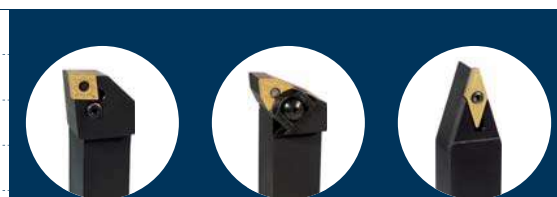

TORNITURA

TURNING / DREHEN / TOURNAGE / TORNEADO



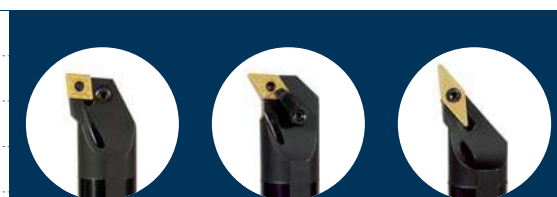
STC

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



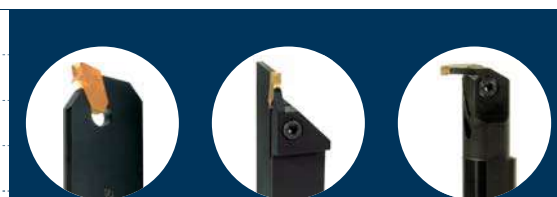
Pag. 8

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



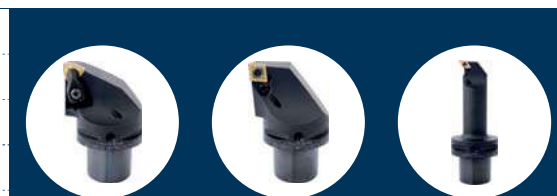
Pag. 44

	UTENSILI PER SCANALATURA E TAGLIO
	TOOLS FOR GROOVING AND PARTING
	NUTENDREHEN UND ABSTECHEEN
	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



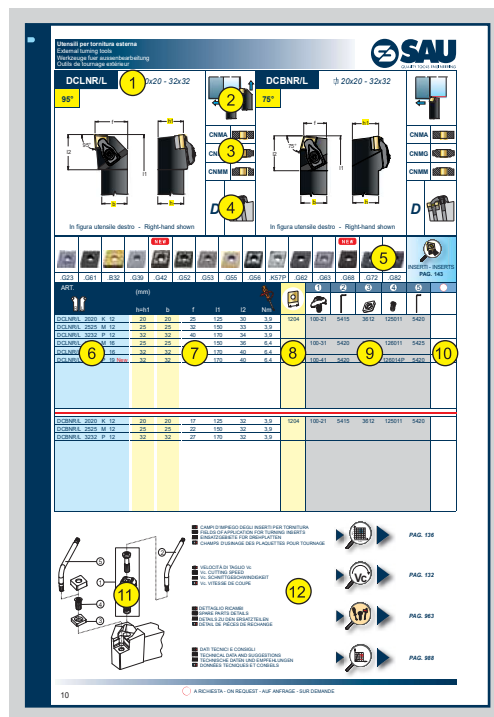
- 1 = ITEM + SHAFT RANGE
- 2 = RECOMMENDED MACHINING TYPES
- 3 = INSERTS
- 4 = CLAMPING SYSTEM
- 5 = AVAILABLE SAU INSERTS
- 6 = ITEM LIST
- 7 = MEASURES, DATA, INDICATIONS
- 8 = RECOMMENDED INSERTS SIZES
- 9 = SPARE PARTS EQUIPMENT
- 10 = OPTIONAL ACCESSORIES AND SPARE PARTS ON REQUEST
- 11 = ASSEMBLY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



CLAMPING TYPES



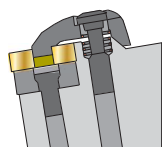
KLEMMTYPEN



TYPES DE BLOCAGE

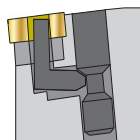
TIPO-TYPE-TYP-TYPE

D



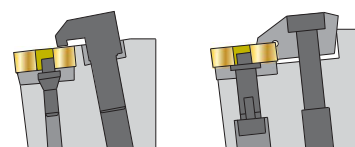
TIPO-TYPE-TYP-TYPE

P



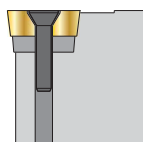
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M



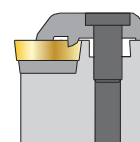
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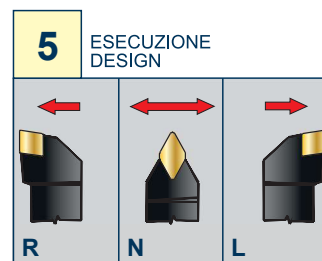
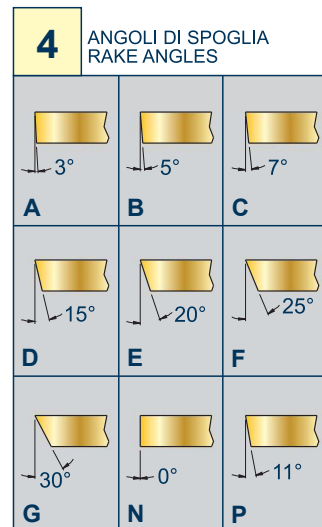
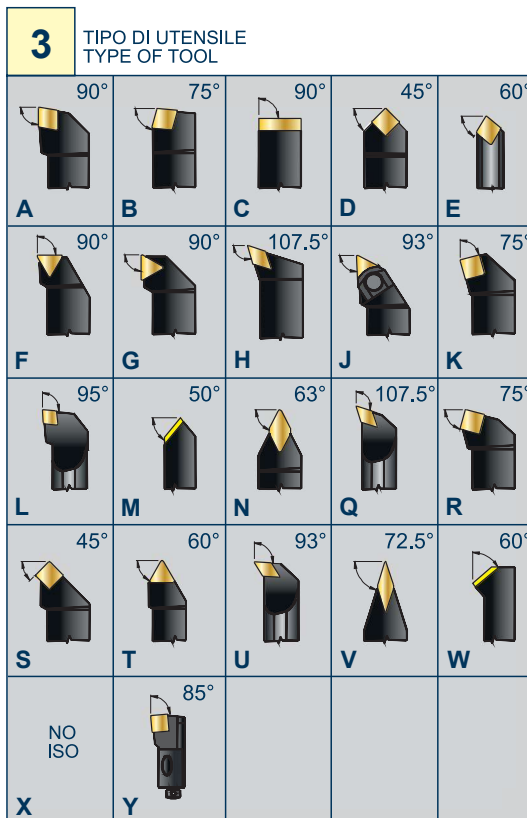
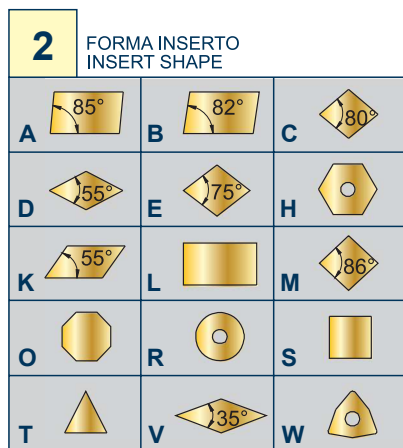
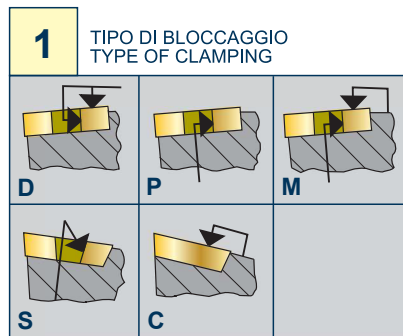
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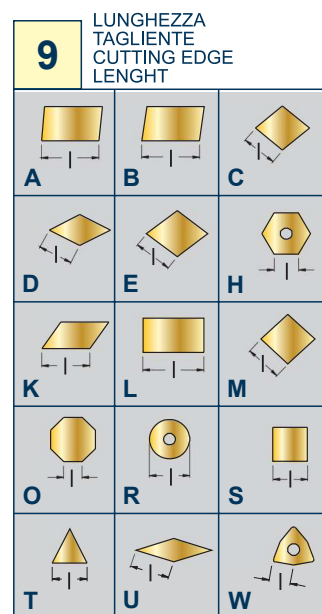
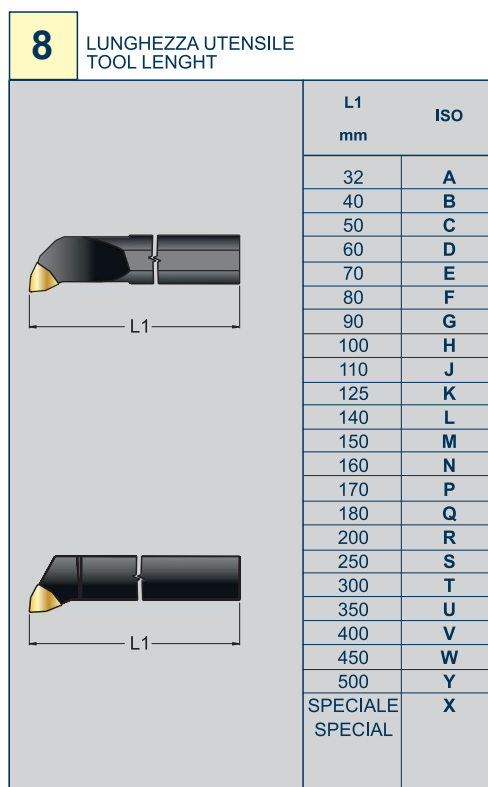
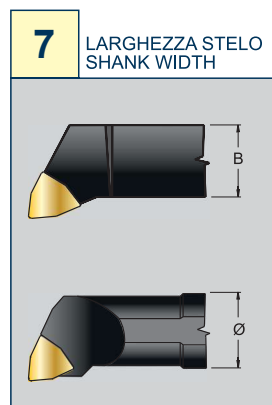
TIPO-TYPE-TYP-TYPE

