 	
SC.. PCLNR/L Pag.115		SC.. SCLCR/L Pag.117				SC.. SER/L Pag.714	
							
PSC40 - PSC50 - PSC63		PSC40 - PSC50 - PSC63				PSC40 - PSC50 - PSC63	
	CNM. 1204..		CC.. 1204..				16ER/EL
SC.. PWLNR/L Pag.116		SC.. SDUCR/L Pag.118				SC.. ANR/L Pag.715	
							
PSC40 - PSC50 - PSC63		PSC40 - PSC50 - PSC63				PSC40 - PSC50 - PSC63	
	WNM. 0804..		DC.. 11T3..				16IR/IL
		SC.. SVQBR/L Pag.119					
							
		PSC50 - PSC63					
			VB.. 1604..				

SC.. DCLNR/L

95°



CNMA



CNMG



CNMM

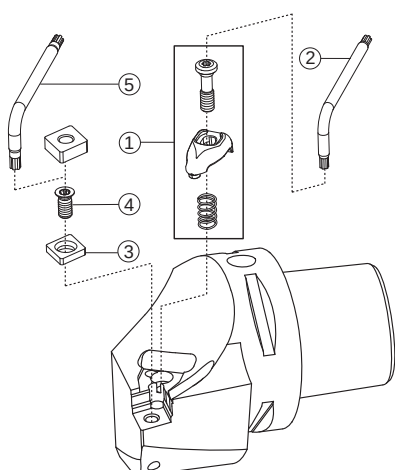


D



In figura utensile destro - Right-hand shown

															 INSERTI - INSERTS PAG. 143		
.G23	.G61	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82			
ART.				(mm)							①	②	③	④	⑤		
SC50 DCLNR/L 35060-12		PSC50	80	165	50	35	60	3,9	1204		100-21	5415	3612	125011	5420		
SC63 DCLNR/L 45065-12		PSC63	100	190	63	45	65	3,9									
SC63 DCLNR/L 45065-16 New		PSC63	125	190	63	45	65	6,4	1604		100-31	5420	3616	126011	5420		



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

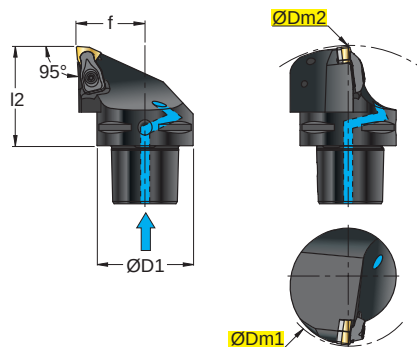


PAG. 967

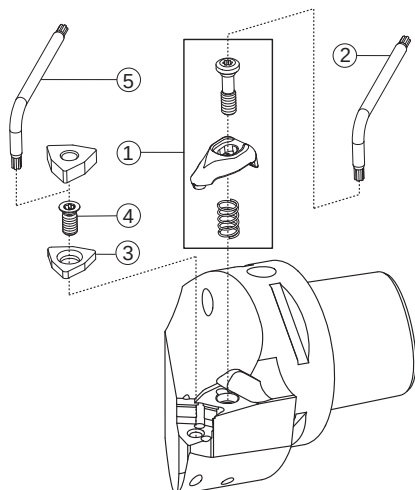
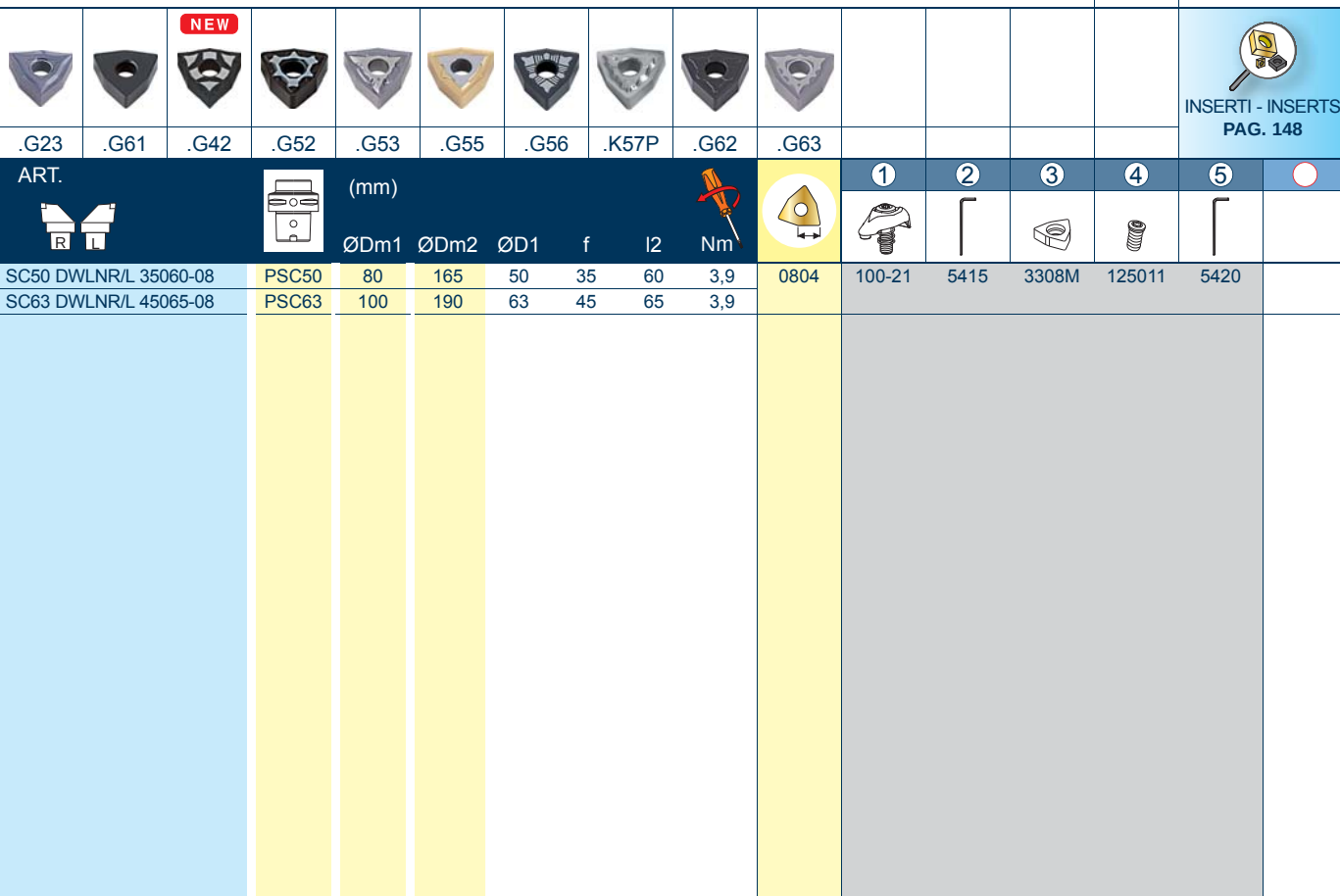


PAG. 992

93°



	
WNMA	
WNMG	
WNMM	
D	



PAG. 136

 **PAG. 132**



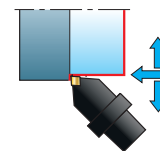
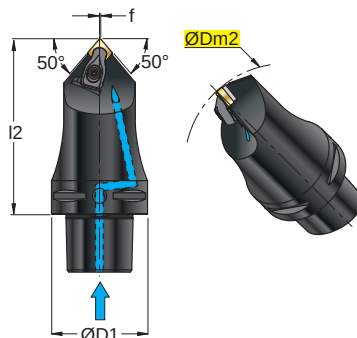
PAG. 967



PAG. 992

SC63 DCMNN

50° 95°



CNMA



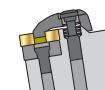
CNMG



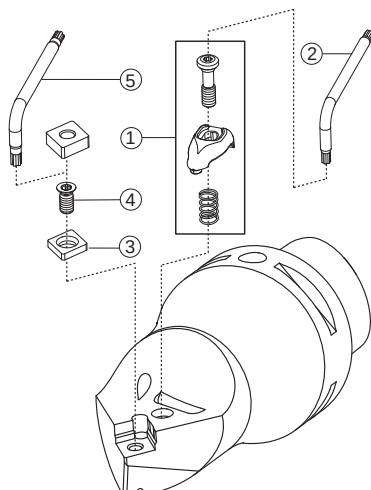
CNMM



D



															 INSERTI - INSERTS PAG. 143	
.G23	.G61	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82		
ART.																
			(mm)													
SC63 DCMNN 00090-12		PSC63	190	63	0	90	3,9		1204		100-21	5415	3612	125011	5420	
SC63 DCMNN 00115-12		PSC63	190	63	0	115	3,9									



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNATURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



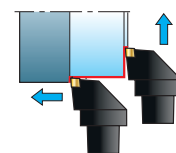
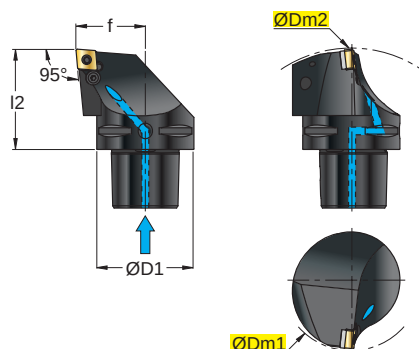
PAG. 967



PAG. 992

SC.. PCLNR/L

95°



CNMA



CNMG



CNMM

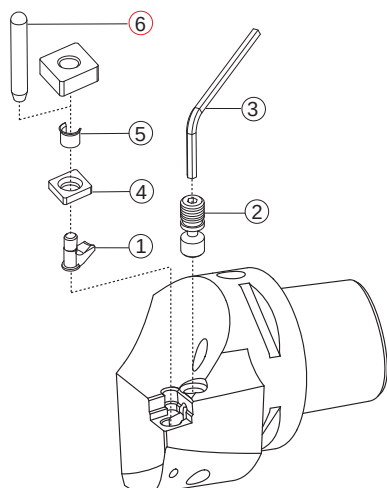


P



In figura utensile destro - Right-hand shown

															 INSERTI - INSERTS PAG. 143	
.G23	.G61	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82		
ART.				(mm)												
SC40 PCLNR/L 27050-12		PSC40	70	140	40	27	50	1204			8012	1608	5003	3612	4112	0012
SC50 PCLNR/L 35060-12		PSC50	80	165	50	35	60									
SC63 PCLNR/L 45065-12		PSC63	100	190	63	45	65									
SC63 PCLNR/L 45065-16 New		PSC63	100	190	63	45	65	1604			8016	1618	5003	3616	4115	0015



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
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DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

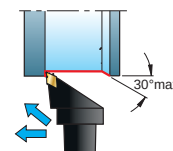
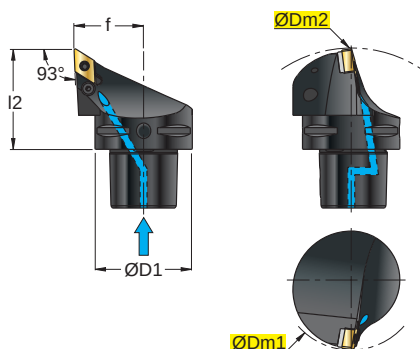


PAG. 967

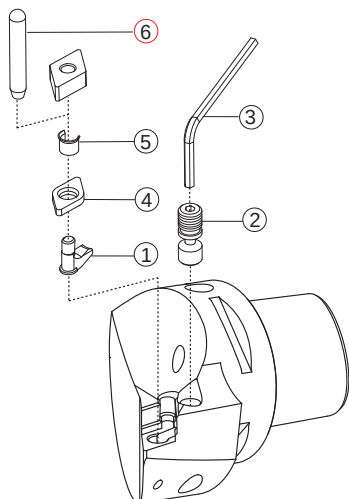


PAG. 992

93°



P

[illegible]

 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

PAG. 136

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

PAG. 132

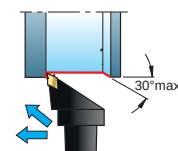
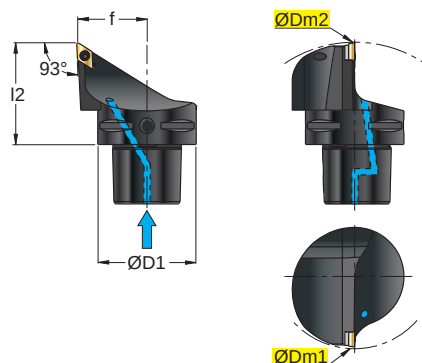
 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

PAG. 967

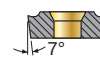
 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

PAG. 992

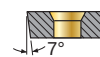
93°



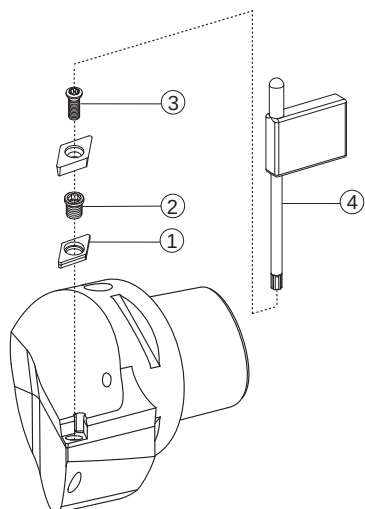
DC.T



DC.W



S

[illegible]

 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 **DATI TECNICI E CONSIGLI**
 TECHNICAL DATA AND SUGGESTIONS
 **TECHNISCHE DATEN UND EMPFEHLUNGEN**
 **DONNÉES TECHNIQUES ET CONSEILS**



PAG. 136



PAG. 132

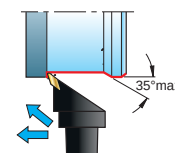
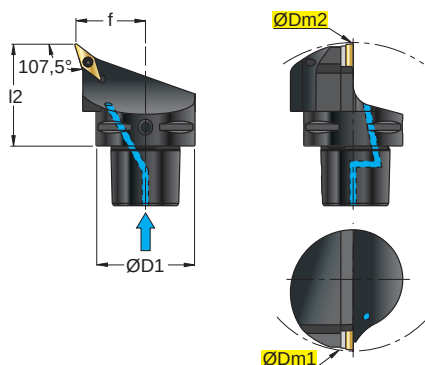


PAG. 967



PAG. 992

107,5°



A cross-sectional diagram of a dovetail joint. It shows a wooden tenon (yellow) with a dovetail-shaped hole (grey) in a wooden board. The angle of the dovetail is labeled as 5°.

A cross-sectional diagram of a fillet weld joint. Two metal plates, represented by hatched areas, are joined by a weld. The weld has a concave profile. The angle between the vertical plate surface and the weld face is labeled as 5° .

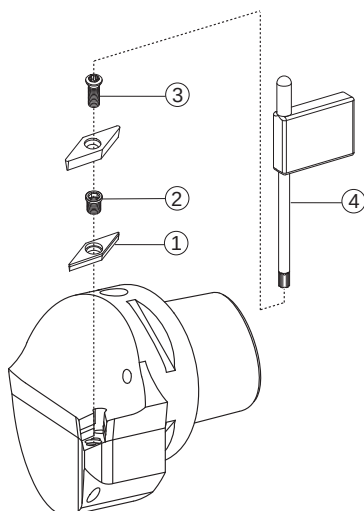
S



												
.G42	.G52	.G58										



INSERTI - INSERTS
PAG. 153

[illegible]

PAG. 136



PAG. 132



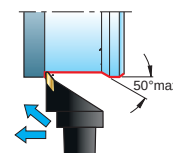
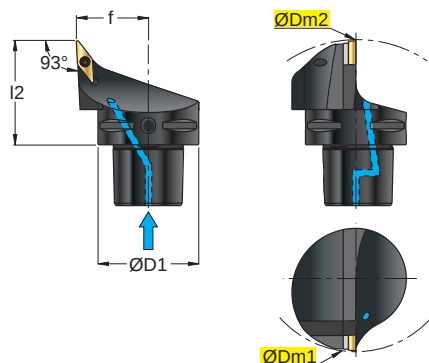
PAG. 967



PAG. 992

SC.. SVJBR/L

93°



VB.T



VB.W

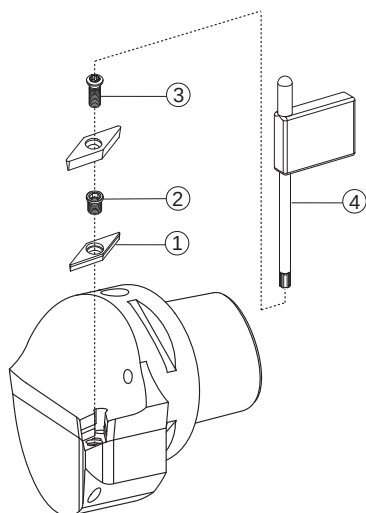


S



In figura utensile destro - Right-hand shown

NEW													INSERTI - INSERTS PAG. 153				
.G42 .G52 .G58																	
ART.			(mm)										1	2	3	4	
R L			ØDm1 ØDm2 ØD1 f l2 Nm														
SC40 SVJBR/L 27050-16			PSC40	120	140	40	27	50	3,0+3,5	1604			3716	BCL7	123511P	5515P	
SC50 SVJBR/L 35060-16			PSC50	120	165	50	35	60	3,0+3,5								
SC63 SVJBR/L 45065-16			PSC63	120	190	63	45	65	3,0+3,5								



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
Vc. CUTTING SPEED
Vc. SCHNITTGESCHWINDIGKEIT
Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
SPARE PARTS DETAILS
DETAILS ZU DEN ERSATZTEILEN
DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
TECHNICAL DATA AND SUGGESTIONS
TECHNISCHE DATEN UND EMPFEHLUNGEN
DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

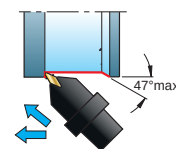
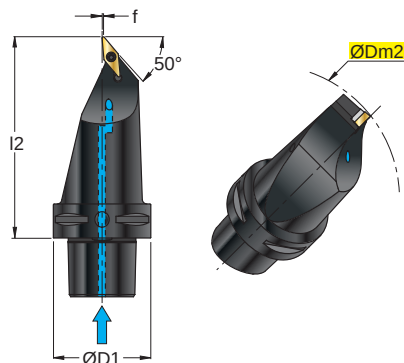


PAG. 967



PAG. 992

50° 95°



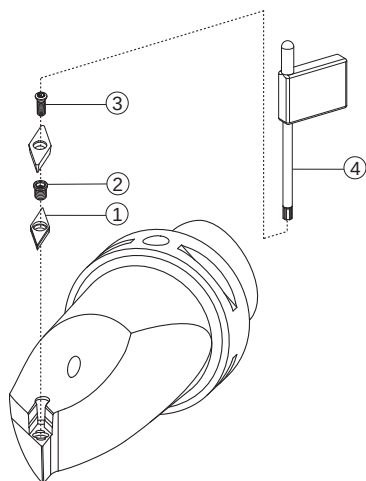
A cross-sectional diagram of a dovetail joint. It shows a wooden tenon (the part being inserted) with a dovetail-shaped end. The tenon is shown in a light tan color, while the surrounding wood (the mortise) is shown in a darker tan color with diagonal hatching. The angle of the dovetail's tail is labeled as 5°.

A cross-sectional diagram of a fillet weld joint. Two plates, represented by hatched areas, are joined by a weld metal (yellow). The weld metal forms a fillet with a concave surface. An arrow points to the angle between the weld metal and the base metal, which is labeled as 5° .

S

[illegible]

ART.		(mm)			①	②	③	④	
		ØDm2 ØD1 f l2	Nm						
SC63 SVMBL 00130-16	PSC63	190 63 0 130	3,0÷3,5	1604					



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

 **DATI TECNICI E CONSIGLI**
 **TECHNICAL DATA AND SUGGESTIONS**
 **TECHNISCHE DATEN UND EMPFEHLUNGEN**
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



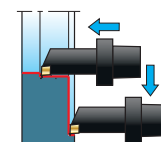
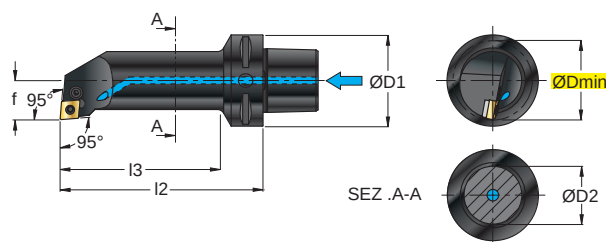
PAG. 967



PAG. 992

SC.. PCLNR/L

95°



CNMA



CNMG



CNMM

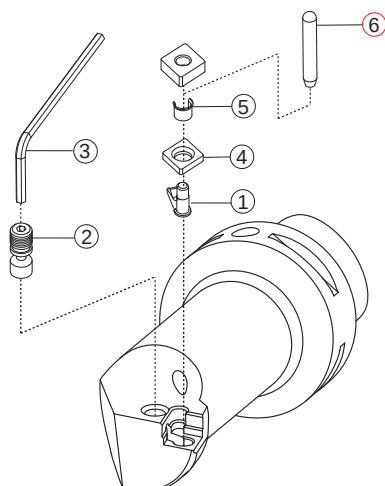


P



in figura utensile destro - right-hand shown

															 INSERTI - INSERTS PAG. 143		
.G23	.G61	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82			
ART.				(mm)							①	②	③	④	⑤	⑥	
				ØDmin	ØD1	ØD2	f	l2	l3								
SC40 PCLNR/L 22110-12				PSC40	39	40	32	22	110		87	8012 1608 5003 3612 4112 0012					
SC50 PCLNR/L 22110-12				PSC50	39	50	32	22	110		87						
SC63 PCLNR/L 27140-12		PSC63	48	63	40	27	140	111									



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE



PAG. 136

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE



PAG. 132

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE



PAG. 967

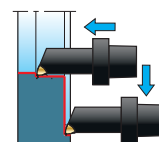
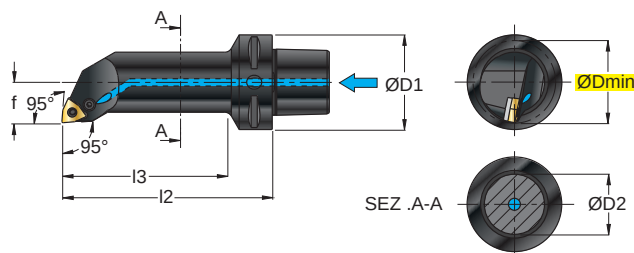
DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 992

SC.. PWLNR/L

95°



WNMA



WNMG



WNMM

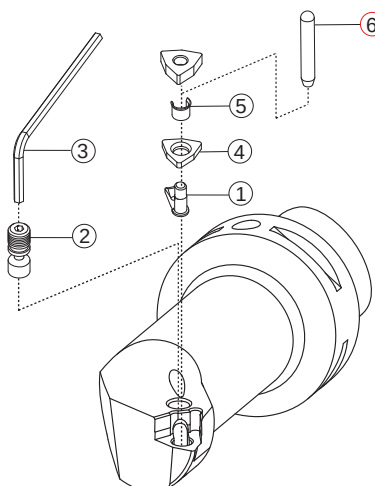


P



In figura utensile destro - Right-hand shown

										 INSERTI - INSERTS PAG. 148					
ART.															
 (mm)															
 ØDmin ØD1 ØD2 f I2 I3										1	2	3	4	5	6
SC40 PWLNR/L 22110-08	PSC40	39	40	32	22	110	87	0804		8012	1608	5003	3308M	4112	0012
SC50 PWLNR/L 22110-08	PSC50	39	50	32	22	110	87								
SC63 PWLNR/L 27140-08	PSC63	48	63	40	27	140	111								



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
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 Vc. SCHNITTGESCHWINDIGKEIT
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DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

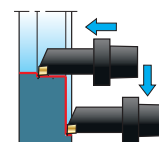
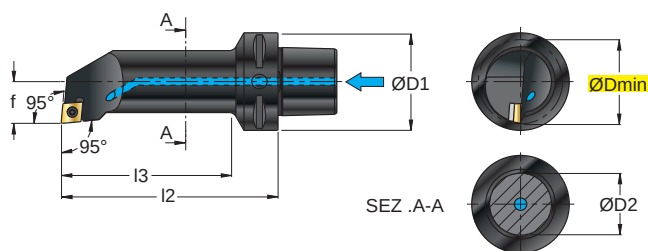


PAG. 967



PAG. 992

95°



A cross-sectional diagram of a dovetail joint. It shows a wooden tenon (yellow) with a dovetail-shaped hole (grey) in a wooden board. The angle of the dovetail is labeled as 7°.