C





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



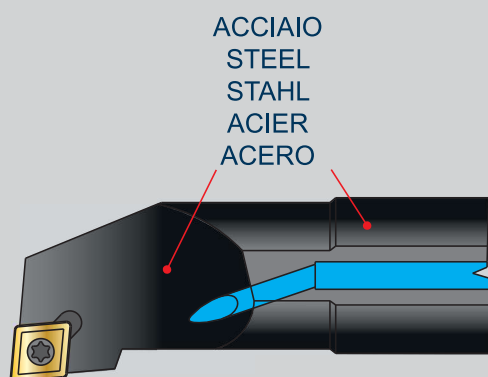
S	20	S	C	T	F	P	R	16	
11	7	8	1	2	3	4	5	9	10

11 STELO SHANK

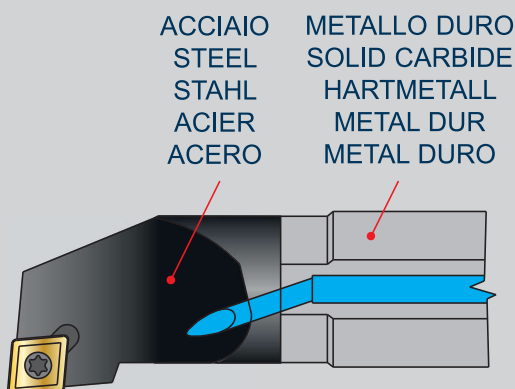
S = Stelo in acciaio
A = Stelo in acciaio + foro refrigerante
B = Stelo in acciaio + dispositivo antivibrante
C = Stelo in metallo duro con testa in acciaio
D = Stelo in acciaio + dispositivo antivibrante + foro refrigerante
E = Stelo in metallo duro con testa in acciaio + foro refrigerante
F = Stelo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

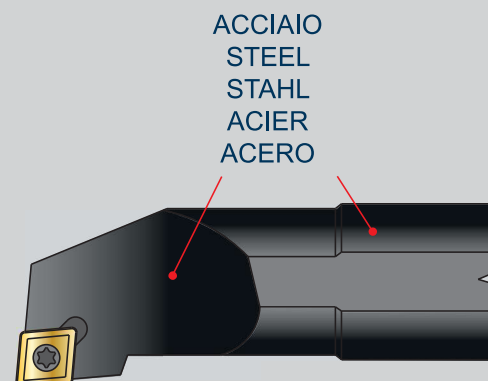
A...

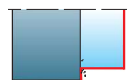
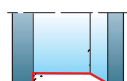
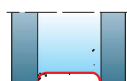


E...



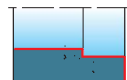
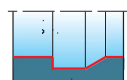
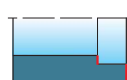
S...



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								

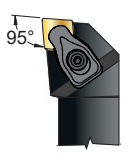
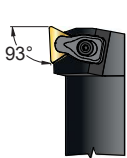
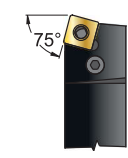
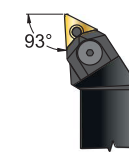
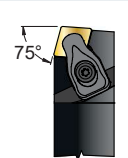
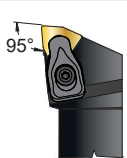
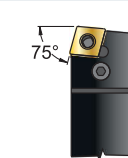
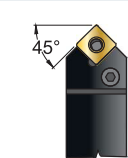
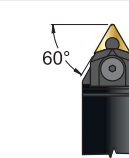
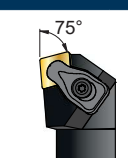
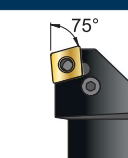
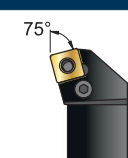
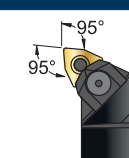
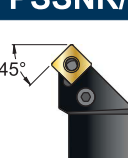
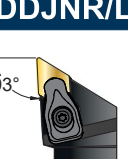
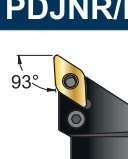
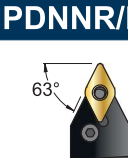
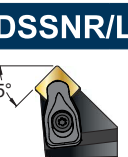
● FORMA CONSIGLIATA - RECOMMENDED SHAPE

○ 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..	 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		DWLNR/L 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		MWLNR/L 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						PWLNR/L Pag.22			
 45° □ 20x20 - 25x25	 SNM. 1204..					 95° □ 16x16 - 32x32	 WNM. 0604.. 0804..		

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

DCLNR/L $\varnothing 20 \times 20 - 32 \times 32$

95°

In figura utensile destro - Right-hand shown

DCBNR/L $\varnothing 20 \times 20 - 32 \times 32$

75°

In figura utensile destro - Right-hand shown

CNMA

CNMG

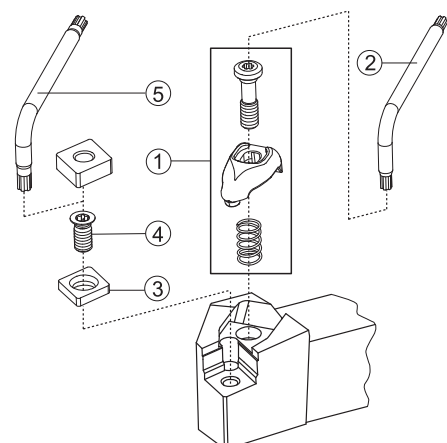
CNMM

D

D



ART.		(mm)												
R	L		h=h1	b	f	l1	l2	Nm		1	2	3	4	5
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	1906	100-41	5420	3619	126014P	5420
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
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PAG. 136



PAG. 132



PAG. 967



PAG. 992

DCKNR/L $\varnothing 20 \times 20 - 32 \times 32$

75°

In figura utensile destro - Right-hand shown

DCSNR/L $\varnothing 20 \times 20 - 32 \times 32$

45°

In figura utensile destro - Right-hand shown

CNMA

CNMG

CNMM

D

CNMA

CNMG

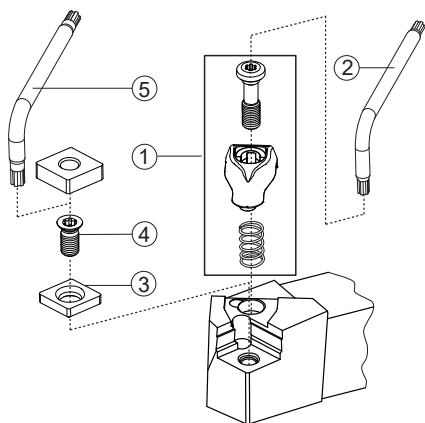
CNMM

D



INSERTI - INSERTS
PAG. 143

ART. (mm)														
R L		h=h1	b	f	l1	l2	Nm		1	2	3	4	5	
DCKNR/L	2020 K 12	20	20	25	125	30	3,9	1204	100-21	5415	3612	125011	5420	
DCKNR/L	2525 M 12	25	25	32	150	33	3,9							
DCKNR/L	3232 P 12	32	32	40	170	34	3,9							
DCSNR/L	2020 K 12	20	20	25	125	35	3,9	1204	100-21	5415	3612	125011	5420	
DCSNR/L	2525 M 12	25	25	32	150	36	3,9							
DCSNR/L	3232 P 12	32	32	40	170	40	3,9							



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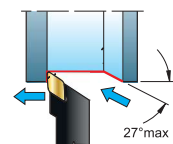
PAG. 136

Vc **PAG. 132**

PAG. 967

PAG. 992

□ 20x20 - 32x32



A cross-sectional diagram of a butt joint. Two plates, represented by hatched areas, are joined by a square groove weld. The weld metal is shown as a solid yellow area filling the groove and extending slightly beyond the plate edges.



														 INSERTI - INSERTS PAG. 145
.G23	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.G62	.G63	.G68	.G72			

(mm)



h=h1

b

f

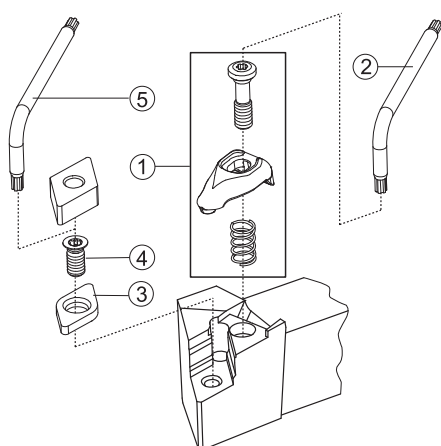
1.



2



DDJNR/L 2020 K 15	20	20	25	125	35	3,9	1506	100-21	5415	3715	125011	5420
DDJNR/L 2525 M 15	25	25	32	150	36	3,9						
DDJNR/L 3232 P 15	32	32	40	170	40	3,9						



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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

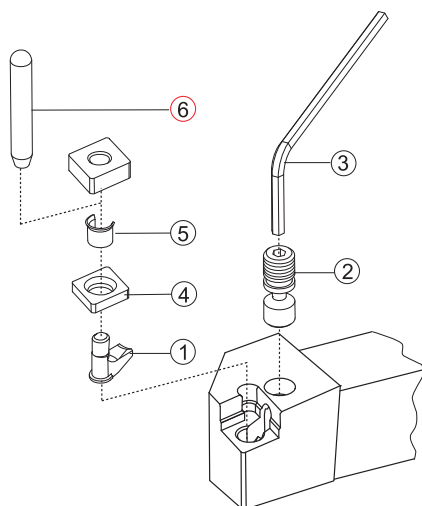
CNMM

P

P



ART. (mm)														
		h=h1		b	f	l1	l2		1	2	3	4	5	6
PCLNR/L	1616 H 09	16	16	20	100	22		0903	8009	1606	5025	3608	4109	0009
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	8012	1608	5003	3612	4112	0012
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	8016	1618	5003	3616	4115	0015
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	8019	1610	5004	3619	4119	0019
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								

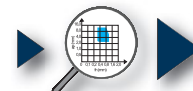


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PAG. 967



PAG. 992

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

75°

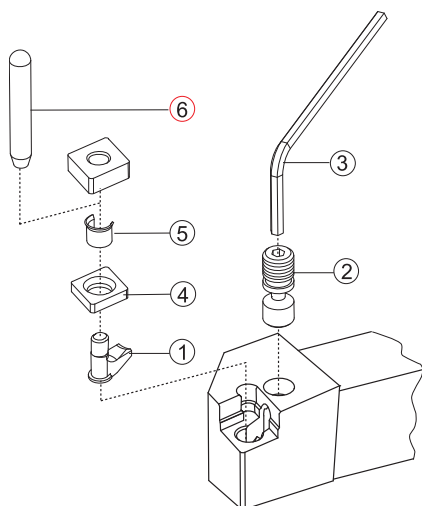
In figura utensile destro - Right-hand shown

PCSNR/L $\varnothing 20 \times 20 - 32 \times 32$

45°

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
		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		8016	1618	5003	3616	4115	0015	
PCKNR/L	3232	P	16	32	32	40	170	34		1906	8019	1610	5004	3619	4119	0019
PCKNR/L	3232	P	19	32	32	40	170	36	8019		1610	5004	3619	4119	0019	
PCKNR/L	4040	S	19	40	40	50	250	45								
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		8016	1618	5003	3616	4115	0015	
PCSNR/L	3232	P	16	32	32	40	170	34		1906	8019	1610	5004	3619	4119	0019
PCSNR/L	3232	P	19	32	32	40	170	40	8019		1610	5004	3619	4119	0019	



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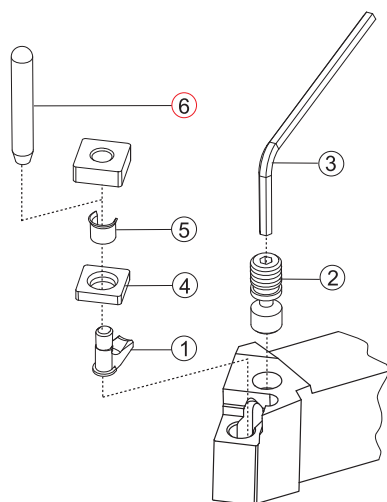
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PSKNR/L								PSSNR/L							
Ø 20x20 - 40x40								Ø 20x20 - 40x40							
75°								45°							
SNMA								SNMA							
SNMG								SNMG							
SNMM								SNMM							
P								P							
In figura utensile destro - Right-hand shown								In figura utensile destro - Right-hand shown							
.G61	.G52	.G53	.G55	.G56	.G62	.G54	.G72	.G82							
ART.															
(mm)															
h=h1 b f l1 l2															
PSKNR/L 2020 K 12			20	20	25	125	26	1204							
PSKNR/L 2525 M 12			25	25	32	150	26	1506	8012	1608	5003	3512	4112	0012	
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	8016	1618	5003	3515	4115	0015	
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								