A cross-sectional diagram of a dovetail joint. It shows a wooden block with a dovetail-shaped hole. The hole is filled with a yellow material, representing glue. The angle of the dovetail is labeled as 7° .

S



												
.B22	.G13	.B33	.G57P	.Z57	.G39	.G42	.G52					



(mm)



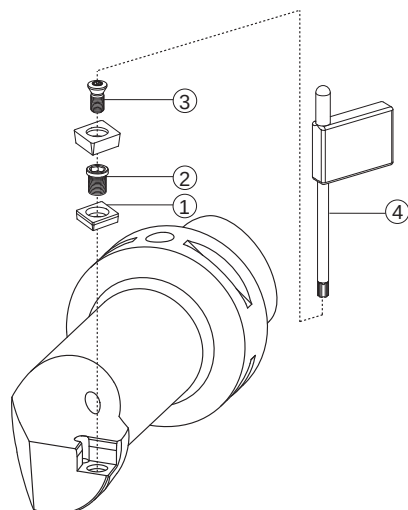
3

4

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SC40 SCLCR/L 11070-09 New	PSC40	20	40	16	11	70	47	3,8+5,0
SC40 SCLCR/L 13080-09 New	PSC40	25	40	20	13	80	58	3,8+5,0
SC40 SCLCR/L 17090-12	PSC40	30	40	25	17	90	68	4,0+5,0
SC40 SCLCR/L 22110-12	PSC40	39	40	32	22	110	87	4,0+5,0
SC50 SCLCR/L 17090-12	PSC50	30	50	25	17	90	68	4,0+5,0
SC50 SCLCR/L 22110-12	PSC50	39	50	32	22	110	87	4,0+5,0
SC63 SCLCR/L 22125-12	PSC63	39	63	32	22	125	102	4,0+5,0
SC63 SCLCR/L 22160-12	PSC63	39	63	32	22	160	132	4,0+5,0
SC63 SCLCR/L 27140-12	PSC63	48	63	40	27	140	111	4,0+5,0
SC63 SCLCR/L 27180-12	PSC63	48	63	40	27	180	151	4,0+5,0

—	—	12409P	5515P
—	—	124510	5520
3611	BCL15	124513P	5520P
—	—	124510	5520
3611	BCL15	124513P	5520P



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

PAG. 136

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

PAG. 132

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

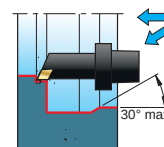
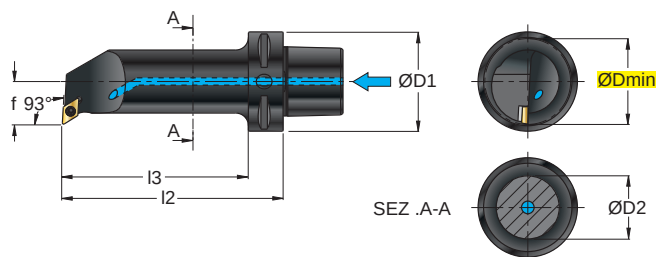
PAG. 967

 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

PAG. 992

SC.. SDUCR/L

93°



DC.T



DC.W

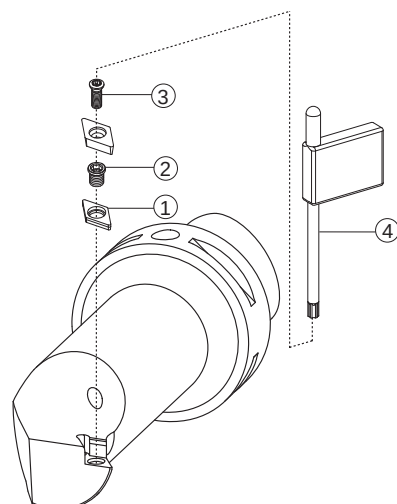


S



in figura utensile destro - right-hand shown

																 INSERTI - INSERTS PAG. 150
.G13	.B53	.G57P	.Z57	.G39	.G42	.G52										
ART.				(mm)												
SC40 SDUCR/L 11070-07 New			PSC40	20	40	16	11	70	47	1,1+1,3	0702	—	—	12256P	5508P	
SC40 SDUCR/L 13080-11 New			PSC40	25	40	20	13	80	58	3,8+5,0	11T3	—	—	12409P	5515P	
SC40 SDUCR/L 17090-11			PSC40	30	40	25	17	90	68	3,0+3,5	11T3	—	—	1240P	5515P	
SC40 SDUCR/L 22110-11			PSC40	39	40	32	22	110	87	3,0+3,5	11T3	3711	BCL7	123511P	5515P	
SC50 SDUCR/L 17090-11			PSC50	30	50	25	17	90	68	3,0+3,5	11T3	—	—	1240P	5515P	
SC50 SDUCR/L 22110-11			PSC50	39	50	32	22	110	87	3,0+3,5	11T3	3711	BCL7	123511P	5515P	
SC63 SDUCR/L 22125-11			PSC63	39	63	32	22	125	102	3,0+3,5						
SC63 SDUCR/L 22160-11			PSC63	39	63	32	22	160	132	3,0+3,5						
SC63 SDUCR/L 27140-11			PSC63	48	63	40	27	140	111	3,0+3,5						
SC63 SDUCR/L 27180-11			PSC63	48	63	40	27	180	151	3,0+3,5						



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE

DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



PAG. 967



PAG. 992

SCELTA VELOCE QUICK PICK



- METODO PER LA SCELTA VELOCE DEL GRADO DI METALLO DURO PIÙ IDONEO. CONTARE IL NUMERO DI RETTANGOLI COLORATI
- METHOD FOR A QUICK CHOICE OF THE MOST SUITABLE SOLID CARBIDE GRADE. COUNT THE NUMBER OF COLORED RECTANGLES
- METHODE ZUR RASCHEN AUSWAHL DER GEEIGNETSTEN HARTMETALLSORTE. DIE ANZAHL DER BUNTEN RECHTECKE ZÄHLEN
- METHODE POUR CHOISIR RAPIDEMENT LE DEGRÉ LE PLUS APPROPRIÉ DU METAL DUR. COMPTER LES RECTANGLES EN COULEURS
- METODO PARA LA ELECCION RAPIDA DE EL GRADO MAS ADECUADO DE METAL DURO. CONTAR LOS NUMEROS DE RECTANGULOS COLORADOS

- GRADO MOLTO RESISTENTE ALL'USURA, SOLO PER FINITURA, LAVORAZIONI AD ALTE VELOCITÀ DI TAGLIO E CONDIZIONI MOLTO RIGIDE E STABILI
- GRADE WITH HIGH RESISTANCE TO WEAR; ONLY FOR FINISHING, MACHINING AT HIGH CUTTING SPEEDS, AND VERY RIGID AND STABLE CONDITIONS
- GRADO CON ALTA RESISTENZA ALL'USURA, DISCRETA TENACITÀ PER LAVORAZIONI A VELOCITÀ MEDIO ALTE ED AVANZAMENTI MEDI, IN CONDIZIONI NORMALI
- GRADE WITH HIGH RESISTANCE TO WEAR, GOOD TOUGHNESS, FOR MEDIUM-HIGH MACHINING AND MEDIUM FEED UNDER NORMAL CONDITIONS
- GRADO CON BUONA RESISTENZA ALL'USURA UNITA A BUONA TENACITÀ, PER LAVORAZIONI GENERICHE IN CONDIZIONI NORMALI
- GRADE WITH GOOD RESISTANCE TO WEAR; COMBINED WITH A GOOD DEGREE OF TOUGHNESS, FOR GENERAL MACHINING UNDER NORMAL CONDITIONS
- GRADO CON OTTIMA TENACITÀ PER LAVORAZIONI MEDIO PESANTI O IN CONDIZIONI POCO STABILI
- GRADE WITH EXCELLENTE TOUGHNESS, FOR MEDIUM HEAVY MACHINING OR MACHINING UNDER CONDITIONS OF LOW STABILITY
- GRADO CON ECCEZIONALE TENACITÀ PER LAVORAZIONI PESANTI CON BASSE VELOCITÀ DI TAGLIO, ALTI AVANZAMENTI O IN CONDIZIONI SFAVOREVOLI
- GRADE WITH EXCELLENTE TOUGHNESS, FOR HEAVY MACHINING WITH LOW CUTTING SPEEDS, HIGH FEED, OR UNDER UNFAVORABLE CONDITIONS

GUIDA FACILE EASY GUIDE

SAU QUALITY TOOLS ENGINEERING

CNMG 120408 .G63 F2425

fn = 0,25-0,50 mm

F	M	R
		● P Vc = 130-200 m/min
		○ M Vc = 100-250 m/min
		K
		N
		S
		H

CNMG 120408 .G53 - F2425

P30-P40/M15-35

- GUIDA ALL'USO DELL'INSERTO. PRESENTE ANCHE SU OGNI ETICHETTA
- GUIDE FOR THE USE OF THE INSERT. ALSO LISTED ON EACH LABEL
- LEITFADEN ZUR VERWENDUNG DER WENDEPLATTE, AUCH AUF JEDEM AUFKLEBER VORHANDEN
- INSTRUCTIONS POUR L'UTILISATION DE LA PLAQUETTE. SE TROUVANT EGALEMENT SUR CHAQUE ETIQUETTE
- GUIA POR EL UTILIZO DE LA PLAQUITA, PRESENTE TAMBIEN EN CADA ETIQUETA

GR. VDI 3323 MATERIALI MATERIALS Pag. 1063	6	P	= ACCIAIO BASSO LEGATO HB 180	- LOW STEEL ALLOY
	14.1	M	= ACCIAIO INOSSIDABILE AUSTENITICO HB 180	- AUSTENITIC STAINLESS STEEL HB 180
	16	K	= GHISA GRIGIA HB 260	- GRAY CAST IRON HB 260
	21	N	= LEGHE DI ALLUMINIO HB 60	- ALUMINUM ALLOYS HB 60
	33	S	= LEGHE RESISTENTI AL CALORE (INCONEL) HB 250	- HEAT RESISTANT ALLOYS (INCONEL) HB 250
	38	H	= ACCIAIO TEMPRATO HRC 55	- TEMPERED STEEL HRC 55
F			= FINITURA, LAVORAZIONI LEGGERE	- FINISHING, LIGHT MACHINING
M			= LAVORAZIONI MEDIE, IMPIEGO GENERICO	- MEDIUM MACHINING, GENERAL USE
R			= SGROSSATURA, LAVORAZIONI PESANTI	- ROUGHING, HEAVY MACHINING
fn (mm)			= AVANZAMENTO PER TORNITURA	- FEED FOR TURNING
fz (mm/z)			= AVANZAMENTO PER FRESATURA	- FEED FOR MILLING
Vc (m/min)			= VELOCITÀ DI TAGLIO	- CUTTING SPEED
●			= APPLICAZIONE CONSIGLIATA	- RECOMMENDED APPLICATION
○			= APPLICAZIONE POSSIBILE	- POSSIBLE APPLICATION



INSERTI PER TORNITURA

TURNING INSERTS / WENDEPLATTEN ZUM DREHEN / PLAQUÉTTES DE TOURNAGE
PLAQUITAS DE TORNEADO





	COME SCEGLIERE I PARAMETRI DI LAVORO	Pag. 123
	PANORAMICA QUALITÀ DI TORNITURA	Pag. 125
	IMPIEGO DELLE QUALITÀ DI TORNITURA	Pag. 126
	VELOCITÀ DI TAGLIO DELLE QUALITÀ DI TORNITURA	Pag. 132
	CAMPI DI IMPIEGO DEI ROMPIRUCIOLI PER TORNITURA	Pag. 136
	DENOMINAZIONI DEGLI INSERTI PER TORNITURA	Pag. 142
	CATALOGO DISPONIBILITÀ INSERTI	Pag. 143

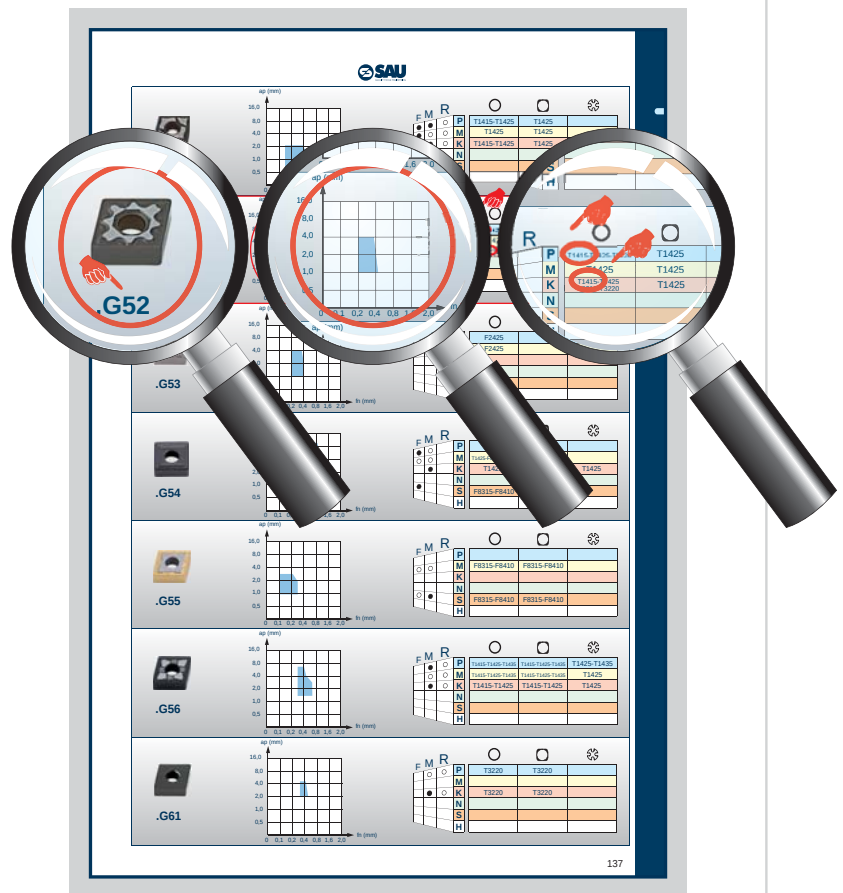
	HOW TO CHOOSE CUTTING DATA	Pag. 123
	GENERAL VIEW OF THE TURNING GRADE	Pag. 125
	APPLICATION OF THE TURNING GRADE	Pag. 126
	CUTTING SPEED OF TURNING GRADES	Pag. 132
	FIELDS OF APPLICATION FOR CHIP BREAKERS	Pag. 136
	INSERTS DESIGNATION FOR TURNING	Pag. 142
	INSERTS STOCK CATALOGUE	Pag. 143

	EINSTELLUNG DER SCHNITTDATEN	Pag. 123
	DREHEN-ÜBERSICHT	Pag. 125
	EINSATZ DER DREHEN	Pag. 126
	SCHNITTGESCHWINDIGKEIT DREHSORTEN (VC)	Pag. 132
	EINSATZGEBIETE DER SPANBRECHER	Pag. 136
	BEZEICHNUNG DER WENDEPLATTEN ZUM DREHEN	Pag. 142
	WENDEPLATTENBESTAND-KATALOG	Pag. 143

	COMMENT CHOISIR LES PARAMETRES DE SERVICE	Pag. 123
	VUE D' ENSEMBLE QUALITÉ DE TOURNAGE	Pag. 125
	UTILISATION DE LES QUALITÉES DE TOURNAGE	Pag. 126
	VITESSE DE COUPE DE LA QUALITÉ DE PLAQUETTES DE TOURNAGE	Pag. 132
	CHAMPS D'USINAGE DE LE BRISE-COPEAUX	Pag. 136
	DÈNOMINATION DES LES PLAQUETTES POUR LE TOURNAGE	Pag. 142
	CATALOGUE DE DISPONIBILITÉ PLAQUETTES	Pag. 143

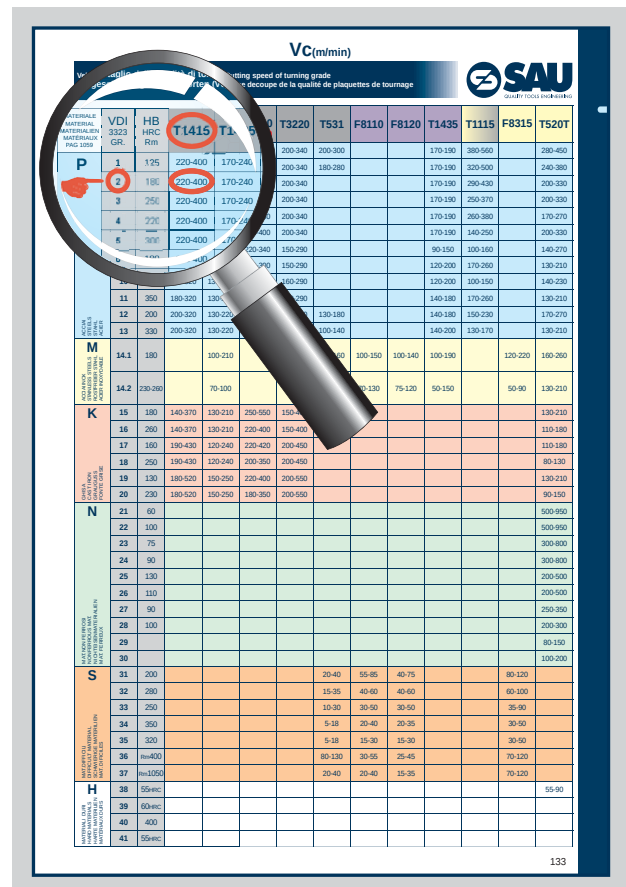
FASE 3 - PHASE 3

SCELTA DELL'AVANZAMENTO
 CHOICE OF FEED
 EINSTELLUNG DES VORSCHUBS
 CHOIX DE L'AVANCEMENT



FASE 4 - PHASE 4

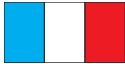
SCELTA DI VC IN FUNZIONE DEL GR. VDI
 CHOICE OF VC DEPENDING ON VDI GR.
 WAHL VC JE NACH WERKSTOFF
 CHOIX DE VC EN FONCTION DU GR. VDI



DIN ISO 513	P ACCIAI STEELS STAHL ACIERS						M ACCIAI INOSSIDABILI STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE				K GHISE, NON FERROSI CAST IRON, NONFERROUS GRAUGUSS, NICHTEISENMA FONTE GRISE, PAS FERREUX				
	01	10	20	30	40	50	10	20	30	40	01	10	20	30	40
HT		C4010					C4010					C4010			
		DT61T					DT61T					DT61T			
		DT63					DT63					DT63			
HW												T110			
												T115			
								T120				T120			
HC		T3210						F8410				T3210	NEW		
		T1115													
		T1415										T1415			
			T520T					F8315				T520T			
								T520T							
								F2120				F2120			
		T3220										T3220			
	NEW	T1625						T1625				T1625			
		T1425						T1425							
			F2425					F2425							
			T531					T531							
			T1435					T1435							
								T2335							
								F2435							
								T540							
TENACITÀ - TOUGHNESS - ZÄHIGKEIT - TÉNACITÉ						TENACITÀ - TOUGHNESS - ZÄHIGKEIT - TÉNACITÉ				TENACITÀ - TOUGHNESS - ZÄHIGKEIT - TÉNACITÉ					
RESISTENZA ALL'USURA - RESISTANCE TO WEAR VERSCHLEISSFESTIGKEIT - RÉSISTANCE À L'USURE						RESISTENZA ALL'USURA - RESISTANCE TO WEAR VERSCHLEISSFESTIGKEIT - RÉSISTANCE À L'USURE				RESISTENZA ALL'USURA - RESISTANCE TO WEAR VERSCHLEISSFESTIGKEIT - RÉSISTANCE À L'USURE					
AVANZAMENTO - FEED - VORSCHUB - AVANCE						AVANZAMENTO - FEED - VORSCHUB - AVANCE				AVANZAMENTO - FEED - VORSCHUB - AVANCE					
VELOCITÀ - SPEED - GESCHWINDIGKEIT - VITESSE						VELOCITÀ - SPEED - GESCHWINDIGKEIT - VITESSE				VELOCITÀ - SPEED - GESCHWINDIGKEIT - VITESSE					
HT	CERMET					HW	METALLO DURO NON RICOPERTO UNCOATED CARBIDE UNBESCHICHTETES HARTMETALL MÉTAL DUR PAS RECOUVERT				HC	METALLO DURO RICOPERTO COATED CARBIDE BESCHICHTETES HARTMETALL MÉTAL DUR RECOUVERT			