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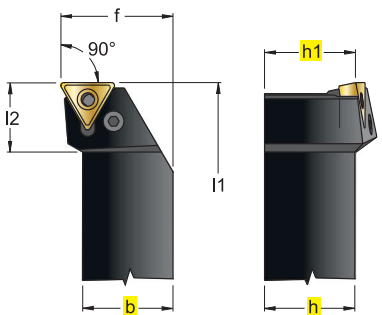
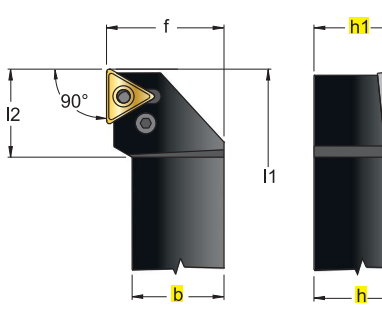
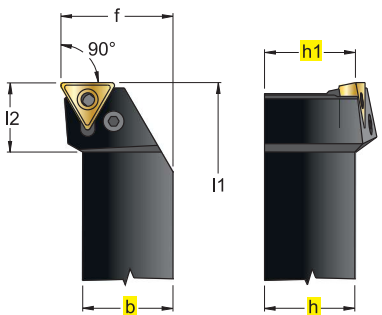
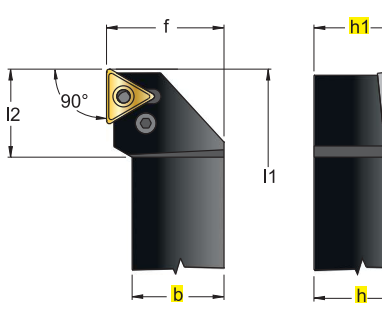
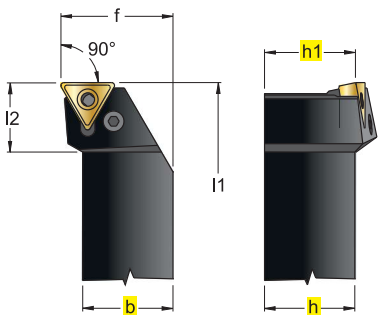
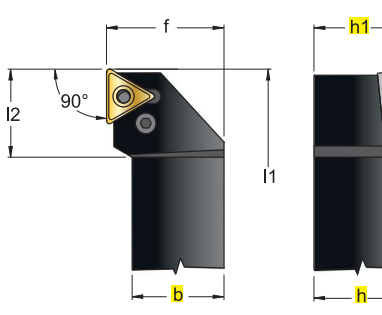
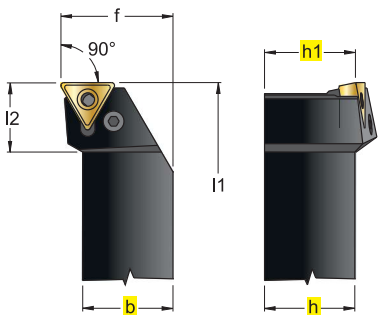
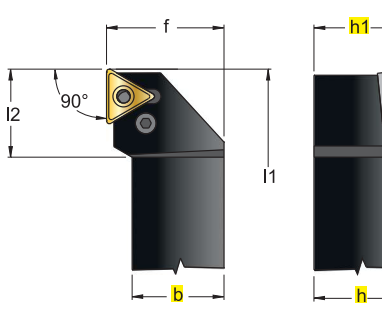
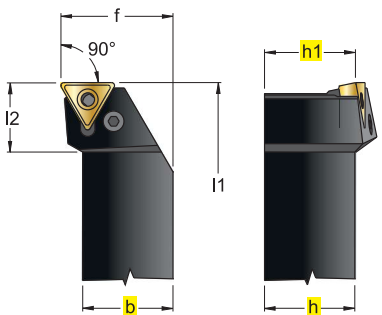
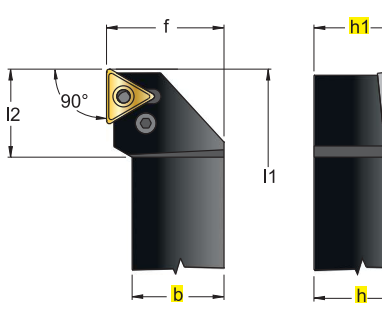
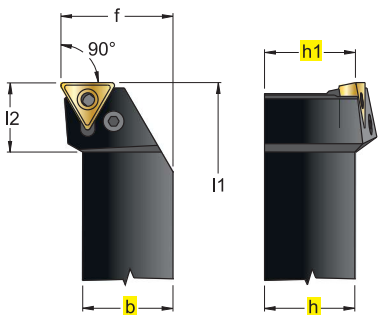
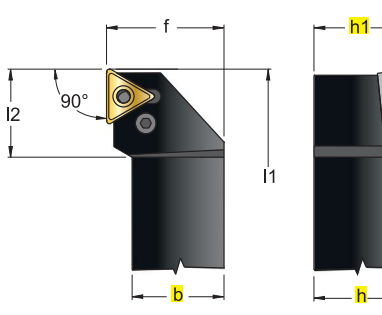
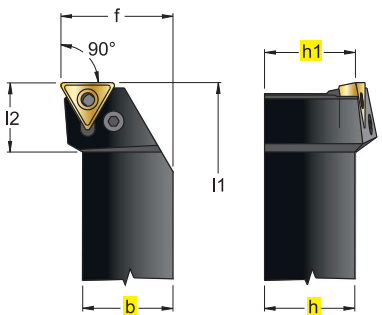
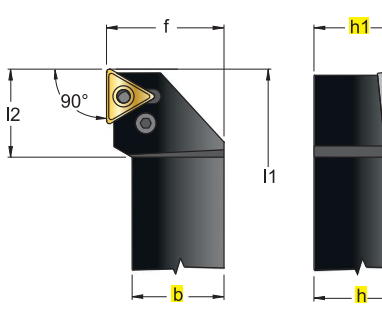
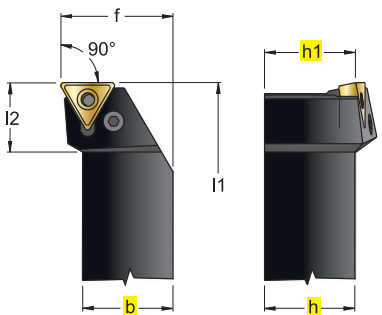
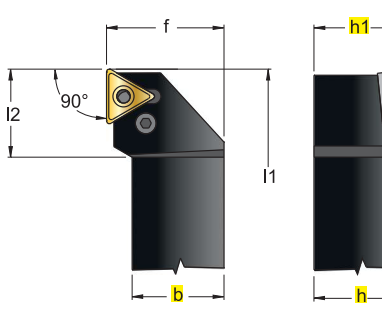
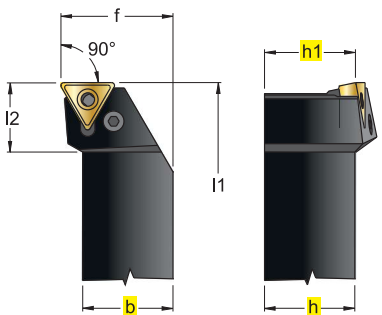
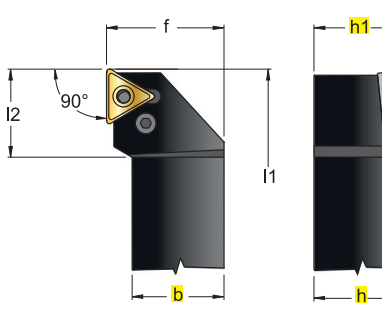
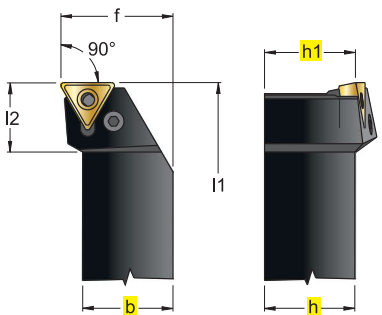
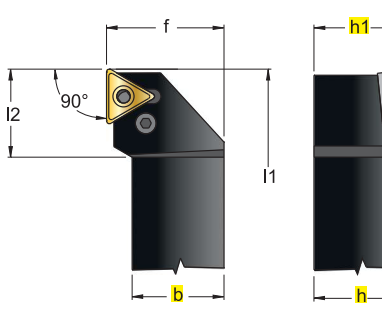
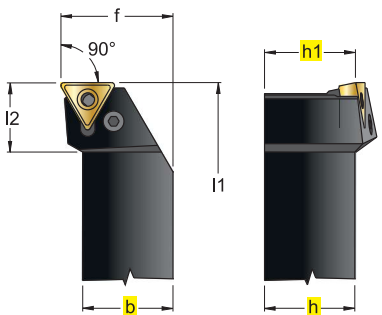
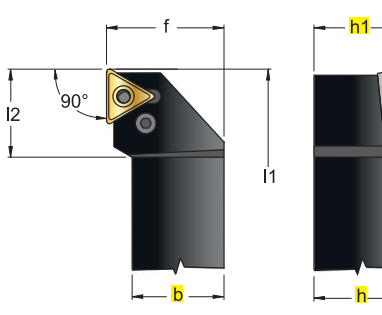
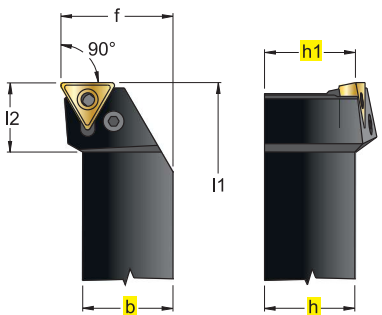
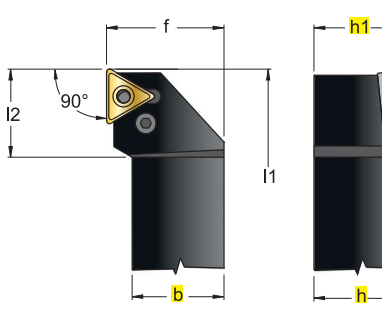
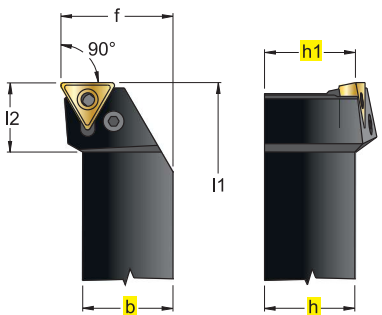
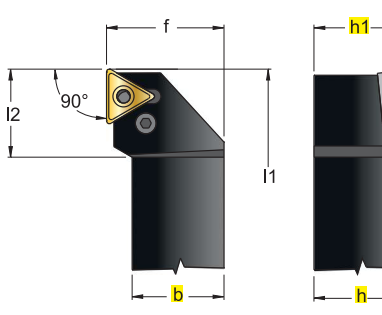
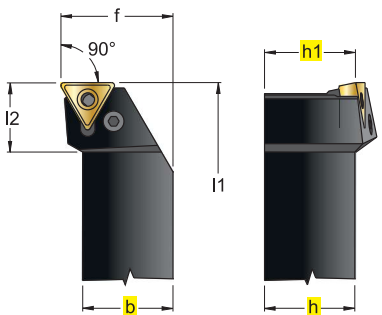
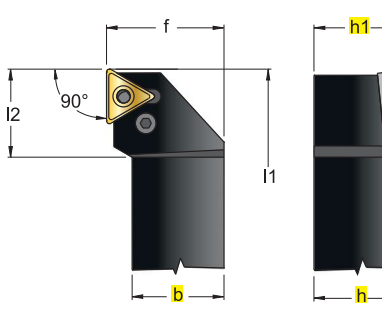
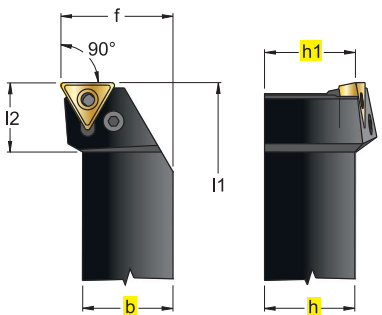
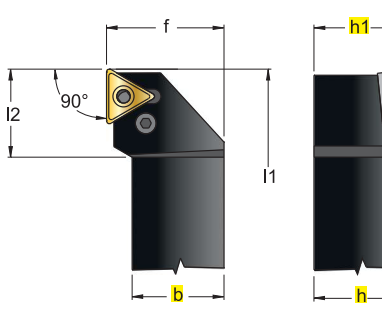
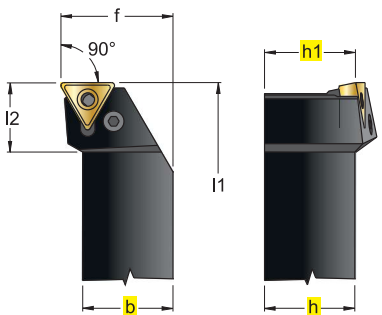
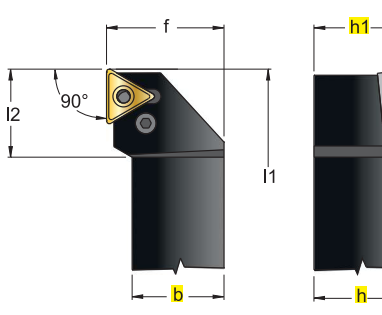
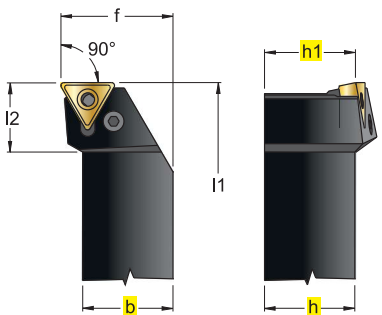
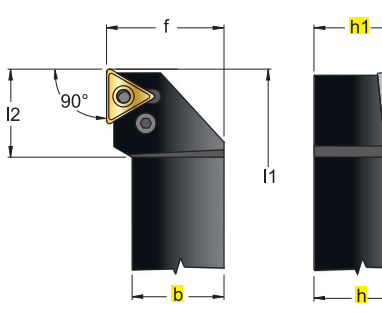