SAU	DIN ISO 513		MATERIALE - MATERIAL MATÉRIEL - MATÉRIEL						QUICK PICK PAG. 120	Tenacità Toughness	INDICAZIONI - USO
			P	M	K	N	S	H			
			ACCIAI STEELS STAHL ACIER	ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	GHISA CAST IRON GRAUGUSS FONTE GRISE	MATTONI FERROSI NONFERROUS MAT NICHT-EISENMATERIALIEN MAT FERREUX	MAT DIFFICILI DIFFICULT MATERIAL SCHWERIGE MATERIALIEN MAT. DIFICILES	MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATERIAUX DURS			
C4010	HT	P10-20 M05-15 K05-15	○	●	○						- QUALITÀ UNIVERSALE - ALTA RESISTENZA AL CALORE E ALL'USURA, BUONA TENACITÀ - INDICATO PER LE ALTE VELOCITÀ DI TAGLIO
DT61T	HT	P05-30 M05-30 K05-30	●	●	○	○					- ALTA RESISTENZA ALL' USURA E BUONA TENACITÀ - INDICATO PER ALTE VELOCITÀ DI TAGLIO IN SEMIFINITURA E FINITURA
DT63	HT	P05-25 M05-25 K05-25	●	●	●						- QUALITÀ MICROGRANO MOLTO RESISTENTE ALLA ROTTURA ED ALL'USURA - INDICATO PER MEDIO-ALTE VELOCITÀ DI TAGLIO IN FINITURA.
T110	HW	K05-15			○	●	○				- ALTA RESISTENZA ALL' USURA , ELEVATA STABILITÀ DEL FILO TAGLIANTE, BASSA TENDENZA ALL'INCOLLAMENTO - INDICATO PER MEDIE VELOCITÀ DI TAGLIO SU GHISA GRIGIA E ALTE PER MATERIALI NON FERROSI PER ASPORTAZIONI MEDIE IN SGROSSATURA
T115	HW	K10-20 N10-20 S10-20			○	●	○				- QUALITÀ MICROGRANO CON BUONA RESISTENZA ALL' USURA ELEVATA STABILITÀ DEL FILO TAGLIANTE, BASSA TENDENZA ALL'INCOLLAMENTO - INDICATO PER MEDIO-BASSE VELOCITÀ DI TAGLIO SU GHISA GRIGIA E ALTE PER MATERIALI NON FERROSI
T120	HW	M10-20 K10-25		○	●	●					- QUALITÀ MICROGRANO CON BUONA TENACITÀ - INDICATO PER MEDIO-BASSE VELOCITÀ DI TAGLIO E ALTI AVANZAMENTI. PER ASPORTAZIONI MEDIE IN SGROSSATURA
F2120	HC PVD	M15-25 K15-25		●	○	○	○				- QUALITÀ SPECIFICA PER LA LAVORAZIONE DEGLI ACCIAI INOX, PARTICOLARMENTE ADATTO ALLE LAVORAZIONI DI SUPER FINITURA - PUÒ ESSERE IMPIEGATO NELLE LAVORAZIONI DI GHISA, ALLUMINIO E LEGHE RESISTENTI AL CALORE
T1625 NEW	HC CVD	P10-40 M05-25 K10-40	●	○	○						- QUALITÀ PER UNA VASTA GAMMA DI MATERIALI - ADATTO PER LE LAVORAZIONI DI SGROSSATURA E FINITURA
F2425	HC PVD	P30-40 M15-35	○	●							- SUBSTRATO DI CARBURO APPPOSITAMENTE SVI- LUPPATO, RIVESTIMENTO IN PVD INNOVATIVO. - QUALITÀ CON UN'ECCELLENTI ROBUSTEZZA SENZA PREGIUDICARE LA DUREZZA A CALDO E LA RESISTENZA ALL'USURA SIA A BASSE CHE AD ALTE VELOCITÀ DI TAGLIO
F2435	HC PVD	P35-45 M25-45	○	●							- SUBSTRATO DI CARBURO APPPOSITAMENTE SVILUPPATO - RIVESTIMENTO IN PVD INNOVATIVO, FORNISCE UN'ECCELLENTI ROBUSTEZZA E OTTIMA TENACITÀ SENZA PREGIUDICARE LA DUREZZA A CALDO SIA A BASSE CHE AD ALTE VELOCITÀ DI TAGLIO

- APPLICAZIONE CONSIGLIATA
RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ
APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE
POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG
APPLICATION POSSIBLE
- APPLICAZIONE CONSIGLIATA
RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ
APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE
POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG
APPLICATION POSSIBLE

 INDICATIONS - USE	 GEBRAUCHSANWEISUNGEN	 INDICATION - USAGE
- UNIVERSAL GRADE - HIGH HEAT AND WEAR RESISTANCE, GOOD TOUGHNESS - SUITABLE FOR HIGH CUTTING SPEEDS	- UNIVERSALSORTE - HOHE HITZE- UND VERSCHLEISSBESTÄNDIGKEIT, GUTE ZÄHIGKEIT - FÜR HOHE SCHNITTGESCHWINDIGKEITEN GEEIGNET	- QUALITE UNIVERSELLE - HAUTE RESISTANCE A LA CHALEUR ET A L'USURE, BONNE TENACITE - INDIQUE POUR LES HAUTES VITESSES DE COUPE
-HIGH RESISTANCE TO WEAR AND GOOD TOUGHNESS -SUITABLE FOR HIGH CUTTING SPEEDS FOR SEMI-FINISHING AND FINISHING	-HOHE VERSCHLEISSFESTIGKEIT UND GUTE ZÄHIGKEIT -FÜR HOHE SCHNITTGESCHWINDIGKEITEN BEIM HALBSCHLICHTEN UND SCHLICHTEN	-HAUTE RÉSISTANCE À L'USURE ET BONNE TENACITÉ -INDIQUÉ POUR HAUTE VITESSE DE COUPE EN SEMIFINISSAGE ET FINISSAGE
-MICROGRAIN GRADE WITH VERY HIGH ULTIMATE STRENGTH AND RESISTANCE TO WEAR -SUITABLE FOR MEDIUM-HIGH CUTTING SPEEDS FOR FINISHING	-MIKROKORNSORTE MIT SEHR HOHER BRUCH- UND VERSCHLEISSFESTIGKEIT -FÜR HOHE SCHNITTGESCHWINDIGKEITEN BEIM SCHLICHTEN GEEIGNET	-QUALITÉ DE MICROGRAIN TRÈS RÉSISTANT À LA RUPTURE ET À L'USURE -INDIQUÉ POUR HAUTE VITESSE DE COUPE EN FINISSAGE
-HIGH RESISTANCE TO WEAR, HIGH STABILITY OF THE CUTTING EDGE, LOW TENDENCY TO STICKING -SUITABLE FOR MEDIUM CUTTING SPEEDS ON GRAY IRON AND HIGH CUTTING SPEEDS AND NONFERROUS MATERIALS.FOR ROUGHING WITH MEDIUM REMOVAL OF MATERIAL	-HOHE VERSCHLEISSFESTIGKEIT, HOHE STABILITÄT DER SCHNEIDE, NIEDRIGE NEIGUNG ZUR VERLEBUNG -FÜR MITTEL-NIEDRIGE SCHNITTGESCHWINDIGKEITEN BEI GRAUGUSS UND NE MATERIALIEN FÜR MITTLERE ZERSPANNUNG BEIM SCHRUPPEN GEEIGNET	-HAUTE RÉSISTANCE A' L'USURE, STABILITÉ ÉLEVÉE DU TRANCHANT, BASSE TENDANCE AU ENCOLLAGE -INDIQUÉE POUR MOYENNE-FAIBLE VITESSE DE COUPE SUR FONTE GRISE ET MATERIAL NON FERROUX, POUR MOYEN EMPORTATION EN ÉBAUCHAGE
- MICROGRAIN GRADE WITH GOOD WEAR RESISTANCE, HIGH CUTTING EDGE STABILITY, LOW TENDENCY TO STICKING - SUITABLE FOR LOW-MEDIUM CUTTING SPEEDS ON GREY CAST IRON AND OTHER NON-FERROUS MATERIALS	- FEINKORNSORTE MIT GUTER VERSCHLEISSBESTÄNDIGKEIT, HOHE ECKENSTABILITÄT, GERINGERE NEIGUNG ZUM KLEBEN - FÜR MITTLERE BIS NIEDRIGE SCHNITTGESCHWINDIGKEITEN FÜR GUSS UND ANDERE NICHT-EISENMATERIALIEN GEEIGNET	- QUALITE MICROGRAIN AVEC BONNE RESISTANCE A L'USURE ELEVEE, STABILITE DU FIL TRANCHANT, FAIBLE TENDANCE A L'ADHERENCE - INDIQUE POUR DES VITESSES HAUTES-MOYENNES DE COUPE SUR FONTE GRISE ET VITESSES HAUTES POUR DES MATERIAUX NON FERREUX
- MICROGRAIN GRADE WITH GOOD TOUGHNESS -SUITABLE FOR MEDIUM CUTTING SPEEDS AND HIGH FEED FOR ROUGHING WITH MEDIUM REMOVAL OF MATERIAL	-MIKROKORN SORTIE MIT GUTER ZÄHIGKEIT -FÜR MITTEL-NIEDRIGE SCHNITTGESCHWINDIGKEITEN GROSSE VORSCHÜBE FÜR MITTLERE ZERSPANNUNG BEIM SCHRUPPEN GEEIGNET	-QUALITÉ DE MICROGRAIN AVEC BONNE TENACITE -INDIQUÉE POUR MOYENNE-FAIBLE VITESSE DE COUPE ET HAUTE DÉPLACEMENT POUR MOYEN EMPORTATION EN ÉBAUCHAGE
- SPECIFIC GRADE FOR INOX STEEL, PARTICULARLY SUITABLE FOR SUPER-FINISHING - IT CAN BE USED FOR CAST IRON, ALUMINIUM AND HEAT-RESISTANT ALLOYS	- SPEZIALSORTE FÜR INOX-STAHL, BESONDERS ZUM FEIN-SCHLICHTEN GEEIGNET -EINSETZBAR FÜR GUSS, ALUMINIUM UND HITZEBESTÄNDIGE LEGIERUNGEN	- QUALITE SPECIFIQUE POUR L'USINAGE DES ACIERS INOX, SPECIALEMENT PREVUE POUR LES USINAGES DE SUPER FINITION - PEUT ETRE EMPLOYEE DANS LES USINAGES DE FONTE, ALUMINIUM ET ALLIAGES RESISTANTS A LA CHALEUR
- GRADE FOR A WIDE RANGE OF MATERIALS - SUITABLE FOR ROUGHING AND FINISHING	- SORTIE FÜR EINE VIELZAHL VON MATERIALIEN - FÜR SCHRUPPEN UND SCHLICHTEN GEEIGNET	- QUALITE POUR UNE VASTE GAMME DE MATERIAUX - PREVU POUR LES USINAGES DE DEGROSSISSAGE ET DE FINITION
- SPECIALLY DEVELOPED CARBIDE SUBSTRATE, INNOVATIVE PVD COATING - GRADE WITH EXCELLENT TOUGHNESS WHICH DOES NOT AFFECT RED HARDNESS AND WEAR RESISTANCE, AT BOTH LOW AND HIGH CUTTING SPEEDS	- SPEZIELL ENTWICKELTES KARBIDSUBSTRAT, INNOVATIVE PVD-BESCHICHTUNG. - SORTIE MIT HERVORRAGENDER ROBUSTHEIT BEI UNVERÄNDERTER WARMHÄRTE UND VERSCHLEISSBESTÄNDIGKEIT SOWOHL MIT NIEDRIGEN ALS AUCH MIT HOHEN SCHNITTGESCHWINDIGKEITEN	- SUBSTRAT DE CARBURE SPÉCIALEMENT DÉVELOPPÉ, REVÊTEMENT EN PVD INNOVANT. - QUALITÉ AVEC UNE ROBUSTESSE EXCELLENTE SANS PORTER PRÉJUDICE À LA DURETÉ À CHAUD ET À LA RÉSISTANCE À L'USURE À BASSES VITESSES COMME À HAUTES VITESSES DE COUPE
- SPECIALLY DEVELOPED CARBIDE SUBSTRATE - INNOVATIVE PVD COATING PROVIDING EXCELLENT STRENGTH AND VERY GOOD TOUGHNESS WITHOUT AFFECTING RED HARDNESS AT BOTH LOW AND HIGH CUTTING SPEED	- SPEZIELL ENTWICKELTES KARBID-SUBSTRAT - INNOVATIVE PVD-BESCHICHTUNG FÜR EXCELLENTE ROBUSTHEIT UND OPTIMALE ZÄHIGKEIT OHNE BEEINTRÄCHTIGUNG DER WARMHÄRTE BEI SOWOHL HOHEN ALS AUCH NIEDRIGEN SCHNITTGESCHWINDIGKEITEN	- SUBSTRAT DE CARBURE SPECIALEMENT DEVELOPPE - REVETEMENT EN PVD INNOVANT, FOURNIT UNE ROBUSTESSE ET TENACITE EXCELLENTE, SANS POUR AUTANT PORTER PREJUDICE A LA DURETE A CHAUD A DE BASSES COMME A DE HAUTES VITESSES DE COUPE.

SAU	DIN ISO 513		MATERIALE - MATERIAL MATÉRIEL - MATÉRIEL						PAG. 1063	QUICK PICK PAG. 120	 INDICAZIONI - USO			
			P	M	K	N	S	H						
			ACCI STEELS STAHL ACIER	ACCI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	GHISA CAST IRON GRAUGUSS FONTE GRISE	MAT NON FERROSI NON FERROUS MAT NICHT-EISENMATERIALIEN MAT. FERREUX	MAT DIFFICILI DIFFICULT MATERIAL SCHWERIGE MATERIALIEN MAT. DIFILES	MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATERIAUX DURS						
											Tenocità + Toughness -			
F8410	HC	M05-20		○				●			○	●	- ECCELLENTE RESISTENZA AL CALORE E ALL'USURA - IDEALE PER LAVORAZIONI DELLE SUPERLEGHE	
	PVD	S05-20												
T1415	HC	P05-25	●		○						○	●	- GRADO INSERTO IDEALE PER LA PRODUZIONE AD ALTO VOLUME - BUONA RESISTENZA AL CALORE CHE LO RENDE PERFETTAMENTE ADATTO PER LA LAVORAZIONE A SECCO ANCHE AD ALTE VELOCITÀ DI TAGLIO	
	CVD	K10-35												
T1425	HC	P15-35 M10-25 K25-35	●	○	○						○	●	- VASTA GAMMA DI IMPIEGHI, IDEALE PER TUTTE LE LEGHE DI ACCIAIO E GHISA, BUONE PRESTAZIONI ANCHE SU INOX	
	CVD													
T3210 NEW	HC	P01-10	○		●						●	○	- GRADO DA TORNITURA PER LA LAVORAZIONE DELLA GHIA GRIGIA E SFEROIDALE CON ELEVATA RESISTENZA ALL'USURA AD ELEVATE VELOCITÀ DI TAGLIO CON TAGLIO CONTINUO	
	CVD	K5-15												
T3220	HC	P01-20	○		●						○	●	- GRADO DA TORNITURA PER LA LAVORAZIONE DELLA GHIA GRIGIA E SFEROIDALE	
	CVD	K10-30												
T531	HC	P15-30 M20-40	○	●				●			○	●	- QUALITA' MICROGRANO TENACE CON BUONA RESISTENZA AGLI URTI ED AGLI SHOCK TERMICI - INDICATO PER MEDIE E MEDIO-BASSE VELOCITÀ DI TAGLIO	
	CVD													
F8110	HC							●				●	- QUALITA' RESISTENTE ALL'USURA, IDEALE PER LAVORAZIONI A TAGLIO NORMALE - INDICATO PER MATERIALI RESISTENTI AL CALORE	
	PVD	S01-20												
F8120	HC			○				●				●	- QUALITA' RESISTENTE ALL'USURA, IDEALE PER LAVORAZIONI A TAGLIO INTERROTTO - INDICATO PER MATERIALI RESISTENTI AL CALORE E INOX	
	PVD	M15-35 S10-30												
T1435	HC	P25-45 M20-30	●	○							●	●	- GRADO INSERTO TENACE PER LAVORAZIONI DIFFICILI CON CONDIZIONI INSTABILI E A TAGLIO INTERROTTO	
	CVD													
T1115	HC	P05-25	●									●	- QUALITA' PER LA TORNITURA DI ACCIAI IN GENERE, PER LAVORAZIONI DI FINITURA E SEMISGROSSATURA - DA UTILIZZARE IN CONDIZIONI DI TAGLIO NORMALI	
	CVD													

- APPLICAZIONE CONSIGLIATA
RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ
APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE
POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG
APPLICATION POSSIBLE
- APPLICAZIONE CONSIGLIATA
RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ
APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE
POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG
APPLICATION POSSIBLE

 INDICATIONS - USE	 GEBRAUCHSANWEISUNGEN	 INDICATION - USAGE
- EXCELLENT HEAT AND WEAR RESISTANCE - IDEAL FOR SUPER-ALLOYS	- EXCELLENTE HITZE- UND VERSCHLEISSBESTÄNDIGKEIT - IDEAL FÜR SUPER-LEGIERUNGEN	- RESISTANCE EXCELLENTE A LA CHALEUR ET A L'USURE - IDEAL POUR LES USINAGES DES SUPER-ALLIAGES
- IDEAL GRADE FOR HIGH VOLUME MACHINING - GOOD HEAT RESISTANCE AND THEREFORE PERFECTLY SUITABLE FOR DRY MACHINING, EVEN AT HIGH CUTTING SPEEDS	- IDEALE SORTE FÜR HOCHVOLUMENFERTIGUNG - GUTE HITZEBESTÄNDIGKEIT UND DAHER PERFECT FÜR DIE TROCKENBEARBEITUNG, AUCH MIT HOHEN SCHNITTGESCHWINDIGKEITEN	- DEGRÉ PLAQUETTE IDÉAL POUR LA PRODUCTION À HAUT VOLUME - BONNE RÉSISTANCE À LA CHALEUR, QUI LE REND PARFAITEMENT INDIQUÉ POUR L'USINAGE À SEC MÊME À DE HAUTES VITESSES DE COUPE
- WIDE RANGE OF APPLICATIONS, IDEAL FOR ALL STEEL AND CAST IRON ALLOYS, GOOD PERFORMANCE ALSO ON INOX	- HOHE VIELSEITIGKEIT, IDEAL FÜR ALLE STAHL- UND GUSSLEGIERUNGEN, GUTE LEISTUNG AUCH MIT INOXSTAHL	- VASTE GAMME D'EMPLOIS, IDÉAL POUR TOUS LES ALLIAGES EN ACIER ET FONTE, BONNES PERFORMANCES MÊME SUR INOX
- TURNING GRADE FOR THE MACHINING OF GREY AND NODULAR CAST IRON WITH HIGH WEAR RESISTANCE AT HIGH CUTTING SPEEDS WITH CONTINUOUS CUT	- DREHSORTE ZUR BEARBEITUNG VON GRAU- UND GRAPHITGUSS MIT HOHEM VERSCHLEISSWIDERSTAND BEI HOHEN SCHNITTGESCHWINDIGKEITEN MIT KONTINUIERLICHEM SCHNITT	- DEGRE DE TOURNAGE POUR LE TRAITEMENT DE LA FONTE GRISE ET SPHEROÏDALE AVEC UNE RESISTANCE ELEVEE A L'USURE A DE HAUTES VITESSES DE COUPE AVEC COUPE CONTINUE
- TURNING GRADE FOR GREY CAST IRON AND NODULAR CAST IRON	- DREHSORTE FÜR DIE BEARBEITUNG VON GUSS UND SPHÄROGUSS	- DEGRE DE TOURNAGE POUR L'USINAGE DE LA FONTE GRISE ET SPHEROÏDALE
-TOUGH MICROGRAIN GRADE WITH HIGH RESISTANCE TO SHOCK AND THERMAL SHOCK. -SUITABLE FOR MEDIUM AND MEDIUM-LOW CUTTING SPEEDS	-MIKROKORNSORTE MIT HOHER STOSSFESTIGKEIT UND TEMPERATURWECHSELBESTÄNDIGKEIT -FÜR MITTLERE UND MITTEL-NIEDRIGE SCHNITTGESCHWINDIGKEITEN GEEIGNET	-QUALITÉ DE MICROGRAIN TENACE AVEC BONNE RÉSISTANCE AU COUPS ET AU SHOCKS THERMIQUES. -INDIQUÉE POUR MOYENNE ET MOYENNE-FAIBLE VITESSE DE COUPE
- WEAR-RESISTANT GRADE, IDEAL FOR NORMAL CUTTING - SUITABLE FOR HEAT-RESISTANT MATERIALS	- VERSCHLEISSFESTE SORTE, IDEAL FÜR NORMALEN SCHNITT - FÜR HITZEBESTÄNDIGE MATERIALIEN GEEIGNET	-QUALITÉ RESISTANTE À L'USURE, IDEAL POUR USINAGE À COUPE NORMAL -INDIQUÉE POUR MATERIAUX RESISTANTES À LA CHALEUR
- WEAR-RESISTANT GRADE, IDEAL FOR INTERRUPTED CUTTING - SUITABLE FOR HEAT-RESISTANT MATERIALS AND STAINLESS STEEL	- VERSCHLEISSFESTE SORTE, IDEAL FÜR UNTERBROCHENEN SCHNITT - FÜR HITZEBESTÄNDIGE MATERIALIEN UND INOX-STAHL GEEIGNET	-QUALITÉ RESISTANTE À L'USURE, IDEAL POUR USINAGE À COUPE INTERROMPU -INDIQUÉE POUR MATERIAUX RESISTANTES À LA CHALEUR ET INOX
- TOUGH DEGREE FOR DIFFICULT MACHINING UNDER UNSTABLE CONDITIONS AND WITH INTERRUPTED CUT	- ZÄHE SORTE FÜR SCHWERE BEARBEITUNGEN UNTER UNSTABILEN BEDINGUNGEN UND MIT UNTERBROCHENEM SCHNITT	- DEGRÉ PLAQUETTE TENACE POUR USINAGES DIFFICILES DANS DES CONDITIONS INSTABLES ET À COUPE INTERROMPUE
-UNIVERSAL TURNING GRADE FOR STEEL, FOR FINISHING AND SEMI-ROUGHING -TO BE USED UNDER NORMAL CUTTING CONDITIONS	-ALLGEMEINE DREHSORTE FÜR STAHL, ZUM SCHLICHTEN UND HALBSCHRUPPEN -VERWENDBAR UNTER NORMALEN SCHNITTBEDINGUNGEN	-QUALITÉ POUR LE TOURNAGE DES ACIERS EN GENERAL, POUR FINISSAGE ET DEMIDEGROSSISAGE -À UTILIZER EN CONDITIONS DE COUPE NORMAL

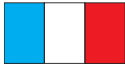
SAU	DIN ISO 513		MATERIALE - MATERIAL MATERIALIEN - MATÉRIAUX						QUICK PICK		 INDICAZIONI - USO		
			PAG. 1063						PAG. 120				
			P	M	K	N	S	H					
			ACCIAI STEELS STAHL ACIER	ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	GHISA CAST IRON GRAUGUSS FONTE GRISE	MAT NON FERROSI NON FERROUS MAT. NICHT-EISENMATERIALIEN MAT. FERREUX	MAT DIFFICILI DIFFICULT MATERIAL SCHWERIGE MATERIALIEN MAT. DIFCILES	MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATERIAUX DURS	Tenacità + Toughness -				
F8315	HC	M05-25		○			●			●	●	- QUALITÀ MICROGRANO IN PVD - ADATTO PER LA LAVORAZIONE DELLE SUPERLEGHE	
	PVD	S05-25											
T520T	HC	P15-35	●	●	●	●		○		●		- OTTIMA RESISTENZA ALL' USURA E BUONA TENACITÀ. - INDICATO PER MEDIO-BASSE VELOCITÀ DI TAGLIO E MEDIO-ALTI AVANZAMENTI	
	CVD	M10-30 K15-35											
T2335	HC	M25-45		●						●		- BUONA TENACITÀ E RESISTENZA ALL'USURA. - QUALITÀ IDEALE PER LA TORNITURA DI ACCIAI AUSTENITICI INOSSIDABILI.	
	CVD												
T540	HC	P25-45	●	●		○	○			●	●	- ALTA TENACITÀ, BUONA RESISTENZA ALL'USURA E ALLO SHOCK TERMICO - INDICATO PER BASSE VELOCITÀ DI TAGLIO E ALTI AVANZAMENTI IN SGROSSATURA PESANTE ANCHE IN CONDIZIONI PRECARIE.	
	CVD	M25-40											