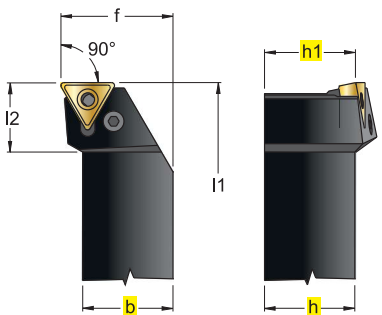
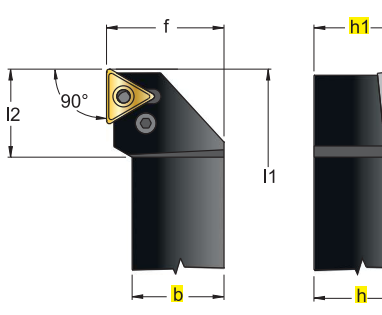
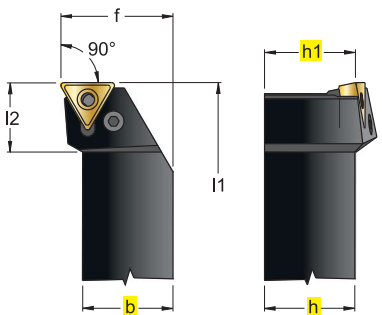
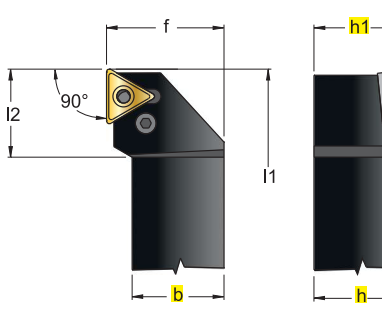
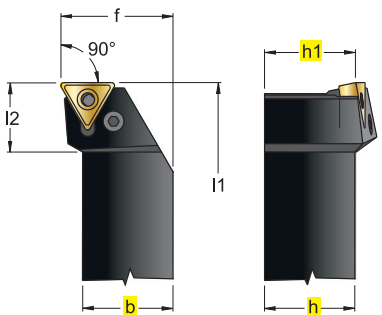
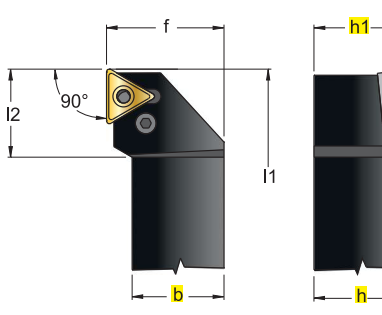
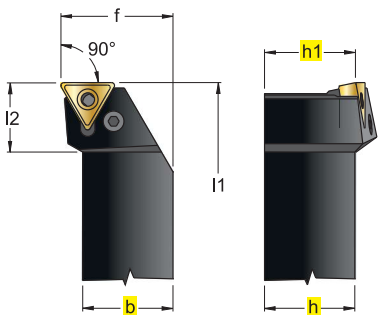
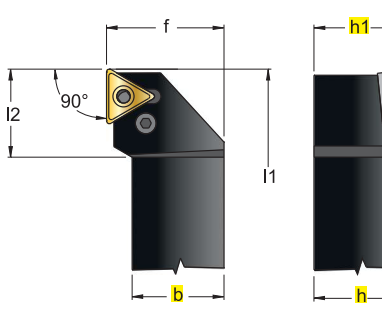
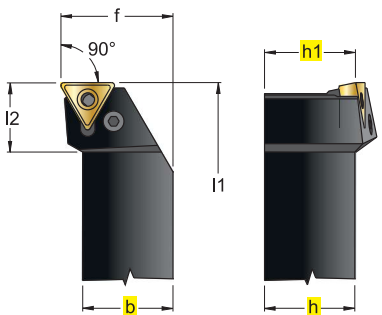
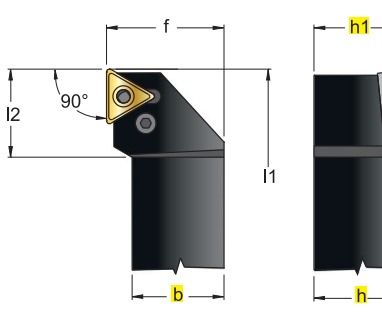
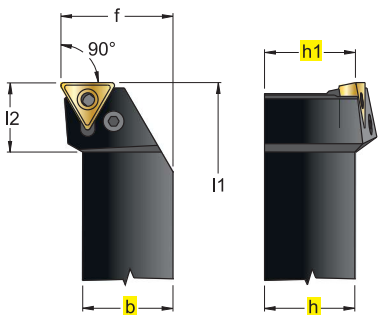
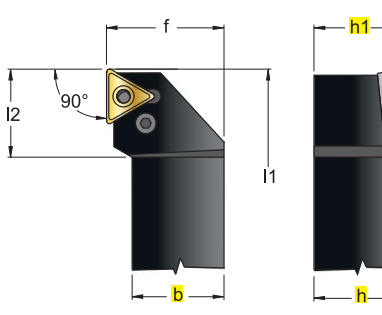
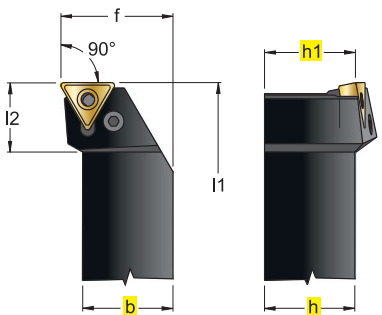
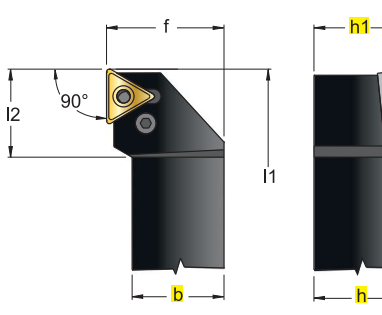
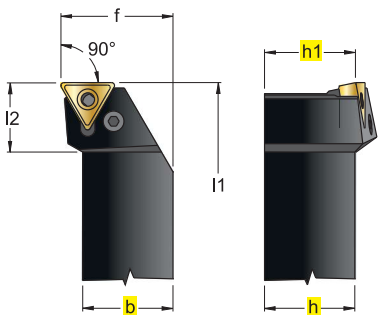
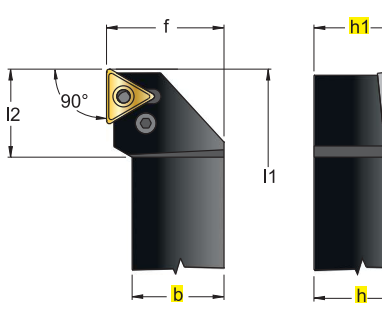
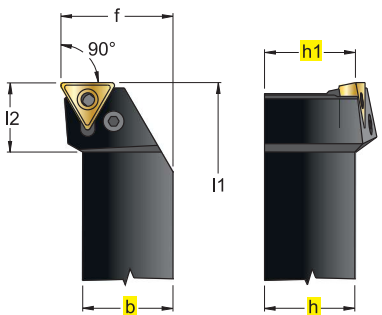
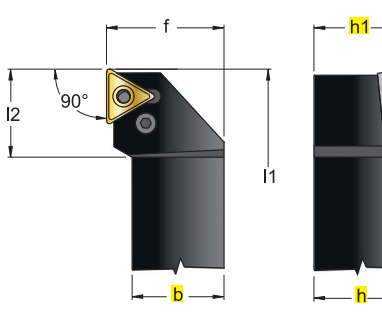
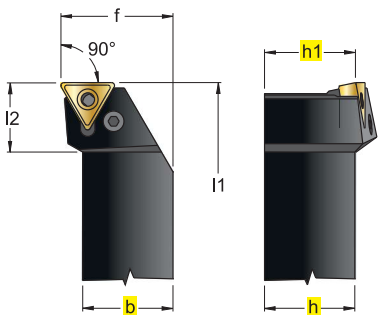
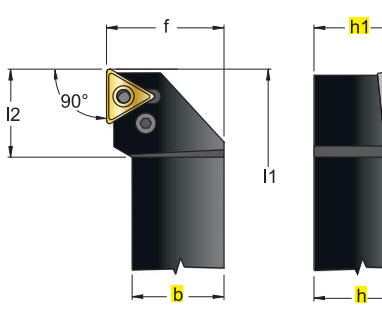
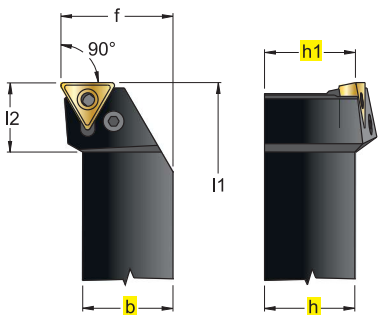
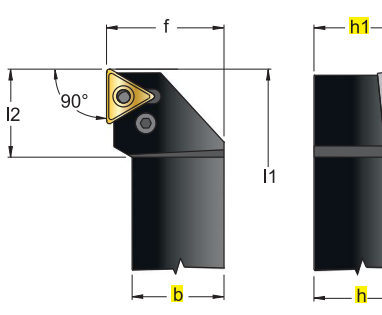
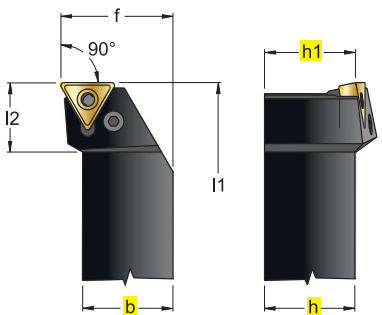
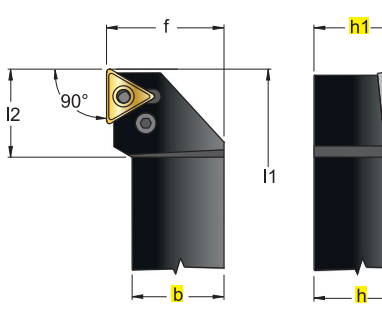
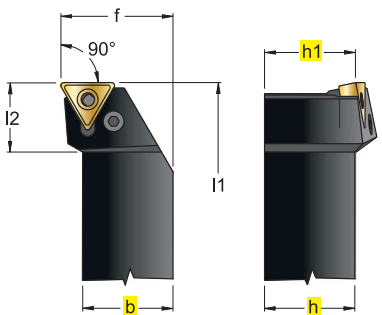
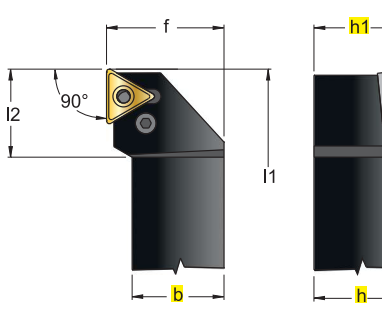
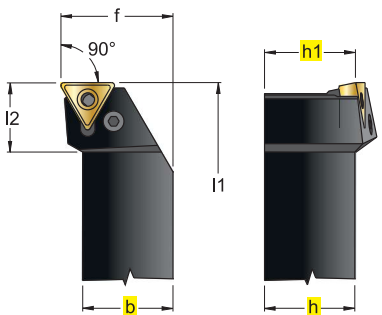
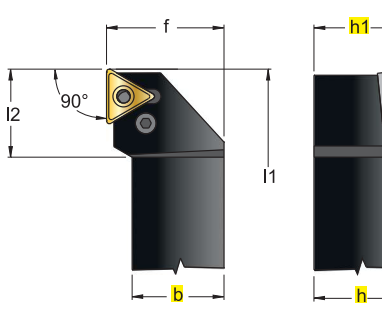
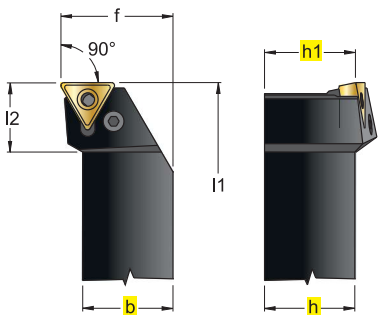
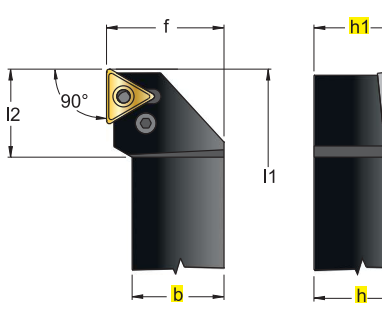
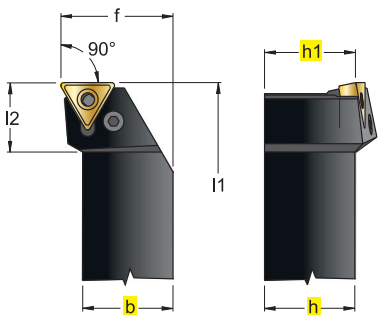
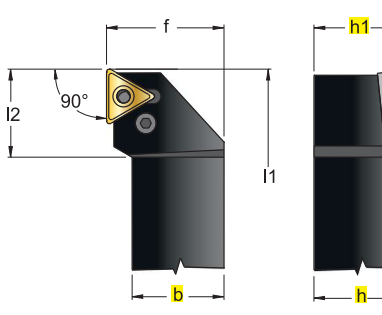
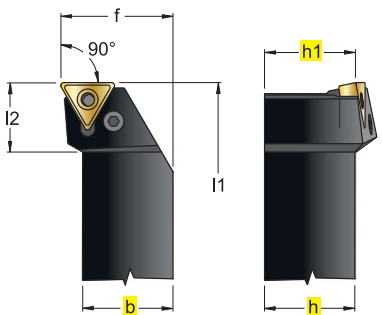
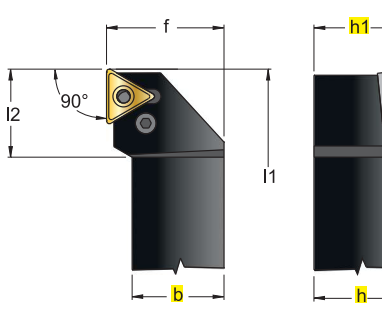
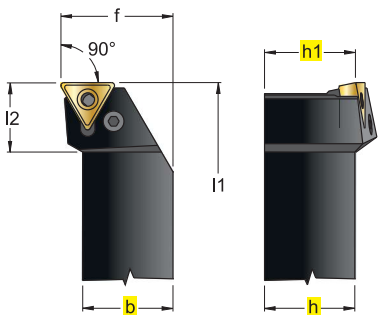
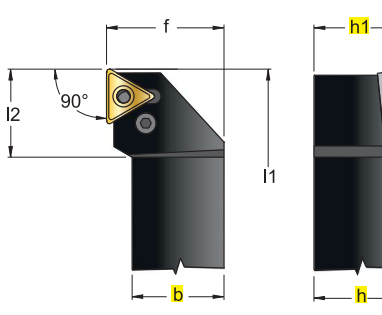