● APPLICAZIONE CONSIGLIATA
RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ
APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE
POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG
APPLICATION POSSIBLE

● APPLICAZIONE CONSIGLIATA
RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ
APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE
POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG
APPLICATION POSSIBLE

 INDICATIONS - USE	 GEBRAUCHSANWEISUNGEN	 INDICATION - USAGE
-MICROGRAIN GRADE, PVD-COATED -SUITABLE FOR SUPER-ALLOYS	- MIKROKORNSORTE, PVD-BESCHICHTET - ZUR BEARBEITUNG VON SUPER-LEGIERUNGEN GEEIGNET	- QUALITE MICROGRAIN EN PVD - PREVUE POUR L'USINAGE DES SUPER-ALLIAGES
-EXCELLENT RESISTANCE TO WEAR AND GOOD TOUGHNESS -SUITABLE FOR MEDIUM-LOW CUTTING SPEEDS AND MEDIUM-HIGH FEED	-OPTIMAL VERSCHLEISSFESTIGKEIT UND GUTE ZÄHIGKEIT -FÜR MITTEL-NIEDRIGE SCHNITTGESCHWINDIGKEITEN MITTEL-GROSSE VORSCHÜBE	-OPTIMAL RÉSISTANCE À L'USURE ET BONNE TENACITÉ -INDIQUÉE POUR MOYENNE-FAIBLE VITESSE DE COUPE ET MOYENNE-HAUTE DÉPLACEMENT
-GOOD TOUGHNESS AND WEAR RESISTANCE -IDEAL GRADE FOR AUSTENITIC STAINLESS STEEL.	-GUTE ZÄHIGLEIT UND VERSCHLEISSFESTIGKEIT -IDEALE SORTE ZUM DREHEN VON AUSTENITISCHEM ROSTFREIEM STAHL	-BONNE TENACITÉ ET RESISTANCE À L'USURE -QUALITÉ IDEALE POUR LE TOURNAGE DES ACIERS AUSTENITICI INOXIDABLES
-HIGH TOUGHNESS, RESISTANCE TO WEAR AND TO THERMAL SHOCK -SUITABLE FOR LOW CUTTING SPEEDS AND HIGH FEED FOR ROUGHING AND HEAVY ROUGHING, EVEN UNDER UNSTABLE CONDITIONS	-FÜR MITTEL-HOHE SCHNITTGESCHWINDIGKEITEN UND BEI MITTLEREN VORSCHÜBEN UNTER NORMALEN BEDINGUNGEN GEEIGNET -FÜR NIEDRIGE SCHNITTGESCHWINDIGKEITEN UND GROSSVORSCHÜBE BEIM SCHRUPPEN UND STARKEN SCHRUPPEN, AUCH UNTER UNSTABILEN BEDINGUNGEN, GEEIGNET.	-HAUTE TENACITÉ, RÉSISTANCE À L'USURE ET AU SHOCK THERMIQUE -INDIQUÉE POUR FAIBLE VITESSE DE COUPE ET HAUT DÉPLACEMENT POUR ÉBAUCHAGE ET ÉBAUCHAGE LOURD, MÊME AVEC CONDITIONS INSTABLES.

HT CERMET

HW METALLO DURO NON RICOPERTO
UNCOATED CARBIDE
UNBESCHICHTETES HARTMETALL
MÉTAL DUR PAS RECOUVERT

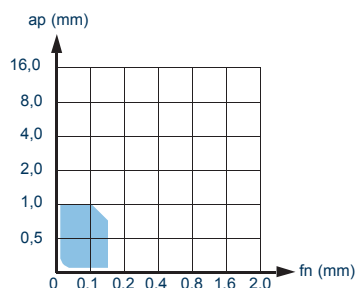
HC METALLO DURO RICOPERTO
COATED CARBIDE
BESCHICHTETES HARTMETALL
MÉTAL DUR RECOUVERT

MATERIALE MATERIAL MATERIALIEN MATERIAUX PAG 1063	VDI 3323 GR.	HB HRC Rm	C4010	DT61T	DT63	T110	T115	T120	F2120	T1625 NEW	F2425	F2435	F8410
P ACCIAI STEELS STAHL ACIER	1	125	230-270	320-600	310-400					450-680	130-250	170-190	
	2	180	230-270	300-560	260-350					450-680	130-250	170-190	
	3	250	230-270	270-430	220-300					450-680	130-250	170-190	
	4	220	230-270	300-450	220-330					300-500	130-250	170-190	
	5	300	230-270	220-340	180-280					300-500	130-250	170-190	
	6	180	230-270	250-420	250-350					200-450	130-250	90-150	
	7-8	250-300	180-230	160-300	200-300					200-450	60-180	90-150	
	9	350	180-230	130-200	150-220					200-450	60-180	90-150	
	10	200	160-200	150-310	200-350					200-400	80-200	120-200	
	11	350	160-200	130-200	150-220					200-400	80-200	120-200	
	12	200	230-270	260-320	180-300			80-150		200-400	120-250	140-180	
	13	330	170-240	160-240	150-250			40-70		200-400	120-250	140-180	
M ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	14.1	180	170-240	180-280	180-280			50-100	120-200	160-260	100-250	110-200	140-230
	14.2	230-260	130-160	130-230	100-150			50-90	60-160	160-260	40-160	55-150	60-100
K GHISA CAST IRON GRAUGUSS FONTE GRISE	15	180	200-300	220-260	200-300	120-160	120-160	100-150	120-160	110-180			
	16	260	200-300	130-170	150-260	90-140	120-160	70-120	120-160	110-180			
	17	160	220-300	200-240	180-300	130-170	130-170	100-140	120-160	110-180			
	18	250	220-300	150-200	150-240	90-130	130-170	80-120	120-160	110-180			
	19	130	250-350	230-300	170-280	140-200	140-200	120-180	140-220	110-180			
	20	230	250-350	130-170	150-220	120-160	140-200	70-120	120-160	110-180			
N MATRON FERROSI NONFERROUS MAT. NICHT-EISENMATERIALIEN MAT. FERREUX	21	60		500-900		300-950	100-950	300-800	100-400				
	22	100		500-900		300-950	100-950	300-800	100-400				
	23	75		500-900		400-950	100-950	300-800	100-400				
	24	90		500-900		400-950	100-950	300-800	100-400				
	25	130		500-900		200-800	100-800	300-800	100-400				
	26	110		500-900		250-600	100-800	400-550	100-400				
	27	90				200-600	100-300	400-550	100-400				
	28	100				150-400	100-300	200-400	100-400				
	29					80-180	100-950		100-600				
	30					100-250	100-950		100-600				
S MATDIFFICILI DIFFICULT MATERIAL SCHWIERIGE MATERIALIEN MAT. DIFFICILES	31	200					30-45		20-50				80-120
	32	280					20-35		20-50				60-100
	33	250					20-35		15-40				35-90
	34	350					18-30		20-35				30-50
	35	320					18-30		20-35				30-50
	36	Rm400				60-120	60-120		80-140				70-120
	37	Rm1050				30-60	60-120		80-140				70-120
H MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATERIAUX DURS	38	55HRC											
	39	60HRC											
	40	400											
	41	55HRC											

MATERIALE MATERIAL MATERIALIEN MATERIAUX PAG 1063	VDI 3323 GR.	HB HRC Rm	T1415	T1425	T3210 NEW	T3220	T531	F8110	F8120	T1435	T1115	F8315	T520T
P ACCIAI STEELS STAHL ACIER	1	125	220-400	170-240	250-550	200-340	200-300			170-190	380-560		280-450
	2	180	220-400	170-240	250-550	200-340	180-280			170-190	320-500		240-380
	3	250	220-400	170-240	250-550	200-340				170-190	290-430		200-330
	4	220	220-400	170-240	250-550	200-340				170-190	250-370		200-330
	5	300	220-400	170-240	250-550	200-340				170-190	260-380		170-270
	6	180	220-400	170-240	250-400	200-340				170-190	140-250		200-330
	7-8	250-300	200-320	100-190	220-340	150-290				90-150	100-160		140-270
	9	350	200-320	130-210	170-300	150-290				120-200	170-260		130-210
	10	200	180-320	130-210	200-350	160-290				120-200	100-150		140-230
	11	350	180-320	130-220	150-300	160-290				140-180	170-260		130-210
	12	200	200-320	130-220	180-320	160-290	130-180			140-180	150-230		170-270
	13	330	200-320	130-220	180-320	160-290	100-140			140-200	130-170		130-210
M ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	14.1	180		100-210			100-160	100-150	100-140	100-190		120-220	160-260
	14.2	230-260		70-100			80-120	70-130	75-120	50-150		50-90	130-210
K GHISA CAST IRON GRAUGUSS FONTE GRISE	15	180	140-370	130-210	250-550	150-400							130-210
	16	260	140-370	130-210	220-400	150-400							110-180
	17	160	190-430	120-240	220-420	200-450							110-180
	18	250	190-430	120-240	200-350	200-450							80-130
	19	130	180-520	150-250	220-400	200-550							130-210
	20	230	180-520	150-250	180-350	200-550							90-150
N MAT. NON FERROSI NONFERROUS MAT. NICHTEISENMATERIALIEN MAT. FERREUX	21	60											500-950
	22	100											500-950
	23	75											300-800
	24	90											300-800
	25	130											200-500
	26	110											200-500
	27	90											250-350
	28	100											200-300
	29												80-150
	30												100-200
S MAT. DIFFICILI DIFFICULT MATERIAL SCHWIERIGE MATERIALIEN MAT. DIFICILES	31	200					20-40	55-85	40-75			80-120	
	32	280					15-35	40-60	40-60			60-100	
	33	250					10-30	30-50	30-50			35-90	
	34	350					5-18	20-40	20-35			30-50	
	35	320					5-18	15-30	15-30			30-50	
	36	Rm400					80-130	30-55	25-45			70-120	
	37	Rm1050					20-40	20-40	15-35			70-120	
H MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATERIAUX DURS	38	55HRC											55-90
	39	60HRC											
	40	400											
	41	55HRC											

MATERIALE MATERIAL MATERIALIEN MATÉRIAUX PAG 1063	VDI 3323 GR.	HB HRC Rm	T2335	T540								
P ACCIAI STEELS STAHL ACIER	1	125		170-250								
	2	180		140-200								
	3	250		120-150								
	4	220		110-150								
	5	300		100-120								
	6	180		140-200								
	7-8	250-300		100-140								
	9	350		70-100								
	10	200		90-130								
	11	350		60-100								
	12	200		120-170								
	13	330		80-130								
M ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	14.1	180	80-120	70-180								
	14.2	230-260	70-100	60-130								
K GHISA CAST IRON GRAUGUSS FONTE GRISE	15	180										
	16	260										
	17	160										
	18	250										
	19	130										
	20	230										
N MAT NON FERROSI NON FERROUS MAT. NICHT-EISENMATERIALIEN MAT. FERREUX	21	60		300-950								
	22	100		300-700								
	23	75		300-700								
	24	90		300-500								
	25	130		250-350								
	26	110		400-500								
	27	90		250-350								
	28	100										
	29											
	30											
S MAT DIFFICILI DIFFICULT MATERIAL SCHWIERIGE MATERIALIEN MAT. DIFICILES	31	200		35-100								
	32	280		35-70								
	33	250										
	34	350		20-60								
	35	320		40-60								
	36	Rm400		40-60								
	37	Rm1050										
H MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATÉRIAUX DURS	38	55HRC										
	39	60HRC										
	40	400										
	41	55HRC										

MATERIALE MATERIAL MATERIALIEN MATERIAUX PAG 1063	VDI 3323 GR.	HB HRC Rm											
P ACCIAI STEELS STAHL ACIER	1	125											
	2	180											
	3	250											
	4	220											
	5	300											
	6	180											
	7-8	250-300											
	9	350											
	10	200											
	11	350											
	12	200											
	13	330											
M ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	14.1	180											
	14.2	230-260											
K GHISA CAST IRON GRAUGUSS FONTE GRISE	15	180											
	16	260											
	17	160											
	18	250											
	19	130											
	20	230											
N MATRON FERROSI NONFERROUS MAT. NICHTEISENMATERIALIEN MAT. FERREUX	21	60											
	22	100											
	23	75											
	24	90											
	25	130											
	26	110											
	27	90											
	28	100											
	29												
	30												
S MAT DIFFICILI DIFFICULT MATERIAL SCHWIERIGE MATERIALIEN MAT. DIFICOLES	31	200											
	32	280											
	33	250											
	34	350											
	35	320											
	36	Rm400											
	37	Rm1050											
H MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATERIAUX DURS	38	55HRC											
	39	60HRC											
	40	400											
	41	55HRC											



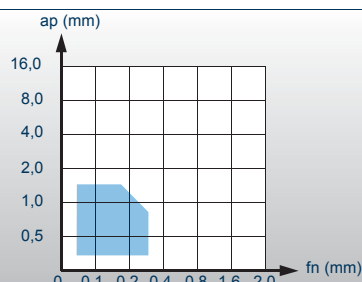
F	M	R			
			P	DT61T	
			M	DT61T	
			K	T120	
			N	T120	
			S		
			H		

GRADI CONSIGLIATI
 RECOMMENDED GRADES
 EMPFOHLENE SORTEN
 DEGRÉS CONSEILLÉS

				
F =	FINITURA, LAV. LEGGERE	FINISHING, LIGHT MACHINING	SCHLICHTEN, LEICHTE BEARBEITUNG	FINISSAGE USINAGES LÉGÈRES
M =	GENERICO, LAV. MEDIE	GENERIC MEDIUM MACHINING	ALLGEMEIN, MITTELSCHWERE BEARBEITUNG	GENERAL USINAGES MOYENS
R =	SGROSSATURA, LAV. PESANTI	ROUGHING, HEAVY MACHINING	SCHRUPPEN, SCHWERE BEARBEITUNG	DEGROSSISAGES, USINAGES LOURDS
P, M, K, N, S, H =	MATERIALI ISO PAG 1063	ISO MATERIALS PAGE 1063	ISO-MATERIEALIEN, SEITE 1063	MATERIAUX ISO PAG 1063
	TAGLIO CONTINUO	CONTINUOUS CUT	KONTINUIERLICHER SCHNITT	TRONÇONNAGE CONTINU
	TAGLIO DISCONTINUO	DISCONTINUOUS CUT	DISKONTINUIERLICHER SCHNITT	TRONÇONNAGE DISCONTINU
	TAGLIO INTERROTTO	INTERRUPTED CUT	UNTERBROCHENER SCHNITT	TRONÇONNAGE INTERROMPU
	APPLICAZIONE CONSIGLIATA	RECOMMENDED APPLICATION	EMPFOHLENER EINSATZ	APPLICATION CONSEILLÉE
	APPLICAZIONE POSSIBILE	POSSIBLE APPLICATION	MOGLICHE ANWENDUNG	APPLICATION POSSIBLE
ap (mm) =	PROFONDITÀ DI PASSATA	DEPTH OF CUT	GANGTIEFE	PROFONDEUR DE PASSE
fn (mm) =	AVANZAMENTO AL GIRO	FEED/REVOLUTION	VORSCHUB PRO UMDREHUNG	DÉPLACEMENT AU TOUR



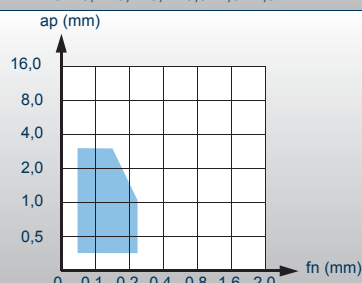
.B32



F	M	R			
			P	T1115	
			M		
			K		
			N		
			S		
			H		



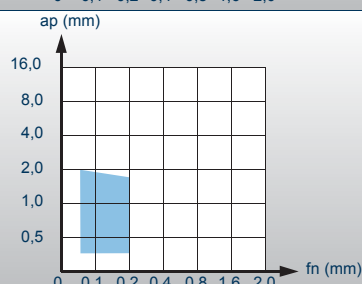
.G23



F	M	R			
			P		
			M	F2120	
			K	F2120	
			N	F2120	
			S	F2120	
			H		



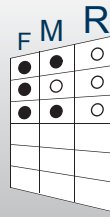
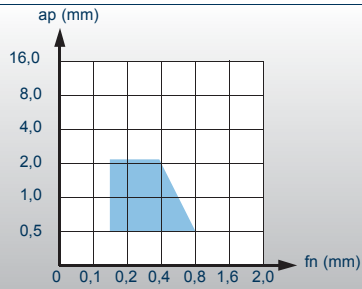
.G39



F	M	R			
			P	C4010	
			M	C4010	
			K	C4010	
			N		
			S		
			H		



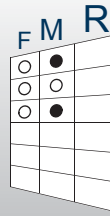
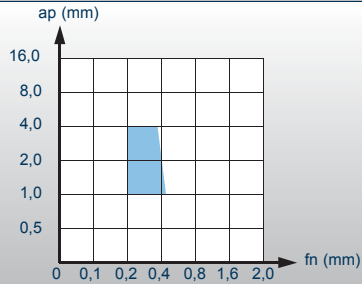
.G42
NEW



	○	□	⊗
P	T1415-T1425	T1425	
M	T1425	T1425	
K	T1415-T1425	T1425	
N			
S			
H			



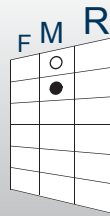
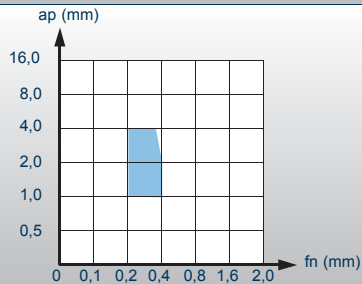
.G52



	○	□	⊗
P	T1415-T1425-T3220	T1425	
M	T1425	T1425	
K	T1415-T1425 T3210-T3220	T1425	
N			
S			
H			



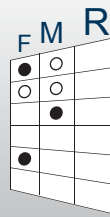
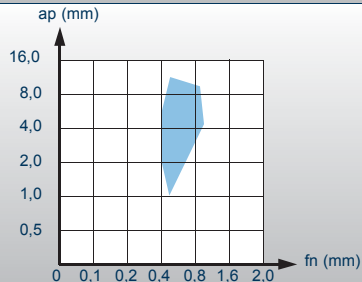
.G53



	○	□	⊗
P	F2425		
M	F2425		
K			
N			
S			
H			



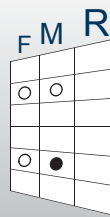
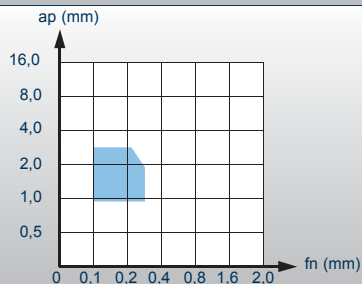
.G54



	○	□	⊗
P	T1425	T1425	
M	T1425-F8315-F8410	T1425-F8315	
K	T1425	T1425	T1425
N			
S	F8315-F8410	F8315	
H			



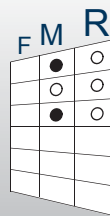
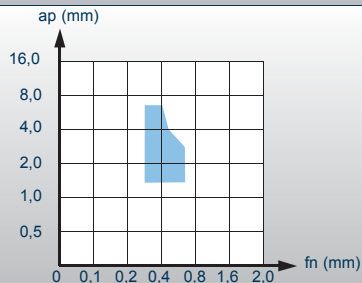
.G55



	○	□	⊗
P			
M	F8315-F8410	F8315-F8410	
K			
N			
S	F8315-F8410	F8315-F8410	
H			



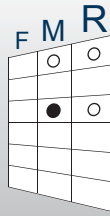
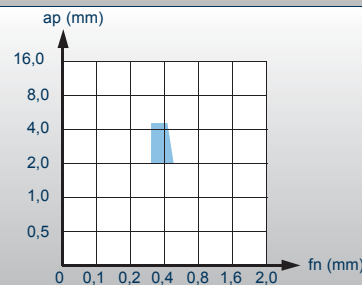
.G56



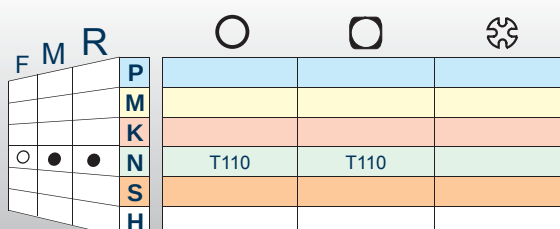
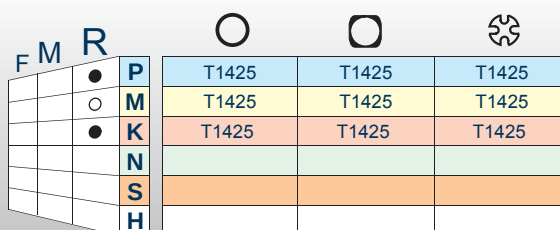
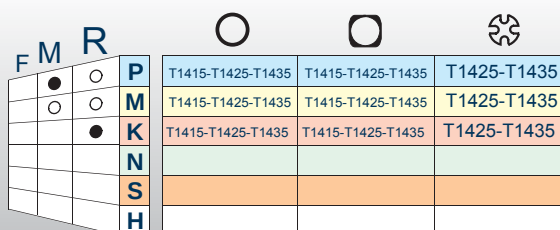
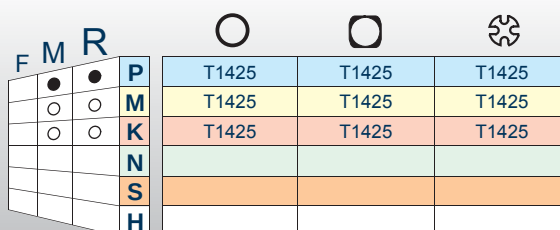
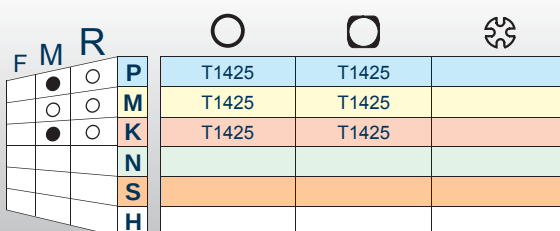
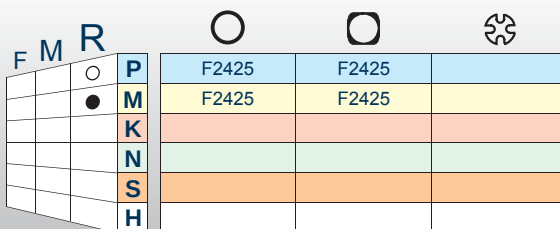
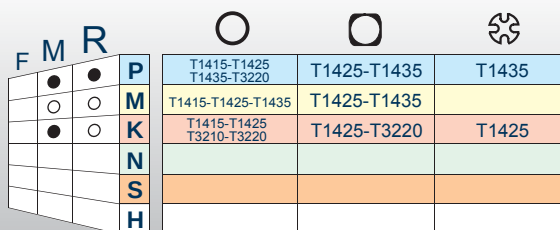
	○	□	⊗
P	T1415-T1425-T1435	T1415-T1425-T1435	T1425-T1435
M	T1415-T1425-T1435	T1415-T1425-T1435	T1425
K	T1415-T1425	T1415-T1425	T1425
N			
S			
H			

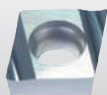


.G61

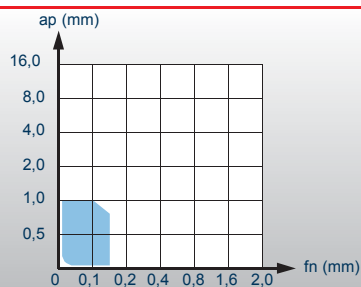


	○	□	⊗
P	T3220	T3220	
M			
K	T3220	T3220	
N			
S			
H			





.B22



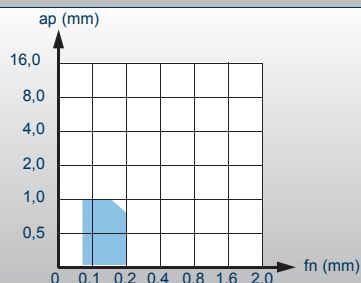
F	M	R
●		
●		
●		

P
M
K
N
S
H

○	□	⊗
DT63		
DT63-T531	T531	T531
DT63		



.B33



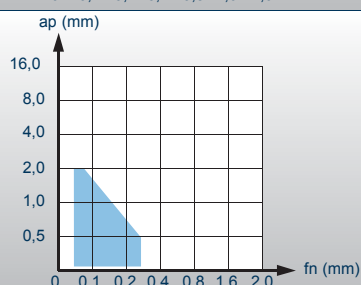
F	M	R
●		
●		

P
M
K
N
S
H

○	□	⊗
F8110	F8110	
F8110	F8110	



.B53



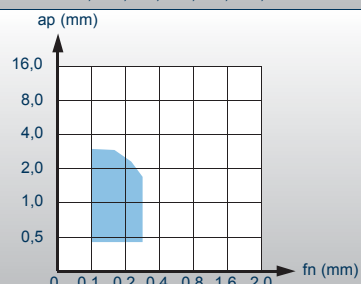
F	M	R
	●	
	●	

P
M
K
N
S
H

○	□	⊗
		F8120
		F8120



.B56



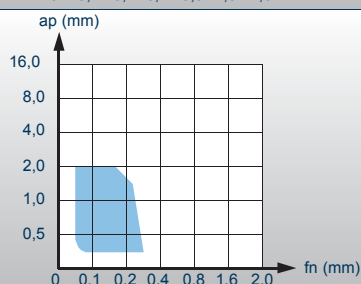
F	M	R
○	●	○
○	●	○

P
M
K
N
S
H

○	□	⊗
DT63		
DT63-T2335	T2335	



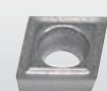
.D34



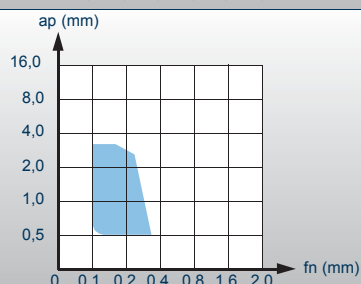
F	M	R
●		
●		

P
M
K
N
S
H

○	□	⊗
DT61T		
DT61T		



.D42



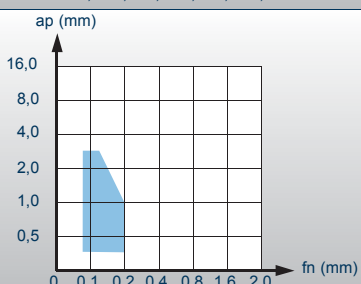
F	M	R
●	●	
●	●	
●	●	

P
M
K
N
S
H

○	□	⊗
T120	T120	
T120	T120	
T120	T120	



.G13



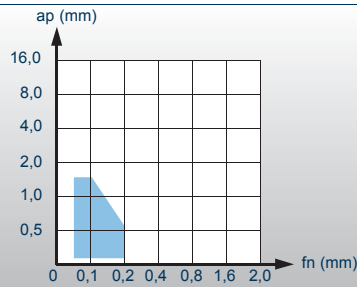
F	M	R
●		
○		
○		
○		

P
M
K
N
S
H

○	□	⊗
F2120	F2120	
F2120	F2120	
F2120	F2120	
F2120	F2120	



.G39

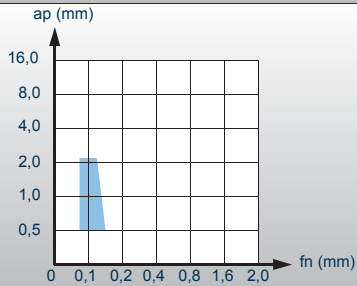


F	M	R
○		
●		
○		

	○	□	⊗
P	C4010		
M	C4010		
K	C4010		
N			
S			
H			



.G42

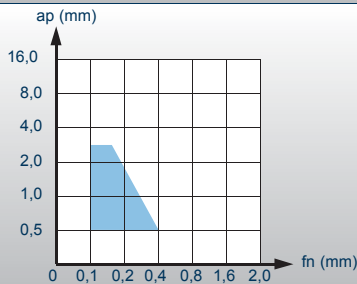


F	M	R
○		
●		
○		

	○	□	⊗
P	T1415-T1425-F2425	T1415-T1425-F2425	
M	T1425-F2425	T1425-F2425	
K	T1415-T1425	T1415-T1425	
N			
S			
H			



.G52

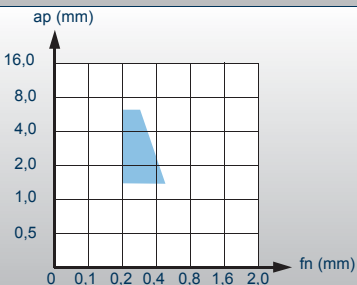


F	M	R
○	●	
○	●	
○	●	

	○	□	⊗
P	F2425-F2435-T1415 T1425-T1435-T3220	F2425-F2435-T1425 T1435-T3220	F2435-T1435
M	F2425-F2435 T1425-T1435	F2425-F2435 T1425-T1435	F2435-T1435
K	T3220-T1415-T1425	T3220-T1425	
N			
S			
H			



.G57P

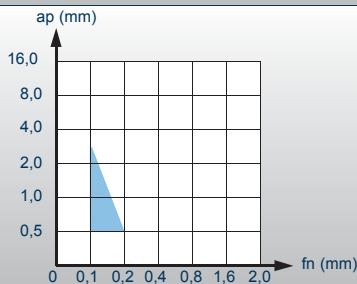


F	M	R
○	○	
○	○	
○	○	

	○	□	⊗
P			
M			
K	T115	T115	
N	T115	T115	
S	T115	T115	
H			



.G58

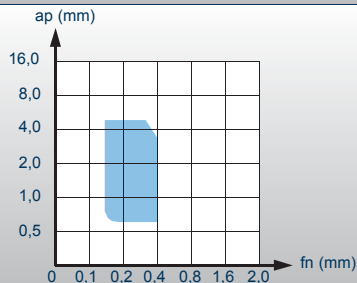


F	M	R
○	●	
○	○	
○	○	

	○	□	⊗
P	T1425-F2435	T1425-F2435	
M	T1425-F2435	T1425-F2435	
K	T1425-F2435	T1425-F2435	
N			
S			
H			



.S42

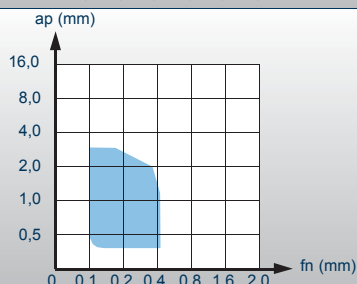


F	M	R
●	●	
●	●	
●	●	
●	●	

	○	□	⊗
P	T540	T540	T540
M	T540	T540	T540
K	T120	T120	T120
N	T120	T120	T120
S			
H			

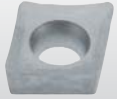


.S44

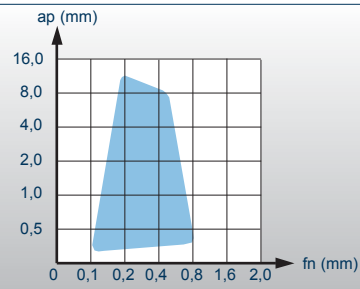


F	M	R
●	●	
●	○	
●	○	

	○	□	⊗
P	T520T-T1625	T520T-T1625	
M	T520T-T1625	T520T-T1625	
K	T520T-T1625	T520T-T1625	
N			
S			
H			



.Z57



F	M	R
●		
○	●	●

	○	□	⊗
P			
M			
K	T110	T110	T110
N	T110	T110	T110
S			
H			

C	N	M	G
1	2	3	4

12	04	08
5	6	7

-	-
8	9

W	5	2	P
10	11	12	13

1 FORMA INSERTO
SHAPE OF INSERT

A	85°	B	82°
C	80°	D	55°
E	75°	H	
K	55°	L	
M	86°	R	
S		T	
V	35°	W	

2 SPOGLIA INFER.
RELIEF ANGLE

A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°

3 TOLLERANZA+/- (mm)
TOLERANCE+/- (mm)

	m	s	d
A	+/-0,005	+/-0,025	+/-0,025
C	+/-0,013	+/-0,025	+/-0,025
E	+/-0,025	+/-0,025	+/-0,025
F	+/-0,005	+/-0,025	+/-0,013
G	+/-0,025	+/-0,05 +/-0,13	+/-0,025
H	+/-0,013	+/-0,025	+/-0,013
J	+/-0,005	+/-0,025	+/-0,05 +/-0,13
K	+/-0,013	+/-0,025	+/-0,05 +/-0,13
L	+/-0,05	+/-0,013	+/-0,025
M	+/-0,08 +/-0,18	+/-0,13	+/-0,05 +/-0,18
N	+/-0,08 +/-0,18	+/-0,025	+/-0,05 +/-0,13
U	+/-0,13 +/-0,38	+/-0,05 +/-0,13	+/-0,08 +/-0,32

4 TIPO INSERTO
TYPE OF INSERT

A	N
B	Q
C	R
F	T
G,P	U
H	W
J	X SPECIALE SPECIAL
M	

5 LUNGHEZZA TAGLIANTE
CUTTING EDGE LENGTH

Ød CERCHIO INSCRITTO INSCRIBED CIRCLE	A	C	D	E	K	L	M	R	S	T	V	W
3,97												02
4,76										08		02-03
5,56		05								09		
6,00												03
6,35		06	07	06			06		06	11	11	04
6,70	10									07		
7,94												
8,00				08				08				05
9,45	16											
9,52	15-16	09	11	09	16	15	09		09	16	16	06
10,00								10				06
11,00									11			
11,50						12						
12,00								12				07
12,62						18						
12,70		12	15	12	15-20				12	22		08
15,87		16							15			
19,05		19							19			
25,40		25							25			

6 SPESSORE
THICKNESS

S	mm
01	1,59
T1	1,97
02	2,38
T2	2,78
03	3,18
T3	3,97
04	4,76
05	5,56
06	6,35
07	7,94
09	9,52

7 RAGGIO
RADIUS

R	00 (")	MO (mm)
		r (mm)
00		r≤0,05
01		r=0,1
02		r=0,2
04		r=0,4
05		r=0,5
06		r=0,6
08		r=0,8
10		r=1,0
12		r=1,2
16		r=1,6
24		r=2,4
32		r=3,2

8

F
E
T
S

9

R
L
N

10 LETTERA DI IDENTIF.
IDENTIFICATION LETTER

A	N
C	P
D	R
E	S
H	T
I	U
J	W
K	Y
L	Z
M	

11 CAMPO DI LAVORAZIONE
MACHINING TYPES

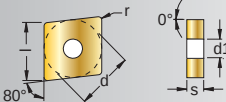
1	SUPERFINITURA SUPER-FINISHING
2	TAGLIANTE AFFILATO SHARP CUTTING EDGE
3	FINITURA FINISHING
4	GENERIC
5	GENERIC
6	GENERIC
7	SGROSSATURA ROUGHING

12 PREPARAZIONE TAGLIANTE
CUTTING EDGE PREPARATION

1 =	SPECIFICO PER GHISA SPECIFIC FOR CAST IRON
3 =	SPECIFICO PER ACCIAIO INOX SPECIFIC FOR STAINLESS STEEL
7 =	SPECIFICO PER LEGHE DI ALLUMINIO SPECIFIC FOR ALUMINIUM ALLOYS
9 =	SPECIFICO PER ACCIAIO SPECIFIC FOR STEEL
2 =	INTERMEDI DI USO GENERIC INTERMEDIATE FOR GENERAL USE
4 =	
5 =	
6 =	
8 =	

13

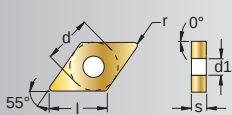
P =	LUCIDATO POLISH
W =	GEOMETRIA CON WIPER GEOMETRY WITH WIPER

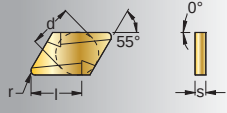
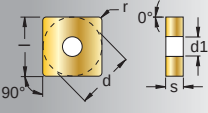
CNGP CNMA CNMG		HT		HW		HC																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
		CERMET		NON RIVESTITI CEMENTED CARBIDE GRADES		RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
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■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ **NEW**
 ● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION-
 EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

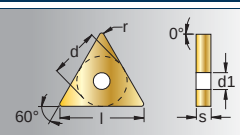
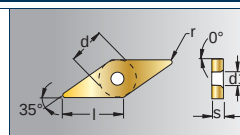
□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ **NEW**
 ○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION -
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

DNGP DNMG DNMM		HT		HW		HC																							
		CERMET		NON RIVESTITI CEMENTED CARBIDE GRADES		RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																							
INSERTI NEGATIVI - NEGATIVE INSERTS - NEGATIVE WENDEPLATTEN - PLAQUÉTTES NEGATIVES												C4010								F2120	F2425	F8410	T1415	T1425	T3220	T1435	T1115	F8315	
ART.	COD.	l	d	s	d1	r																							
 .G23	DNGP 110404 .G23	11,6	9,52	4,76	3,81	0,4																							
	DNGP 150602 .G23	15,5	12,7	6,35	5,16	0,2																							
	DNGP 150604 .G23	15,5	12,7	6,35	5,16	0,4																							
	DNGP 150608 .G23	15,5	12,7	6,35	5,16	0,8																							
 .B32	DNMG 150604 .B32	15,5	12,7	6,35	5,16	0,4																							
	DNMG 150608 .B32	15,5	12,7	6,35	5,16	0,8																							
 .G39	DNMG 150604 .G39	15,5	12,7	6,35	5,16	0,4	□																						
 .G42	DNMG 110404 .G42 <i>New</i>	11,6	9,52	4,76	3,81	0,4																							
	DNMG 150604 .G42 <i>New</i>	15,5	12,7	6,35	5,16	0,4																							
 .G52	DNMG 110404 .G52	11,6	9,52	4,76	3,81	0,4																							
	DNMG 110408 .G52	11,6	9,52	4,76	3,81	0,8																							
	DNMG 150604 .G52	15,5	12,7	6,35	5,16	0,4																							
	DNMG 150608 .G52	15,5	12,7	6,35	5,16	0,8																							
	DNMG 150612 .G52	15,5	12,7	6,35	5,16	1,2																							
 .G53	DNMG 110404 .G53	11,6	9,52	4,76	3,81	0,4																							
	DNMG 110408 .G53	11,6	9,52	4,76	3,81	0,8																							
	DNMG 150604 .G53	15,5	12,7	6,35	5,16	0,4																							
	DNMG 150608 .G53	15,5	12,7	6,35	5,16	0,8																							
 .G55	DNMG 150608 .G55	15,5	12,7	6,35	5,16	0,8																							
 .G56	DNMG 150608 .G56 <i>New</i>	15,5	12,7	6,35	5,16	0,8																							
	DNMG 150612 .G56 <i>New</i>	15,5	12,7	6,35	5,16	1,2																							
 .G62	DNMG 150608 .G62	15,5	12,7	6,35	5,16	0,8																							
 .G63	DNMG 150608 .G63	15,5	12,7	6,35	5,16	0,8																							
	DNMG 150612 .G63	15,5	12,7	6,35	5,16	1,2																							
 .G68	DNMM 150608 .G68 <i>New</i>	15,5	12,7	6,35	5,16	0,8																							
 .G72	DNMM 150612 .G72 <i>New</i>	15,5	12,7	6,35	5,16	1,2																							
MATERIALE - MATERIAL - MATERIALIEN - MATÉRIAUX							C4010										F2120	F2425	F8410	T1415	T1425	T3220	T1435	T1115	F8315				
P	ACCIAIO - STEEL - STAHL - ACIER						○											○		●	●	○		●	●				
M	ACCIAIO INOX - STAINLESS STEEL - ROSTFREIER STAHL - ACIER INOXYDABLE						●											●	●	○		○		○		○			
K	GHISA - CAST IRON - GRAUGUSS - FONTE GRISE						○											○		○	○	●							
N	LEGHE DI ALLUMINIO - ALUMINIUM ALLOYS - ALUMINIUM-LEGIERUNGEN - ALLIAGES D'ALUMINIUM																	○											
S	LEGHE RESISTENTI AL CALORE - HEAT RESISTANT ALLOYS - WÄRMEBESTÄNDIGE LEGIERUNGEN - ALLIAGES RÉISTANTES À LA CHALEUR																	○		●						●			
H	MATERIALI DURI E TEMPRATI - HARD AND HARDENED MATERIAL - HARTE UND GEHÄRTETE MATERIALIEN - MATERIAUX DURS ET TREMPÉS																												

KNUX	  SNMA SNMG SNMM												HT CERMET	HW NON RIVESTITI CEMENTED CARBIDE GRADES	HC RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																			
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■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ **NEW**
 ● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION-
 EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ **NEW**
 ○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION -
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

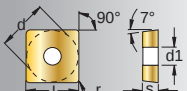
TNMA TNMG		VNGP VNMG		HT		HW		HC															
				CERMET		NON RIVESTITI CEMENTED CARBIDE GRADES		RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS															
INSERTI NEGATIVI - NEGATIVE INSERTS - NEGATIVE WENDEPLATTEN - PLAQUÉTTES NEGATIVES																							
ART.	COD.	l	d	s	d1	r																	
 .G61	TNMA 160408 .G61	16,5	9,52	4,76	3,81	0,8																	
 .B32	TNMG 160404 .B32	16,5	9,52	4,76	3,81	0,4																	
	TNMG 160408 .B32	16,5	9,52	4,76	3,81	0,8																	
 .G52	TNMG 160404 .G52	16,5	9,52	4,76	3,81	0,4																	
	TNMG 160408 .G52	16,5	9,52	4,76	3,81	0,8																	
	TNMG 160412 .G52	16,5	9,52	4,76	3,81	1,2																	
	TNMG 220404 .G52	22,0	12,70	4,76	5,16	0,4																	
	TNMG 220408 .G52	22,0	12,70	4,76	5,16	0,8																	
 .G53	TNMG 160404 .G53	16,5	9,52	4,76	3,81	0,4																	
	TNMG 160408 .G53	16,5	9,52	4,76	3,81	0,8																	
 .G55	TNMG 160408 .G55	16,5	9,52	4,76	3,81	0,8																	
 .G56	TNMG 160408 .G56	16,5	9,52	4,76	3,81	0,8																	
	TNMG 160412 .G56	16,5	9,52	4,76	3,81	1,2																	
 .G62	TNMG 160408 .G62	16,5	9,52	4,76	3,81	0,8																	
 .G63	TNMG 160408 .G63	16,5	9,52	4,76	3,81	0,8																	
	TNMG 160412 .G63	16,5	9,52	4,76	3,81	1,2																	
 .G23	VNGP 160402 .G23	16,6	9,52	4,76	3,81	0,2																	
	VNGP 160404 .G23	16,6	9,52	4,76	3,81	0,4																	
 .G42	VNMG 160404 .G42	16,6	9,52	4,76	3,81	0,4																	
	NEW																						
 .G52	VNMG 160404 .G52	16,6	9,52	4,76	3,81	0,4																	
	VNMG 160408 .G52	16,6	9,52	4,76	3,81	0,8																	
 .G53	VNMG 160408 .G53	16,6	9,52	4,76	3,81	0,8																	
 .G55	VNMG 160408 .G55	16,6	9,52	4,76	3,81	0,8																	
MATERIALE - MATERIAL - MATERIALIEN - MATÉRIAUX																							
P	ACCIAIO - STEEL - STAHL - ACIER																						
M	ACCIAIO INOX - STAINLESS STEEL - ROSTFREIER STAHL - ACIER INOXYDABLE																						
K	GHISA - CAST IRON - GRAUGUSS - FONTE GRISE																						
N	LEGHE DI ALLUMINIO - ALUMINIUM ALLOYS - ALUMINIUM-LEGIERUNGEN - ALLIAGES D'ALUMINIUM																						
S	LEGHE RESISTENTI AL CALORE - HEAT RESISTANT ALLOYS - WÄRMEBESTÄNDIGE LEGIERUNGEN - ALLIAGES RÉISTANTES À LA CHALEUR																						
H	MATERIALI DURI E TEMPRATI - HARD AND HARDENED MATERIAL - HARTE UND GEHÄRTETE MATERIALIEN - MATERIAUX DURS ET TREMPÉS																						

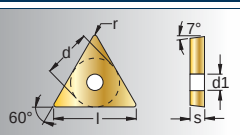
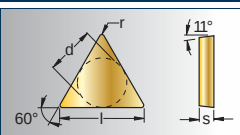
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■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION-
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

☐ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / ☒ NEW
☐ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION -
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

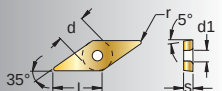
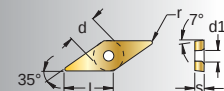
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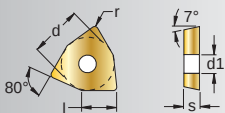
RCGT RCMT			SCGT SCMT			HT CERMET		HW NON RIVESTITI CEMENTED CARBIDE GRADES		HC RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
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TCGT TCMT		TPMR		HT		HW		HC																	
				CERMET		NON RIVESTITI CEMENTED CARBIDE GRADES		RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																	
				INSERTI POSITIVI - POSITIVE INSERTS - POSITIVE WENDEPLATTEN - PLAQUÉTTES POSITIVES																					
ART.	COD.	l	d	s	d1	r	C4010				T110	T115	T120	T1625	F2425	F2435	T1415	T1425	T3220		T1435		T520T	T540	
	TCGT 110202 .G39	11,0	6,35	2,38	2,8	0,2	■																		
	.G39																								
	TCGT 090202 .G57P	9,6	5,56	2,38	2,5	0,2						■													
	TCGT 090204 .G57P	9,6	5,56	2,38	2,5	0,4						■													
	TCGT 110204 .G57P	11,0	6,35	2,38	2,8	0,4						■													
	TCGT 16T304 .G57P	16,5	9,52	3,97	4,4	0,4						■													
	TCGT 16T308 .G57P	16,5	9,52	3,97	4,4	0,8						■													
	NEW																								
	TCGT 110202 FN .Z57	11,0	6,35	2,38	2,8	0,2						■													
	TCGT 110204 FN .Z57	11,0	6,35	2,38	2,8	0,4						■													
	TCGT 16T302 FN .Z57	16,5	9,52	3,97	4,4	0,2						■													
	TCGT 16T304 FN .Z57	16,5	9,52	3,97	4,4	0,4						■													
	TCGT 16T308 FN .Z57	16,5	9,52	3,97	4,4	0,8						■													
	TCMT 110204 .G39	11,0	6,35	2,38	2,8	0,4	■																		
	TCMT 110202 .S42	11,0	6,35	2,38	2,8	0,2																		■	
	TCMT 110204 .S42	11,0	6,35	2,38	2,8	0,4							■											■	
	TCMT 16T304 .S42	16,5	9,52	3,97	4,4	0,4							■												
	TCMT 16T308 .S42	16,5	9,52	3,97	4,4	0,8							■											■	
	TCMT 220404 .S42	22,0	12,7	4,76	5,6	0,4							■												
	TCMT 090204 .G52	9,6	5,56	2,38	2,5	0,4									■				■	■					
	TCMT 110204 .G52	11,0	6,35	2,38	2,8	0,4									■	■	■	■	■		■				
	TCMT 110208 .G52	11,0	6,35	2,38	2,8	0,8									■	■		■	■		■				
	TCMT 16T304 .G52	16,5	9,52	3,97	4,4	0,4									■			■	■		■				
	TCMT 16T308 .G52	16,5	9,52	3,97	4,4	0,8									■			■	■		■				
	TCMT 16T312 .G52	16,5	9,52	3,97	4,4	1,2									■			■	■						
	TPMR 110304 .S44	11,0	6,35	3,18	–	0,4									■										
	TPMR 110308 .S44	11,0	6,35	3,18	–	0,8									■										
	TPMR 160304 .S44	16,5	9,52	3,18	–	0,4																	■		
	TPMR 160308 .S44	16,5	9,52	3,18	–	0,8																	■		
MATERIALE - MATERIAL - MATERIALIEN - MATÉRIAUX							C4010				T110	T115	T120	T1625	F2425	F2435	T1415	T1425	T3220		T1435		T520T	T540	
P	ACCIAIO - STEEL - STAHL - ACIER						○								●	○	○	●	●	○		●		●	●
M	ACCIAIO INOX - STAINLESS STEEL - ROSTFREIER STAHL - ACIER INOXYDABLE						●						○		○	●	●		○			○		○	●
K	GHISA - CAST IRON - GRAUGUSS - FONTE GRISE						○				○	○	●		○			○	○	●				●	
N	LEGHE DI ALLUMINIO - ALUMINIUM ALLOYS - ALUMINIUM-LEGIERUNGEN - ALLIAGES D'ALUMINIUM										●	●	○											○	
S	LEGHE RESISTENTI AL CALORE - HEAT RESISTANT ALLOYS - WÄRMEBESTÄNDIGE LEGIERUNGEN - ALLIAGES RÉISTANTES À LA CHALEUR										○	○	○											○	
H	MATERIALI DURI E TEMPRATI - HARD AND HARDENED MATERIAL - HARTE UND GEHÄRTETE MATERIALIEN - MATERIAUX DURS ET TREMPÉS																								

■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
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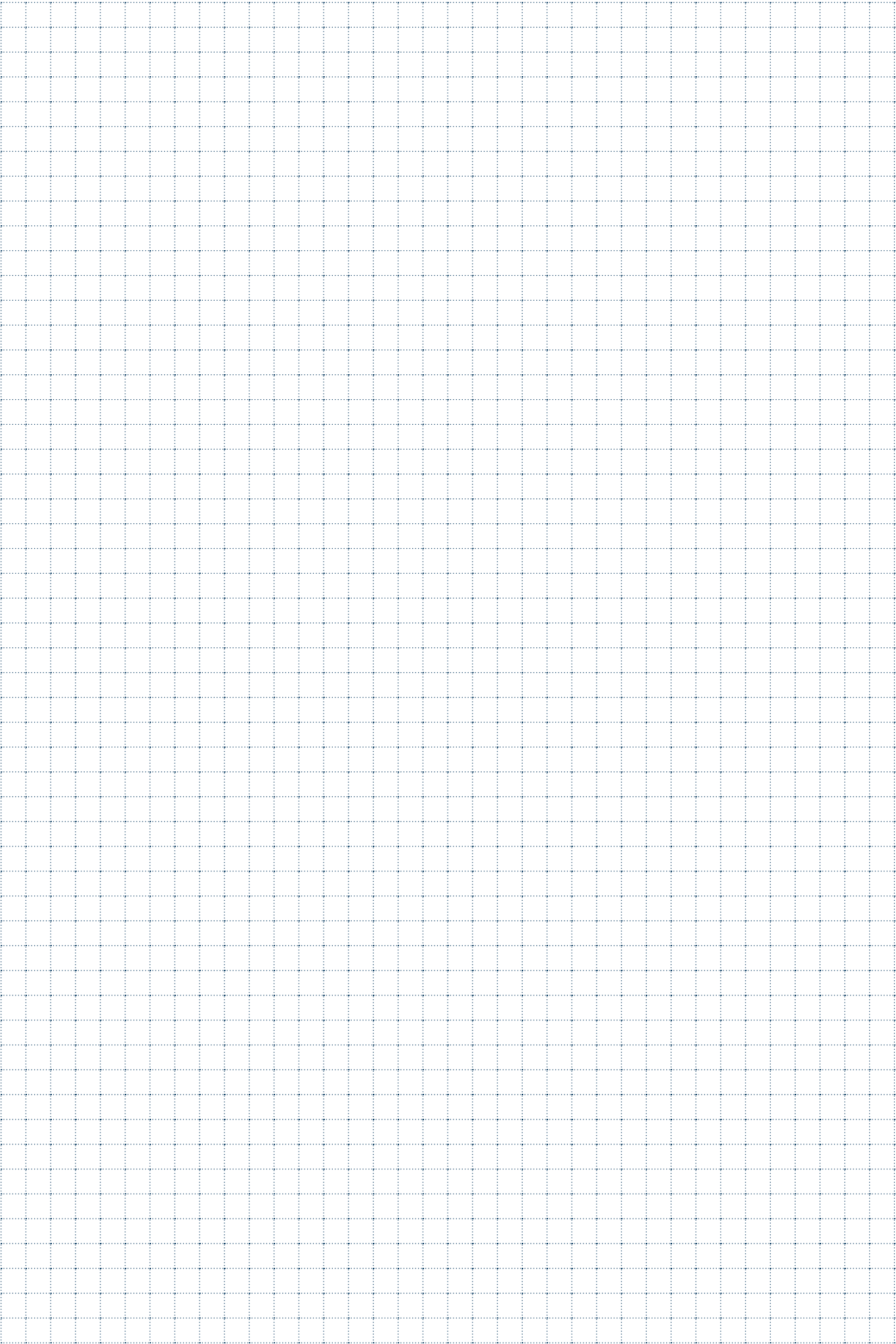
□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW
 ○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION -
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

VBMT		VCGT VCMT		HT		HW		HC																								
				CERMET		NON RIVESTITI CEMENTED CARBIDE GRADES		RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																								
				INSERTI POSITIVI - POSITIVE INSERTS - POSITIVE WENDEPLATTEN - PLAQUÉTTES POSITIVES																												
ART.	COD.	l	d	s	d1	r				T110	T115		F2120	F2425	F2435	T1415	T1425															
 .G42	VBMT 160404 .G42	16,5	9,52	4,76	4,4	0,4								■		■	■									■						
	VBMT 160408 .G42	16,5	9,52	4,76	4,4	0,8								■		■	■									■						
	NEW																															
 .G52	VBMT 160404 .G52	16,5	9,52	4,76	4,4	0,4								■		■	■									■						
	VBMT 160408 .G52	16,5	9,52	4,76	4,4	0,8								■		■	■									■						
	NEW																															
 .G58	VBMT 160404 .G58	16,5	9,52	4,76	4,4	0,4									■		■															
	VBMT 160408 .G58	16,5	9,52	4,76	4,4	0,8									■		■															
 .G13	VCGT 110300 .G13	11,1	6,35	3,18	2,9	0,0								■																		
	VCGT 110301 .G13	11,1	6,35	3,18	2,9	0,1								■																		
	VCGT 160400 .G13	16,5	9,52	4,76	4,4	0,0								■																		
	VCGT 160401 .G13	16,5	9,52	4,76	4,4	0,1								■																		
 .G57P	VCGT 110302 .G57P	11,1	6,35	3,18	2,9	0,2					■																					
	VCGT 110304 .G57P	11,1	6,35	3,18	2,9	0,4					■																					
	VCGT 160404 .G57P	16,5	9,52	4,76	4,4	0,4					■																					
	VCGT 160408 .G57P	16,5	9,52	4,76	4,4	0,8					■																					
	VCGT 160412 .G57P	16,5	9,52	4,76	4,4	1,2					■																					
 .Z57	VCGT 110302 FN .Z57	11,1	6,35	3,18	2,9	0,2					■																					
	VCGT 110304 FN .Z57	11,1	6,35	3,18	2,9	0,4					■																					
	VCGT 110308 FN .Z57	11,1	6,35	3,18	2,9	0,8					■																					
	VCGT 160404 FN .Z57	16,5	9,52	4,76	4,4	0,4					■																					
	VCGT 160408 FN .Z57	16,5	9,52	4,76	4,4	0,8					■																					
	VCGT 160412 FN .Z57	16,5	9,52	4,76	4,4	1,2					■																					
 .G42	VCMT 110302 .G42	11,1	6,35	3,18	2,9	0,2								■			■															
	VCMT 110304 .G42	11,1	6,35	3,18	2,9	0,4								■			■															
	VCMT 160404 .G42	16,5	9,52	4,76	4,4	0,4								■			■															
 .G52	VCMT 110304 .G52	11,1	6,35	3,18	2,9	0,4								■	■	■	■									■						
	VCMT 110308 .G52	11,1	6,35	3,18	2,9	0,8								■	■	■	■									■						
	VCMT 160404 .G52	16,5	9,52	4,76	4,4	0,4								■		■	■								■							
	VCMT 160408 .G52	16,5	9,52	4,76	4,4	0,8								■	■	■	■								■							
MATERIALE - MATERIAL - MATERIALIEN - MATÉRIAUX										T110	T115		F2120	F2425	F2435	T1415	T1425							T1435								
P	ACCIAIO - STEEL - STAHL - ACIER													○	○	●	●								●							
M	ACCIAIO INOX - STAINLESS STEEL - ROSTFREIER STAHL - ACIER INOXYDABLE													●	●	●		○							○							
K	GHISA - CAST IRON - GRAUGUSS - FONTE GRISE									○	○			○			○	○														
N	LEGHE DI ALLUMINIO - ALUMINIUM ALLOYS - ALUMINIUM-LEGIERUNGEN - ALLIAGES D'ALUMINIUM										●	●		○																		
S	LEGHE RESISTENTI AL CALORE - HEAT RESISTANT ALLOYS - WÄRMEBESTÄNDIGE LEGIERUNGEN - ALLIAGES RÉISTANTES À LA CHALEUR										○	○		○																		
H	MATERIALI DURI E TEMPRATI - HARD AND HARDENED MATERIAL - HARTE UND GEHÄRTETE MATERIALIEN - MATERIAUX DURS ET TREMPÉS																															

WCGT WCMT							HT		HW		HC																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
							CERMET		NON RIVESTITI CEMENTED CARBIDE GRADES		RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
INSERTI POSITIVI - POSITIVE INSERTS - POSITIVE WENDEPLATTEN - PLAQUÉTTES POSITIVES																			C4010	DT63																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																					

■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
 ● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION-
 EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW
 ○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION -
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE



SCELTA VELOCE QUICK PICK

Tenacità +
Toughness -



- METODO PER LA SCELTA VELOCE DEL GRADO DI METALLO DURO PIÙ IDONEO. CONTARE IL NUMERO DI RETTANGOLI COLORATI
- METHOD FOR A QUICK CHOICE OF THE MOST SUITABLE SOLID CARBIDE GRADE. COUNT THE NUMBER OF COLORED RECTANGLES
- METHODE ZUR RASCHEN AUSWAHL DER GEEIGNETSTEN HARTMETALLSORTE. DIE ANZAHL DER BUNTEN RECHTECKE ZÄHLEN
- METHODE POUR CHOISIR RAPIDEMENT LE DEGRÉ LE PLUS APPROPRIÉ DU METAL DUR. COMPTER LES RECTANGLES EN COULEURS
- METODO PARA LA ELECCION RAPIDA DE EL GRADO MAS ADECUADO DE METAL DURO. CONTAR LOS NUMEROS DE RECTANGULOS COLORADOS

- GRADO MOLTO RESISTENTE ALL'USURA, SOLO PER FINITURA, LAVORAZIONI AD ALTE VELOCITÀ DI TAGLIO E CONDIZIONI MOLTO RIGIDE E STABILI
- GRADE WITH HIGH RESISTANCE TO WEAR; ONLY FOR FINISHING, MACHINING AT HIGH CUTTING SPEEDS, AND VERY RIGID AND STABLE CONDITIONS
- GRADO CON ALTA RESISTENZA ALL'USURA, DISCRETA TENACITÀ PER LAVORAZIONI A VELOCITÀ MEDIO ALTE ED AVANZAMENTI MEDI, IN CONDIZIONI NORMALI
- GRADE WITH HIGH RESISTANCE TO WEAR, GOOD TOUGHNESS, FOR MEDIUM-HIGH MACHINING AND MEDIUM FEED UNDER NORMAL CONDITIONS
- GRADO CON BUONA RESISTENZA ALL'USURA UNITA A BUONA TENACITÀ, PER LAVORAZIONI GENERICHE IN CONDIZIONI NORMALI
- GRADE WITH GOOD RESISTANCE TO WEAR; COMBINED WITH A GOOD DEGREE OF TOUGHNESS, FOR GENERAL MACHINING UNDER NORMAL CONDITIONS
- GRADO CON OTTIMA TENACITÀ PER LAVORAZIONI MEDIO PESANTI O IN CONDIZIONI POCO STABILI
- GRADE WITH EXCELLENTE TOUGHNESS, FOR MEDIUM HEAVY MACHINING OR MACHINING UNDER CONDITIONS OF LOW STABILITY
- GRADO CON ECCEZIONALE TENACITÀ PER LAVORAZIONI PESANTI CON BASSE VELOCITÀ DI TAGLIO, ALTI AVANZAMENTI O IN CONDIZIONI SFAVOREVOLI
- GRADE WITH EXCELLENTE TOUGHNESS, FOR HEAVY MACHINING WITH LOW CUTTING SPEEDS, HIGH FEED, OR UNDER UNFAVORABLE CONDITIONS

GUIDA FACILE EASY GUIDE

SAU QUALITY TOOLS ENGINEERING

GX16-3E4.00N-0.40 .Z32 - T5226

fn = 0,1-0,3 mm

F	M	R	P	Vc = 120-200 m/min
●	○	○	M	Vc = 100-170 m/min
●	○	○	K	Vc = 80-150 m/min
			N	
			S	
			H	

P15-35 / M05-25 / K15-35

T5226

- GUIDA ALL'USO DELL'INSERTO. PRESENTE ANCHE SU OGNI ETICHETTA
- GUIDE FOR THE USE OF THE INSERT. ALSO LISTED ON EACH LABEL
- LEITFADEN ZUR VERWENDUNG DER WENDEPLATTE, AUCH AUF JEDEM AUFKLEBER VORHANDEN
- INSTRUCTIONS POUR L'UTILISATION DE LA PLAQUETTE. SE TROUVANT EGALEMENT SUR CHAQUE ETIQUETTE
- GUIA POR EL UTILIZO DE LA PLAQUITA, PRESENTE TAMBIEN EN CADA ETIQUETA

GR. VDI 3323 MATERIALI MATERIALS Pag. 1063	6	P	= ACCIAIO BASSO LEGATO HB 180	- LOW STEEL ALLOY
	14.1	M	= ACCIAIO INOSSIDABILE AUSTENITICO HB 180	- AUSTENITIC STAINLESS STEEL HB 180
	16	K	= GHISA GRIGIA HB 260	- GRAY CAST IRON HB 260
	21	N	= LEGHE DI ALLUMINIO HB 60	- ALUMINUM ALLOYS HB 60
	33	S	= LEGHE RESISTENTI AL CALORE (INCONEL) HB 250	- HEAT RESISTANT ALLOYS (INCONEL) HB 250
	38	H	= ACCIAIO TEMPRATO HRC 55	- TEMPERED STEEL HRC 55
	F		= FINITURA, LAVORAZIONI LEGGERE	- FINISHING, LIGHT MACHINING
	M		= LAVORAZIONI MEDIE, IMPIEGO GENERICO	- MEDIUM MACHINING, GENERAL USE
	R		= SGROSSATURA, LAVORAZIONI PESANTI	- ROUGHING, HEAVY MACHINING
	fn (mm)		= AVANZAMENTO PER TORNITURA	- FEED FOR TOURNING
	fz (mm/z)		= AVANZAMENTO PER FRESATURA	- FEED FOR MILLING
	Vc (m/min)		= VELOCITÀ DI TAGLIO	- CUTTING SPEED
	●		= APPLICAZIONE CONSIGLIATA	- RECOMMENDED APPLICATION
	○		= APPLICAZIONE POSSIBILE	- POSSIBLE APPLICATION

INSERTI PER TAGLIO SCANALATURA

PARTING-GROOVING INSERTS / WENDEPLATTEN ZUM A BSTECHEN-NUTENDREHEN
PLAQUÉTTES DE TRONÇONNAGE-GORGES / PLAQUITAS DE CORTE-RANURAS



	COME SCEGLIERE I PARAMETRI DI LAVORO	Pag. 159
	PANORAMICA QUALITÀ TAGLIO-SCANALATURA	Pag. 161
	IMPIEGO DELLE QUALITÀ TAGLIO-SCANALATURA	Pag. 162
	VELOCITÀ DI TAGLIO DELLE QUALITÀ TAGLIO-SCAN.	Pag. 164
	CAMPI DI IMPIEGO DEI ROMPIRUCIOLI TAGLIO-SCAN.	Pag. 166
	DENOMINAZIONI DEGLI INSERTI TAGLIO-SCAN.-FILETTATURA	Pag. 170
	CATALOGO DISPONIBILITÀ INSERTI TAGLIO-SCAN.	Pag. 171

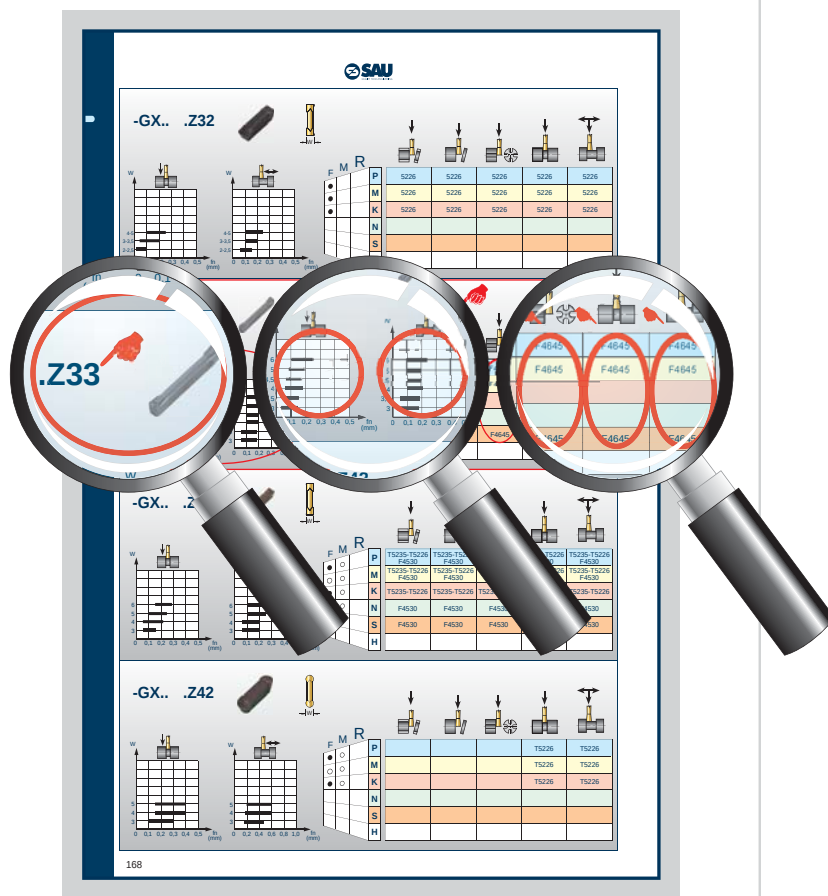
	HOW TO CHOOSE CUTTING DATA	Pag. 159
	GENERAL VIEW OF THE PARTING-GROOVING GRADE	Pag. 161
	APPLICATION OF THE PARTING-GROOVING GRADE	Pag. 162
	CUTTING SPEED OF PARTING-GROOVING GRADES	Pag. 164
	FIELDS OF APPLICATION FOR CHIP BREAKERS,PARTING-GROOVING	Pag. 166
	INSERTS DESIGNATION FOR PARTING-GROOVING-THREADING	Pag. 170
	PARTING-GROOVING INSERTS STOCK CATALOGUE	Pag. 171

	EINSTELLUNG DER SCHNITTDATEN	Pag. 159
	ABSTECHEN-NUTENDREHEN-ÜBERSICHT	Pag. 161
	EINSATZ DER ABSTECHEN-NUTENDREHEN	Pag. 162
	EINSATZBEREICHE DER SPANBRECHER (VC)	Pag. 164
	SCHNITTGESCHWINDIGKEIT ABSTECHEN-NUTENDREHEN	Pag. 166
	BEZEICHNUNG DER WENDEPLATTEN ZUM ABSTECHEN NUNTENDREHEN UND GEWINDESCHNEIDEN	Pag. 170
	AB LAGER LIEFERBARE WENDEPLATTEN ZUM STECH-UND NUTENDREHEN	Pag. 171

	COMMENT CHOISIR LES PARAMETRES DE SERVICE	Pag. 159
	VUE D'ENSEMBLE QUALITÉ DE TRONÇONNAGE-GORGES	Pag. 161
	UTILISATION DE LES QUALITÉES DE TRONÇONNAGE-GORGES	Pag. 162
	VITESSE DE COUPE DE LA QUALITÉ DE PLAQUETTES DE TRONÇONNAGE-GORGES	Pag. 164
	CHAMPS D'USINAGE DE LE BRISE-COPEAUX TRONÇONNAGE-GORGES	Pag. 166
	DÉNOMINATION DE LES PLAQUETTES POUR LE TRONÇONNAGE-GORGES-FILETAGE	Pag. 170
	CATALOGUE DE DISPONIBILITÉ PLAQUETTES DE TRONÇONNAGE-GORGES	Pag. 171

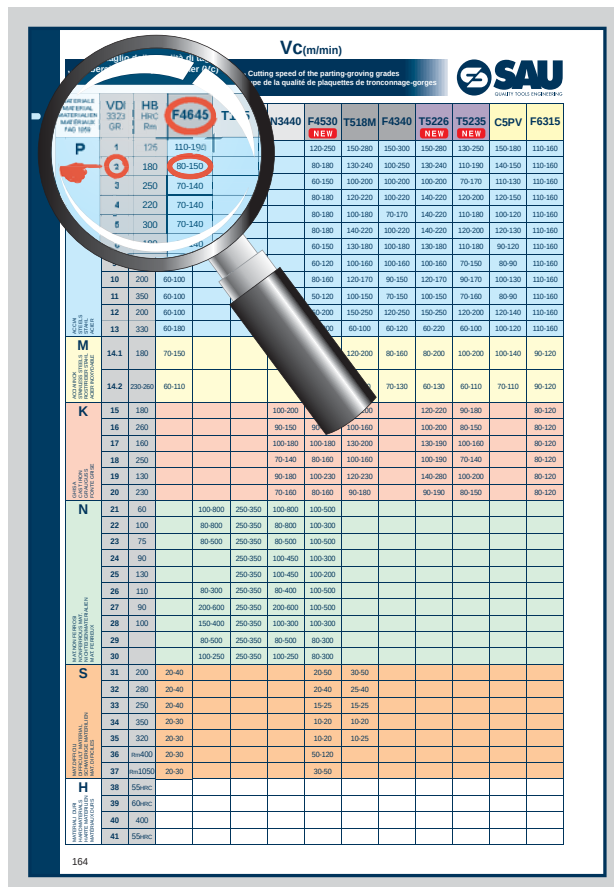
FASE 3 - PHASE 3

SCELTA DELL'AVANZAMENTO
CHOICE OF FEED
EINSTELLUNG DES VORSCHUBS
CHOIX DE L'AVANCEMENT



FASE 4 - PHASE 4

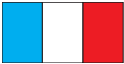
SCELTA DI VC IN FUNZIONE DEL GR. VDI
CHOICE OF VC DEPENDING ON VDI GR.
WAHL VC JE NACH WERKSTOFF
CHOIX DE VC EN FONCTION DU GR. VDI



DIN ISO 513	P ACCIAI STEELS STAHL ACIERS						M ACCIAI INOSSIDABILI STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE				K GHISE, NON FERROSI CAST IRON, NONFERROUS GRAUGUSS, NICHTEISENMA FONTE GRISE, PAS FERREUX																																				
	01	10	20	30	40	50	10	20	30	40	01	10	20	30	40																																
HW											T115 N3440																																				
HC																																															
TENACITÀ - TOUGHNESS - ZÄHIGKEIT - TÉNACITÉ RESISTENZA ALL'USURA - RESISTANCE TO WEAR VERSCHLEISSFESTIGKEIT - RÉSISTANCE À L'USURE																TENACITÀ - TOUGHNESS - ZÄHIGKEIT - TÉNACITÉ RESISTENZA ALL'USURA - RESISTANCE TO WEAR VERSCHLEISSFESTIGKEIT - RÉSISTANCE À L'USURE																TENACITÀ - TOUGHNESS - ZÄHIGKEIT - TÉNACITÉ RESISTENZA ALL'USURA - RESISTANCE TO WEAR VERSCHLEISSFESTIGKEIT - RÉSISTANCE À L'USURE															
AVANZAMENTO - FEED - VORSCHUB - AVANCE VELOCITÀ - SPEED - GESCHWINDIGKEIT - VITESSE																AVANZAMENTO - FEED - VORSCHUB - AVANCE VELOCITÀ - SPEED - GESCHWINDIGKEIT - VITESSE																AVANZAMENTO - FEED - VORSCHUB - AVANCE VELOCITÀ - SPEED - GESCHWINDIGKEIT - VITESSE															
HT	CERMET						HW				HC				METALLO DURO NON RICOPERTO UNCOATED CARBIDE UNBESCHICHTETES HARTMETALL MÉTAL DUR PAS RECOUVERT				METALLO DURO RICOPERTO COATED CARBIDE BESCHICHTETES HARTMETALL MÉTAL DUR RECOUVERT																												

SAU	DIN ISO 513		MATERIALE - MATERIAL MATERIALEN - MATÉRIAUX						PAG. 1063		QUICK PICK		 INDICAZIONI - USO	
			P	M	K	N	S	H	PAG. 156					
			ACCIAI STEELS STAHL ACIER	ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	GHISA CAST IRON GRAUGUSS FONTE GRISE	MAT NON FERROSI NON FERROUS MAT. NICHT-EISENMATERIALIEN MAT. FERREUX	MAT DIFFICILI DIFFICULT MATERIAL SCHWERGE MATERIALIEN MAT. DIFFICILES	MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATÉRIAUX DURS	Tenacità Toughness					
T115	HW	K10-25				●					●	- QUALITÀ MICROGRANO CON ALTA RESISTENZA ALL' USURA E AGLI SHOCK TERMICI - INDICATO PER MEDIO-BASSE VELOCITÀ DI TAGLIO E ALTI AVANZAMENTI		
N6315	HW	N05-25				●					●	- QUALITÀ PER LAVORAZIONE DI MATERIALI NON FERROSI		
N3440	HW	K20-40 N20-30			●	●					●	- QUALITÀ UNIVERSALE PER GHISA E MATERIALI NON FERROSI - OTTIME PRESTAZIONI A UMIDO		
F4530 NEW	HC PVD	P25-45 M25-40 N25-40 S25-40	●	●	●	○	●				●	- QUALITÀ UNIVERSALE PER VARIE TIPOLOGIE DI MATERIALI - OTTIMO IMPIEGO IN CONDIZIONI DI TAGLIO INTERROTTO O DI LAVORAZIONI IN CONDIZIONI DIFFICILI. - INDICATO PER LAVORAZIONI A BASSE VELOCITÀ DI TAGLIO.		
F4645 NEW	HC PVD	P30-45 M30-40 S20-40	●	●			○				●	- ELEVATA TENACITÀ, PARTICOLARMENTE INDICATO PER LA LAVORAZIONE DI ACCIAIO INOX. - BUON CONTROLLO DELL'USURA E OTTIMO NELL'IMPIEGO DI LAVORAZIONI IN CONDIZIONI DIFFICILI.		
T518M	HC CVD	P05-25 M10-20 K05-20	●	●	●		●				●	- BUONA TENACITÀ - INDICATO PER MEDIE VELOCITÀ DI TAGLIO E ALTI AVANZAMENTI ANCHE SU MATERIALI CHE CREANO IL TAGLIENTE DI RIPOERTO		
F4340	HC PVD	P20-40 M20-30	●	●							●	- PER LA LAVORAZIONE DI ACCIAI E ACCIAI INOSSIDABILI A BASSE VELOCITÀ DI TAGLIO, CON AMPIO CAMPO APPLICATIVO - OTTIME PRESTAZIONI A UMIDO		
T5226 NEW	HC CVD	P15-35 M05-25 K15-35	●	○	●						●	- ALTA RESISTENZA ALL'USURA - INDICATO PER LA LAVORAZIONE DI ACCIAIO E GHISA UTILIZZANDO VELOCITÀ DI TAGLIO ELEVATE.		
T5235 NEW	HC CVD	P20-45 M20-40 K20-40	●	○	●						●	- ALTA RESISTENZA ALL'USURA, ALL'OSSIDAZIONE E BUONA TENACITÀ. - PERFORMANTE ANCHE AD ALTE VELOCITÀ DI TAGLIO		
C5PV	HC PVD	P30-45 M30-40	●	●							●	- ELEVATA TENACITÀ - INDICATO PER BASSE VELOCITÀ DI TAGLIO ANCHE NELLA TRONCATURA FINO AL CENTRO E PER LAVORAZIONI A TAGLIO INTERROTTO		
F6315	HC PVD	P10-30 M05-25 K05-25	●	●	●							- OTTIMA RESISTENZA ALL'USURA - QUALITÀ UNIVERSALE PER VARI TIPI DI MATERIALE - INDICATO PER MEDIE-ALTE VELOCITÀ DI TAGLIO		
T533	HC CVD	P10-35 M10-30 K15-25	●	●			●				●	-BUONA TENACITÀ E RESISTENZA ALL' USURA -INDICATO PER MEDIE VELOCITÀ DI TAGLIO ANCHE PER MATERIALI CHE CREANO IL TAGLIENTE DI RIPOERTO		

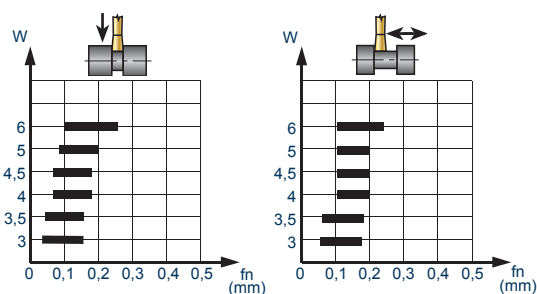
- APPLICAZIONE CONSIGLIATA
RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ
APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE
POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG
APPLICATION POSSIBLE
- APPLICAZIONE CONSIGLIATA
RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ
APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE
POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG
APPLICATION POSSIBLE

 INDICATIONS - USE	 GEBRAUCHSANWEISUNGEN	 INDICATION - USAGE
- MICROGRAIN GRADE WITH HIGH RESISTANCE TO WEAR AND TO THERMAL SHOCK - SUITABLE FOR MEDIUM-LOW CUTTING SPEEDS AND HIGH FEED	- MIKROKORNSORTE MIT HOHER VERSCHLEISSFESTIGKEIT UND TEMPERATURWECHSELBESTÄNDIGKEIT - FÜR MITTLERE SCHNITTGESCHWINDIGKEITEN UND GROSSE VORSCHÜBE	- QUALITÉ DE MICROGRAIN AVEC HAUTE RÉSISTANCE À L'USURE ET AU SHOCK THERMIQUE - INDIQUÉE POUR MOYENNE VITESSE DE COUPE ET HAUT DÉPLACEMENT
- DEGREE FOR NON-FERROUS MATERIALS	- SORTE FÜR NICHT-EISENMATERIALIEN	- QUALITÉ POUR L'USINAGE DE MATÉRIAUX NON FERREUX
- ALL-PURPOSE QUALITY FOR CAST IRON AND NON-FERROUS MATERIALS - EXCELLENT WET PERFORMANCE	- UNIVERSALE QUALITÄT FÜR GUSS UND NICHT-EISENMATERIALIEN - AUSGEZEICHNETE NASSLEISTUNGEN	- QUALITÉ UNIVERSELLE POUR FONTE ET MATÉRIAUX NON FERREUX - PERFORMANCES EXCEPTIONNELLES À L'EAU
- UNIVERSAL GRADE FOR VARIOUS TYPES OF MATERIALS - EXCELLENT PERFORMANCE UNDER INTERRUPTED OR DIFFICULT CUTTING CONDITIONS - SUITABLE FOR MACHINING WITH LOW CUTTING SPEED	- UNIVERSALE SORTE FÜR VERSCHIEDENE MATERIALIEN - SEHR GUTE LEISTUNGSFÄHIGKEIT MIT UNTERBROCHENEM SCHNITT ODER BEARBEITUNG UNTER SCHWIERIGEN BEDINGUNGEN - FÜR BEARBEITUNGEN MIT NIEDRIGEN SCHNITTGESCHWINDIGKEITEN GEEIGNET	- QUALITÉ UNIVERSELLE POUR DIFFÉRENTES TYPOLOGIES DE MATÉRIAUX - EMPLOI PARFAIT DANS DES CONDITIONS DE COUPE INTERROMPUE OU D'USINAGES DANS DES CONDITIONS DIFFICILES - INDIQUÉ POUR LES USINAGES À DE FAIBLES VITESSES DE COUPE
- CONSIDERABLE TOUGHNESS, PARTICULARLY SUITABLE FOR STAINLESS STEEL - GOOD WEAR CONTROL AND EXCELLENT PERFORMANCE UNDER DIFFICULT MACHINING CONDITIONS	- HOHE ZÄHIGKEIT, BESONDERS FÜR DIE BEARBEITUNG VON EDELSTAHL GEEIGNET - GUTE VERSCHLEISSKONTROLLE UND BESTENS GEEIGNET ZUR BEARBEITUNG UNTER SCHWIERIGEN BEDINGUNGEN	- TÉNACITÉ ÉLEVÉE, PARTICULIÈREMENT INDIQUÉ POUR L'USINAGE D'ACIER INOX - BON CONTRÔLE DE L'USURE ET PARFAIT DANS L'EMPLOI D'USINAGES DANS DES CONDITIONS DIFFICILES
- GOOD TOUGHNESS - SUITABLE FOR MEDIUM CUTTING SPEEDS AND HIGH FEED EVEN ON MATERIALS THAT FORM A BUILT-UP EDGE	- GUTE ZÄHIGKEIT - FÜR MITTEL SCHNITTGESCHWINDIGKEITEN UND GROSSE VORSCHÜBE, AUCH BEI MATERIALIEN, DIE KEINE AUFBAUSCHNEIDE BILDEN, GEEIGNET	- BONNE TENACITÉ - INDIQUÉE POUR MOYENNE VITESSE DE COUPE ET HAUT DÉPLACEMENT MÊME SUR MATÉRIAUX QUI CRÉENT LE COUPANT DE RAPPORT
- FOR MACHINING STEELS AND STAINLESS STEELS AT SLOW CUTTING SPEEDS FOR A VAST RANGE OF APPLICATIONS - EXCELLENT WET PERFORMANCE	- FÜR DIE BEARBEITUNG VON STAHL UND EDELSTAHL MIT NIEDRIGER SCHNITTGESCHWINDIGKEIT, GROSSER ANWENDBEREICH - AUSGEZEICHNETE NASSLEISTUNGEN	- POUR L'USINAGE D'ACIERS ET ACIERS INOXYDABLES À DE FAIBLES VITESSES DE COUPE, AVEC AMPLE PLAGE D'APPLICATION - PERFORMANCES EXCEPTIONNELLES À L'EAU
- HIGH RESISTANCE TO WEAR - SUITABLE FOR STEEL AND CAST IRON MACHINING WITH HIGH CUTTING SPEED	- HOHE VERSCHLEISSFESTIGKEIT - FÜR DIE BEARBEITUNG VON STAHL UND GUS MIT HOHEN SCHNITTGESCHWINDIGKEITEN GEEIGNET	- HAUTE RÉSISTANCE À L'USURE - INDIQUÉ POUR L'USINAGE D'ACIER ET DE FONTE, EN UTILISANT DES VITESSES DE COUPE ÉLEVÉES
- HIGH RESISTANCE TO WEAR, OXIDATION AND GOOD TOUGHNESS - EXCELLENT PERFORMANCE ALSO WITH HIGH CUTTING SPEED	- HOHE VERSCHLEISS- UND OXIDATIONSFESTIGKEIT UND GUTE ZÄHIGKEIT - HOHE LEISTUNGSFÄHIGKEIT AUCH BEI HOHEN SCHNITTGESCHWINDIGKEITEN	- HAUTE RÉSISTANCE À L'USURE, À L'OXYDATION ET BONNE TÉNACITÉ - PERFORMANT MÊME À DE HAUTES VITESSES DE COUPE
- HIGH TOUGHNESS - SUITABLE FOR LOW CUTTING SPEEDS EVEN WHEN CUTTING TO THE CENTER AND EVEN FOR DISCONTINUOUS CUTS MACHINING	- HOHE ZÄHIGKEIT - FÜR NIEDRIGE SCHNITTGESCHWINDIGKEITEN, AUCH BEIM TRENNEN BIS ZUM ZENTRUM, GEEIGNET UND GROSSE VORSCHÜBE	- HAUTE TENACITÉ - INDIQUÉE POUR FAIBLE VITESSE DE COUPE, MÊME POUR TRONÇONNAGE JUSQU'AU CENTRE ET POUR COUPE INTERROMPU
- EXCELLENT RESISTANCE TO WEAR - UNIVERSAL DEGREE FOR DIFFERENT TYPES OF MATERIALS - SUITABLE FOR MEDIUM TO HIGH CUTTING SPEEDS	- SEHR HOHE VERSCHLEISSFESTIGKEIT - UNIVERSALSORTE FÜR VERSCHIEDENE MATERIALIEN - FÜR MITTLERE BIS HOHE SCHNITTGESCHWINDIGKEITEN GEEIGNET	- RÉSISTANCE EXCELLENTE À L'USURE - QUALITÉ UNIVERSELLE POUR DIFFÉRENTS TYPES DE MATÉRIAU - INDIQUÉ EN CAS DE VITESSES DE COUPE HAUTES-MOYENNES
- GOOD TOUGHNESS AND RESISTANCE TO WEAR - SUITABLE FOR MEDIUM CUTTING SPEEDS EVEN ON MATERIALS THAT FORM A BUILT-UP EDGE	- GUTE ZÄHIGKEIT VERSCHLEISSFESTIGKEIT - FÜR MITTEL SCHNITTGESCHWINDIGKEITEN, AUCH BEI MATERIALIEN, DIE KEINE AUFBAUSCHNEIDE BILDEN, GEEIGNET	- BONNE TENACITÉ - INDIQUÉE POUR MOYENNE VITESSE DE COUPE MÊME SUR MATÉRIAUX QUI CRÉENT LE COUPANT DE RAPPORT

MATERIALE MATERIAL MATERIALIEN MATERIAUX PAG 1063	VDI 3323 GR.	HB HRC Rm	T115	N6315	N3440	F4530 NEW	F4645 NEW	T518M	F4340	T5226 NEW	T5235 NEW	C5PV	F6315
P ACCIAI STEELS STAHL ACIER	1	125				120-250	110-190	150-280	150-300	150-280	130-250	150-180	110-160
	2	180				80-180	80-150	130-240	100-250	130-240	110-190	140-150	110-160
	3	250				60-150	70-140	100-200	100-200	100-200	70-170	110-130	110-160
	4	220				80-180	70-140	120-220	100-220	140-220	120-200	120-150	110-160
	5	300				80-180	70-140	100-180	70-170	140-220	110-180	100-120	110-160
	6	180				80-180	70-140	140-220	100-220	140-220	120-200	120-130	110-160
	7-8	250-300				60-150	70-120	130-180	100-180	130-180	110-180	90-120	110-160
	9	350				60-120	60-120	100-160	100-160	100-160	70-150	80-90	110-160
	10	200				80-160	60-100	120-170	90-150	120-170	90-170	100-130	110-160
	11	350				50-120	60-100	100-150	70-150	100-150	70-160	80-90	110-160
	12	200				50-200	60-100	150-250	120-250	150-250	120-200	120-140	110-160
	13	330				50-200	60-180	60-100	60-120	60-220	60-100	100-120	110-160
M ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	14.1	180				50-180	70-150	120-200	80-160	80-200	100-200	100-140	90-120
	14.2	230-260				50-100	60-110	80-130	70-130	60-130	60-110	70-110	90-120
K GHISA CAST IRON GRAUGUSS FONTE GRISE	15	180			100-200	100-200		120-200		120-220	90-180		80-120
	16	260			90-150	90-160		100-160		100-200	80-150		80-120
	17	160			100-180	100-180		130-200		130-190	100-160		80-120
	18	250			70-140	80-160		100-160		100-190	70-140		80-120
	19	130			90-180	100-230		120-230		140-280	100-200		80-120
	20	230			70-160	80-160		90-180		90-190	80-150		80-120
N MAT.NON FERROSI NONFERROUS MAT. NICHT-EISENMATERIALIEN MAT. FERREUX	21	60	100-800	250-350	100-800	100-500							
	22	100	80-800	250-350	80-800	100-300							
	23	75	80-500	250-350	80-500	100-500							
	24	90		250-350	100-450	100-300							
	25	130		250-350	100-450	100-200							
	26	110	80-300	250-350	80-400	100-500							
	27	90	200-600	250-350	200-600	100-500							
	28	100	150-400	250-350	100-300	100-300							
	29		80-500	250-350	80-500	80-300							
	30		100-250	250-350	100-250	80-300							
S MAT.DIFFICILI DIFFICULT MATERIAL SCHWIERIGE MATERIALIEN MAT. DIFCILES	31	200				20-50	20-40	30-50					
	32	280				20-40	20-40	25-40					
	33	250				15-25	20-40	15-25					
	34	350				10-20	20-30	10-20					
	35	320				10-20	20-30	10-25					
	36	Rm400				50-120	20-30						
	37	Rm1050				30-50	20-30						
H MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATÉRIAUX DURS	38	55HRC											
	39	60HRC											
	40	400											
	41	55HRC											

MATERIALE MATERIAL MATERIALIEN MATÉRIAUX PAG 1063	VDI 3323 GR.	HB HRC Rm	T533										
P ACCIAI STEELS STAHL ACIER	1	125	150-280										
	2	180	130-240										
	3	250	100-200										
	4	220	120-220										
	5	300	100-180										
	6	180	140-220										
	7-8	250-300	130-180										
	9	350	100-160										
	10	200	120-170										
	11	350	100-150										
	12	200	150-250										
	13	330	60-100										
M ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	14.1	180	120-200										
	14.2	230-260	80-130										
K GHISA CAST IRON GRAUGUSS FONTE GRISE	15	180											
	16	260											
	17	160											
	18	250											
	19	130											
	20	230											
N MATRON FERROSI NONFERROUS MAT. NICHT-EISENMATERIALIEN MAT. FERREUX	21	60											
	22	100											
	23	75											
	24	90											
	25	130											
	26	110											
	27	90											
	28	100											
	29												
	30												
S MAT.DIFFICILI DIFFICULT MATERIAL SCHWIERIGE MATERIALIEN MAT. DIFCILES	31	200	25-45										
	32	280	20-40										
	33	250	15-25										
	34	350	10-20										
	35	320	10-20										
	36	Rm400	100-150										
	37	Rm1050	50-80										
H MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATÉRIAUX DURS	38	55HRC											
	39	60HRC											
	40	400											
	41	55HRC											

-GX.. .Z33


-SCANALATURA
-GROOVING
-GEWINSCHNEIDEN
-GORGES

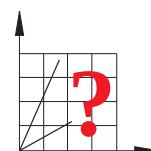
-TORNITURA
-TURNING
-DREHEN
-TOURNAGE

F	M	R
●		
○		

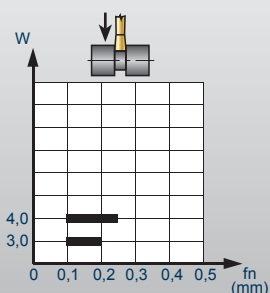
F	M	R
●		
○		

GRADI CONSIGLIATI - RECOMMENDED GRADES - EMPFOHLENE SORTEN - DEGRÉS CONSEILLÉS

				
F =	FINITURA, LAV. LEGGERE	FINISHING,LIGHT MACHING	SCHLICHTEN,LEICHTE BEARBEITUNG	FINISSAGE,USINAGES LÉGÈRES
M =	GENERICO, LAV. MEDIE	GENERIC MEDIUM MACHINING	ALLGEMEIN,MITTELSCHWERE BEARBEITUNG	GENERAL,USINAGES MOYENS
R =	SGROSSATURA, LAV. PESANTI	ROUGHING, HEAVY MACHINING	SCHRUPPEN,SCHWERE BEARBEITUNG	DEGROSSISAGES,USINAGES LOURDS
P,M,K,N,S,H =	MATERIALI ISO PAG 1063	ISO MATERIALS PAGE 1063	ISO-MATERIEIALIEN,SEITE 1063	MATERIAUX ISO PAG 1063
	TRONCATURA TUBI	PARTING OF PIPES	ROHRABSTECHE	TRONÇONNAGE TUYAUX
	TRONCATURA BARRE	PARTING OF BARS	STANGENABSTECHE	TRONÇONNAGE BARRES
	TRONCATURE DIFFICILI	DIFFICULT PARTING OPERATION	SCHWIERIGES ABSTECHE	TRONÇONNAGE DIFFICILES
	SCANALATURA	GROOVING	NUTENDREHEN	RAINURER
	SCANALATURA-TORNITURA	GROOVING-TURNING	NUTENDREH-DREHWERKZEUGE	RAINURER-TOURNAGE
● =	APPLICAZIONE CONSIGLIATA	RECOMMENDED APPLICATION	EMPFOHLENER EINSATZ	APPLICATION CONSEILLÉE
○ =	APPLICAZIONE POSSIBILE	POSSIBLE APPLICATION	MOGLICHE ANWENDUNG	APPLICATION POSSIBLE
fn (mm) =	AVANZAMENTO AL GIRO	FEED/REVOLUTION	VORSCHUB PRO UMDREHUNG	DÉPLACEMENT AU TOUR
W (mm) =	LARGHEZZA TAGLIENTE	CUTTING EDGE WIDTH	SCHNITTBREITE	LARGEUR DU TRANCHANT



-TRLN.. .G52

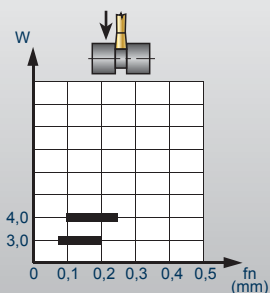


F	M	R	
○	●	●	P
○	●	●	M
○	●	●	K
○	●	●	N
○	●	●	S
○	●	●	H



T5235-F4645	T5235-F4645	T5235-F4645	T5235-F4645	
T5235	T5235	T5235	T5235	

-TRLN.. .G56

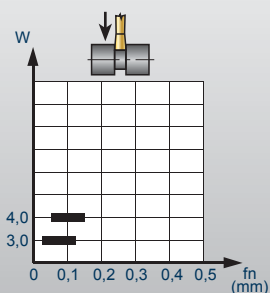


F	M	R	
○	●	●	P
○	●	●	M
○	●	●	K
○	●	●	N
○	●	●	S
○	●	●	H



T5235-F4645	T5235-F4645	T5235-F4645	T5235-F4645	T5235-F4645
T5235	T5235	T5235	T5235	T5235

-TRLN.. .G57P

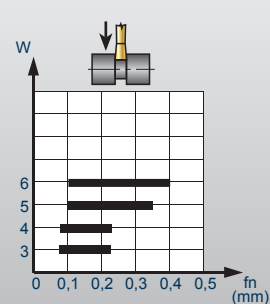


F	M	R	
○	●	●	P
○	●	●	M
○	●	●	K
○	●	●	N
○	●	●	S
○	●	●	H

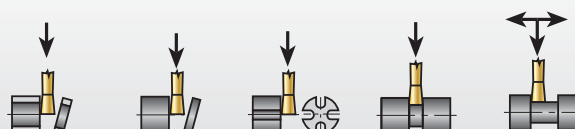


T115	T115	T115	T115	

-STN .L52

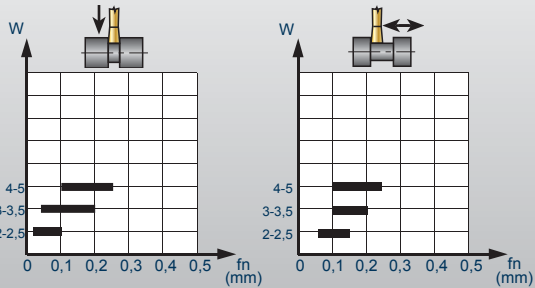


F	M	R	
○	●	●	P
○	●	●	M
○	●	●	K
○	●	●	N
○	●	●	S
○	●	●	H



T518M-T533	T518M-T533		T518M-T533	
T518M-T533	T518M-T533		T518M-T533	
T518M	T518M		T518M	
T518M-T533	T518M-T533		T518M-T533	

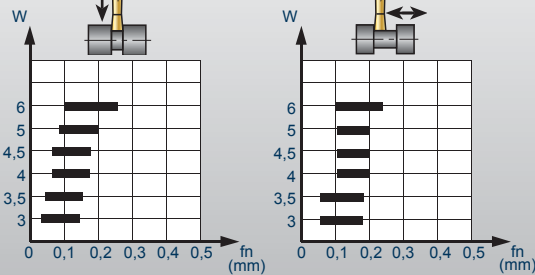
-GX.. .Z32



F	M	R
●		
●		
●		

P	5226	5226	5226	5226
M	5226	5226	5226	5226
K	5226	5226	5226	5226
N				
S				
H				

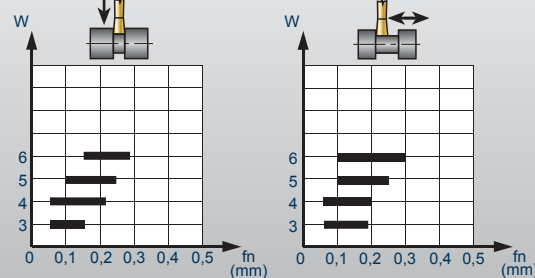
-GX.. .Z33



F	M	R
●		
○		
○		

P	F4645	F4645	F4645	F4645
M	F4645	F4645	F4645	F4645
K				
N				
S	F4645	F4645	F4645	F4645
H				

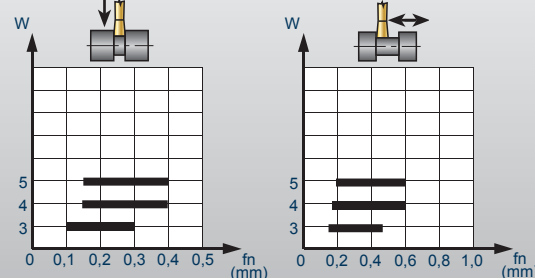
-GX.. .Z42



F	M	R
●	○	
○	○	
●	○	
○	○	
○	○	

P	T5235-T5226 F4530	T5235-T5226 F4530	T5235-T5226 F4530	T5235-T5226 F4530
M	T5235-T5226 F4530	T5235-T5226 F4530	T5235-T5226 F4530	T5235-T5226 F4530
K	T5235-T5226	T5235-T5226	T5235-T5226	T5235-T5226
N	F4530	F4530	F4530	F4530
S	F4530	F4530	F4530	F4530
H				

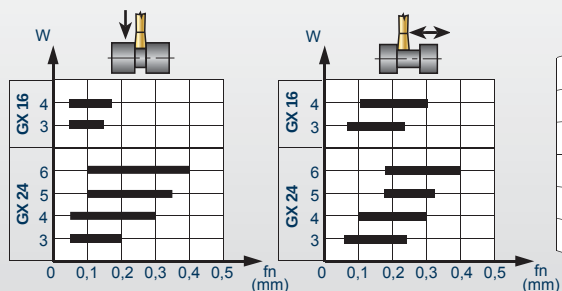
-GX.. .Z42



F	M	R
●	○	
○	○	
●	○	

P			T5226	T5226
M			T5226	T5226
K			T5226	T5226
N				
S				
H				

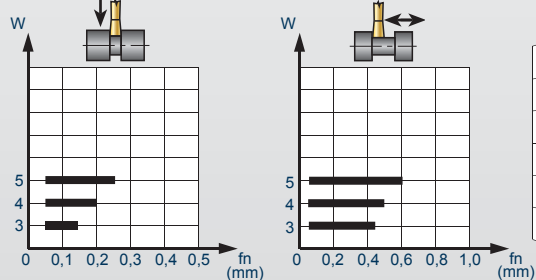
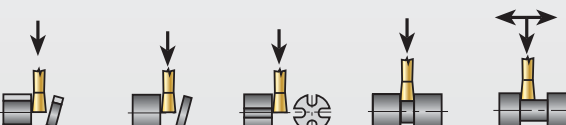
-GX.. .Z47P



F	M	R

P				
M				
K				
N	T115	T115	T115	T115
S				
H				

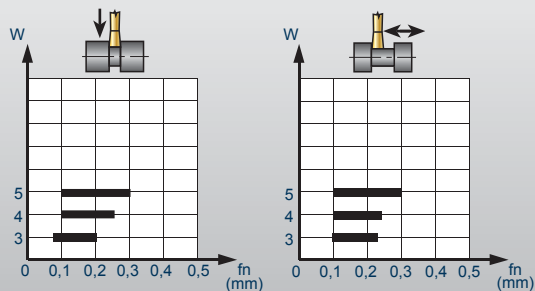
-GX.. .Z47P



F	M	R

P				
M				
K				
N			T115	T115
S				
H				

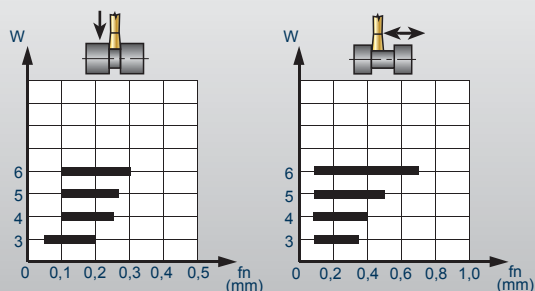
-GX.. .Z52



F	M	R

P	F4645	F4645	F4645	F4645	F4645
M	F4645	F4645	F4645	F4645	F4645
K					
N					
S	F4645	F4645	F4645	F4645	F4645
H					

-GX.. .Z62



F	M	R

P			T5235	T5235
M			T5235	T5235
K			T5235	T5235
N				
S				
H				

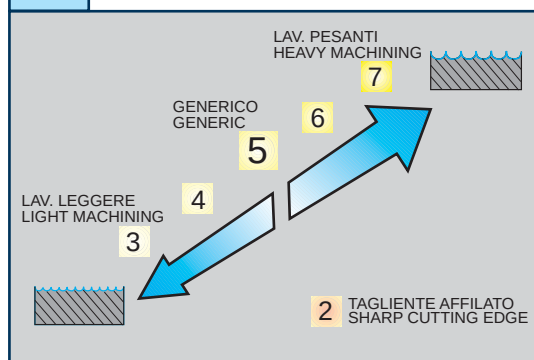
GX 24 - 2E 3.00 N - 0.30

-	-	-	P
1	2	3	4

1 LETTERA DI IDENTIF.
 IDENTIFICATION LETTER

A	N
C	P
D	R
E	S
H	T
I	U
J	W
K	Y
L	Z
M	

2 CAMPO DI LAVORAZIONE
 MACHINING TYPES



3 PREPARAZIONE TAGLIANTE
 CUTTING EDGE PREPARATION

1 =	SPECIFICO PER GHISA SPECIFIC FOR CAST IRON
3 =	SPECIFICO PER ACCIAIO INOX SPECIFIC FOR STAINLESS STEEL
7 =	SPECIFICO PER LEGHE DI ALLUMINIO SPECIFIC FOR ALUMINIUM ALLOYS
9 =	SPECIFICO PER ACCIAIO SPECIFIC FOR STEEL
2 =	
4 =	INTERMEDI DI USO GENERICO INTERMEDIATE FOR GENERAL USE
5 =	
6 =	
8 =	

4

LUCIDATO
 POLISH



154.15.. 156.15..		GX..		HW				HC										
				NON RIVESTITI CEMENTED CARBIDE GRADES				RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS										
				T115	N6315	N3440		F4645 $\leq m2$	F4340				T5226 $\leq m2$	F6315				
ART.	COD.	W	r/s	l	d	M/T	a°/d1											
 C54	TOLLERANZA W - W TOLERANCE		$\begin{smallmatrix} +0,05 \\ -0,05 \end{smallmatrix}$															
	154.15-16110		1,25	2,5	16,0	9,52	1,2	4,5			■		■					
	154.15-16130		1,45	2,5	16,0	9,52	1,5	4,5			■		■					
	154.15-16160		1,80	2,5	16,0	9,52	1,8	4,5			■		■					
	154.15-16185		2,00	2,5	16,0	9,52	3	4,5			■		■					
	154.15-16215		2,30	2,8	16,0	9,52	3	4,5			■		■					
	154.15-16265		2,80	3,3	16,0	9,52	3	4,5			■		■					
	154.15-16315		3,35	3,8	16,0	9,52	3	4,5			■		■					
	TOLLERANZA W - W TOLERANCE		$\begin{smallmatrix} +0,05 \\ +0,01 \end{smallmatrix}$															
	156.15-16110	.C54	1,10	3	16,0	9,52	3,0	4,5										■
	156.15-16130	.C54	1,30	3	16,0	9,52	3,0	4,5										■
	156.15-16160	.C54	1,60	3	16,0	9,52	3,0	4,5										■
	156.15-16185	.C54	1,85	3	16,0	9,52	3,0	4,5										■
	156.15-16215	.C54	2,15	3	16,0	9,52	3,0	4,5										■
156.15-16265	.C54	2,65	3	16,0	9,52	3,0	4,5										■	
156.15-16315	.C54	3,15	3,5	16,0	9,52	3,3	4,5										■	
156.15-16415	.C54	4,15	4,5	16,0	9,52	3,3	4,5										■	
 C57	156.15-16110	.C57	1,10	3	16,0	9,52	3,0	4,5	■									
	156.15-16130	.C57	1,30	3	16,0	9,52	3,0	4,5	■									
	156.15-16160	.C57	1,60	3	16,0	9,52	3,0	4,5	■									
	156.15-16185	.C57	1,85	3	16,0	9,52	3,0	4,5	■									
	156.15-16215	.C57	2,15	3	16,0	9,52	3,0	4,5	■									
	156.15-16265	.C57	2,65	3	16,0	9,52	3,0	4,5	■									
	156.15-16315	.C57	3,15	3,5	16,0	9,52	3,3	4,5	■									
	156.15-16415	.C57	4,15	4,5	16,0	9,52	3,3	4,5	■									
	 .Z32	GX16-1E2.00N-0.20	.Z32	2,0	0,2	16	-	1,40	6°									■
		GX16-1E2.50N-0.20	.Z32	2,5	0,2	16	-	1,40	6°									■
		GX16-2E3.00N-0.30	.Z32	3,0	0,3	16	-	2,10	6°									■
		GX16-2E3.50N-0.30	.Z32	3,5	0,3	16	-	2,10	6°									■
		GX16-3E4.00N-0.40	.Z32	4,0	0,4	16	-	3,05	6°									■
GX16-3E5.00N-0.40		.Z32	5,0	0,4	16	-	3,05	6°									■	
 .Z42	GX16-2R1.50N	.Z42	3,0	1,5	16	-	2,10	6°									■	
	GX16-3R2.00N	.Z42	4,0	2,0	16	-	3,05	6°									■	
	GX16-3R2.50N	.Z42	5,0	2,5	16	-	3,05	6°									■	
 .Z52	GX16-2E3.00N-0.30	.Z52	3,0	0,3	16	-	2,10	6°				■						
	GX16-3E4.00N-0.40	.Z52	4,0	0,4	16	-	3,05	6°				■						
	GX16-3E5.00N-0.40	.Z52	5,0	0,4	16	-	3,05	6°				■						
 .Z47P	GX16-2E3.00N-0.30	.Z47P	3,0	0,3	16	-	2,10	6°	■									
	GX16-3E4.00N-0.40	.Z47P	4,0	0,4	16	-	3,05	6°	■									
 .Z47P	GX16-2R1.5N	.Z47P	3,0	1,5	16	-	2,10	6°	□									
	GX16-3R2.0N	.Z47P	4,0	2,0	16	-	3,05	6°	□									
	GX16-3R2.5N	.Z47P	5,0	2,5	16	-	3,05	6°	□									
MATERIALE - MATERIAL - MATERIALIEN - MATÉRIAUX								T115	N6315	N3440		F4645 $\leq m2$	F4340			T5226 $\leq m2$	F6315	
P	ACCIAIO - STEEL - STAHL - ACIER											●	●			●	●	
M	ACCIAIO INOX - STAINLESS STEEL - ROSTFREIER STAHL - ACIER INOXYDABLE											●	●			○	●	
K	GHISA - CAST IRON - GRAUGUSS - FONTE GRISE									●						●	●	
N	LEGHE DI ALLUMINIO - ALUMINIUM ALLOYS - ALUMINIUM-LEGIERUNGEN - ALLIAGES D'ALUMINIUM							●	●	●								
S	LEGHE RESISTENTI AL CALORE - HEAT RESISTANT ALLOYS - WÄRMEBESTÄNDIGE LEGIERUNGEN - ALLIAGES RÉISTANTES À LA CHALEUR											○						
H	MATERIALI DURI E TEMPRATI - HARD AND HARDENED MATERIAL - HARTE UND GEHÄRTETE MATERIALIEN - MATERIAUX DURS ET TREMPÉS																	

GX..		STN..		TRLN..		HW		HC			
NON RIVESTITI CEMENTED CARBIDE GRADES		RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS									
INSERTI NEGATIVI - NEGATIVE INSERTS - NEGATIVE WENDEPLATTEN - PLAQUÊTES NEGATIVES											
ART.	COD.	W	r/s	l	d	M/T	a°/d1	T115	F4530 F4645 T518M	T5226 T5235 T533	
 .Z33	GX24-2E3.00N-0.30 .Z33	3,0	0,3	24	—	2,10	6°				
	GX24-2E3.50N-0.30 .Z33	3,5	0,3	24	—	2,10	6°				
	GX24-3E4.00N-0.40 .Z33 New	4,0	0,4	24	—	3,05	6°				
	GX24-3E5.00N-0.40 .Z33 New	5,0	0,4	24	—	3,05	6°				
	GX24-4E6.00N-0.50 .Z33 New	6,0	0,5	24	—	4,30	6°				
	GX24-2E3.00N-0.30 .Z42	3,0	0,3	24	—	2,10	6°				
	GX24-3E4.00N-0.40 .Z42	4,0	0,4	24	—	3,05	6°				
	GX24-3E5.00N-0.40 .Z42	5,0	0,4	24	—	3,05	6°				
	GX24-4E6.00N-0.50 .Z42	6,0	0,5	24	—	4,30	6°				
 .Z62	GX24-3R2.0N .Z62	4,0	2,0	24	—	3,05	6°				
	GX24-3R2.5N .Z62	5,0	2,5	24	—	3,05	6°				
	GX24-4R3.0N .Z62	6,0	3,0	24	—	4,3	6°				
 .Z47P	GX24-2E3.00N-0.30 .Z47P	3,0	0,3	24	—	2,10	6°				
	GX24-3E4.00N-0.40 .Z47P	4,0	0,4	24	—	3,05	6°				
	GX24-3E5.00N-0.40 .Z47P	5,0	0,4	24	—	3,05	6°				
	GX24-4E6.00N-0.50 .Z47P	6,0	0,5	24	—	4,3	6°				
 .L52	STN 2 .L52	2,21	0,2	—	—	—	0°				
	STN 3 .L52	3,1	0,2	—	—	—	0°				
	STN 4 .L52	4,1	0,24	—	—	—	0°				
	STN 5 .L52	5,1	0,28	—	—	—	0°				
	IN ESAURIMENTO END OF STOCK AUSLAUFEND EN ÉPUISEMENT										
 .G52	TRLN 3.00-0.20N .G52	3,0*	0,2	—	—	—	0°				
	TRLN 4.00-0.30N .G52	4,0*	0,3	—	—	—	0°				
	NEW										
	TRLN 3.00-0.30N .G56	3,0*	0,3	—	—	—	0°				
	TRLN 4.00-0.40N .G56	4,0*	0,4	—	—	—	0°				
	NEW										
	TRLN 3.00-0.30N .G57P	3,0*	0,3	—	—	—	0°				
	TRLN 4.00-0.40N .G57P	4,0*	0,4	—	—	—	0°				
NEW											
MATERIALE - MATERIAL - MATERIALIEN - MATÉRIAUX								T115	F4530 F4645 T518M	T5226 T5235 T533	
P	ACCIAIO - STEEL - STAHL - ACIER										
M	ACCIAIO INOX - STAINLESS STEEL - ROSTFREIER STAHL - ACIER INOXYDABLE										
K	GHISA - CAST IRON - GRAUGUSS - FONTE GRISE										
N	LEGHE DI ALLUMINIO - ALUMINIUM ALLOYS - ALUMINIUM-LEGIERUNGEN - ALLIAGES D'ALUMINIUM										
S	LEGHE RESISTENTI AL CALORE - HEAT RESISTANT ALLOYS - WÄRMEBESTÄNDIGE LEGIERUNGEN - ALLIAGES RÉSISTANTES À LA CHALEUR										
H	MATERIALI DURI E TEMPRATI - HARD AND HARDENED MATERIAL - HARTE UND GEHÄRTETE MATERIALIEN - MATERIAUX DURS ET TREMPÉS										

Taglio Scanalatura		Parting Grooving		Abstechen Nutendrehen		Tronçonnage Gorges		Corte Ranuras		 SAU QUALITY TOOLS ENGINEERING																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						
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