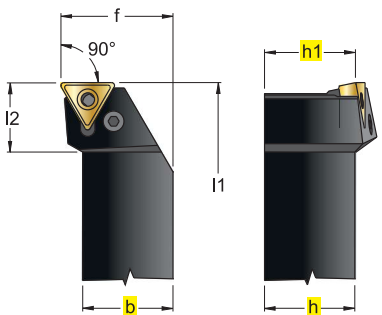
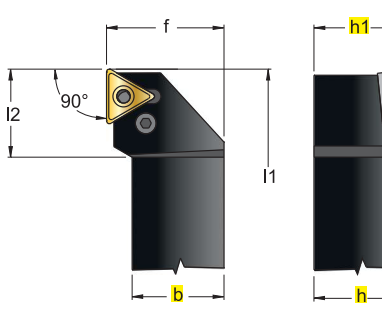
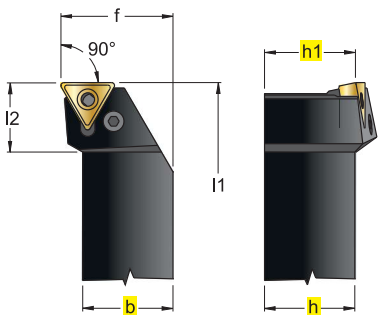
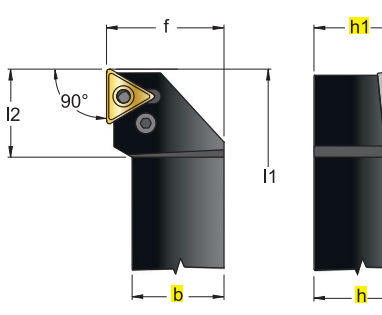
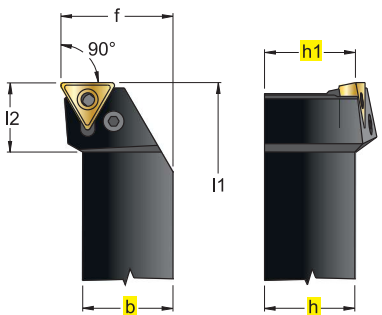
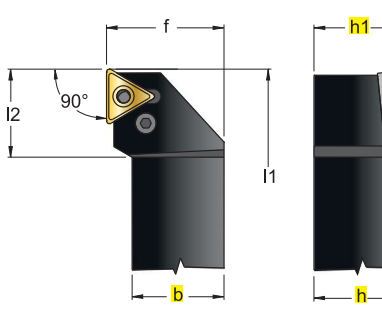
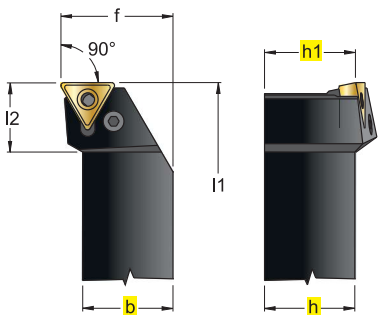
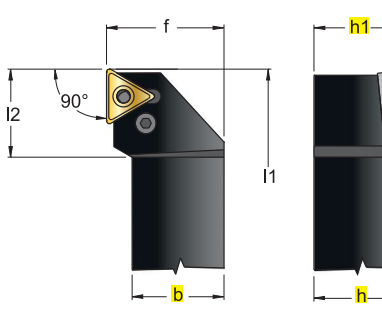
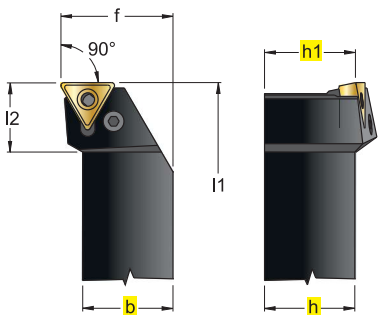
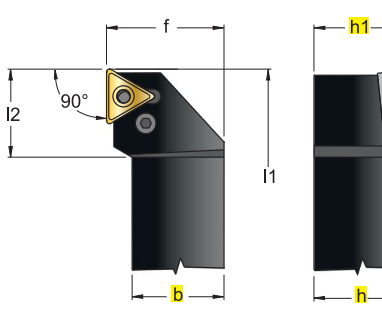
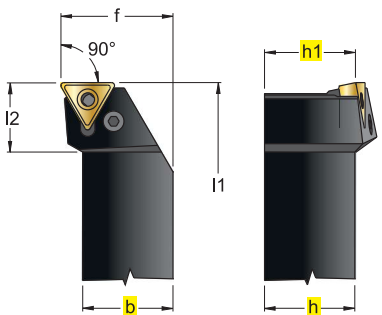
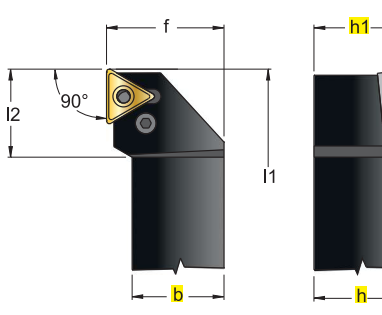
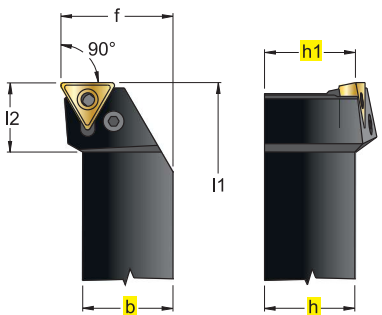
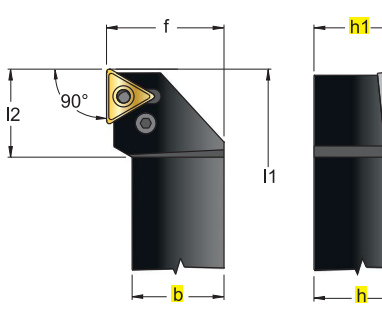
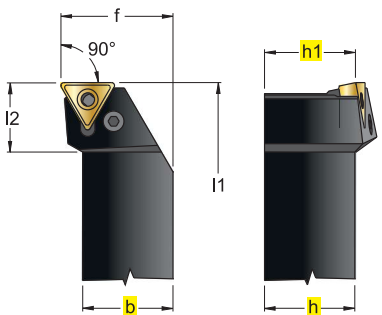
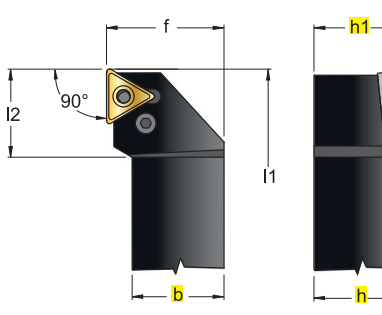
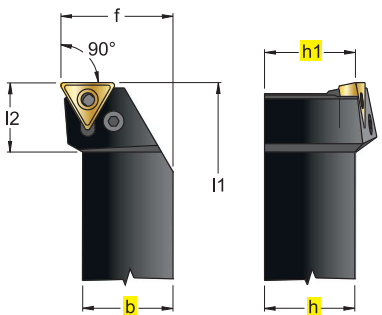
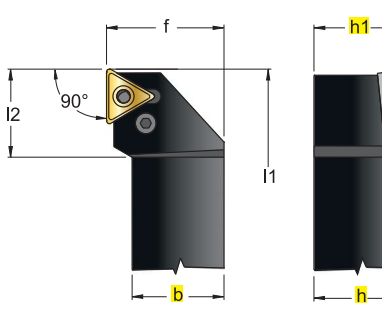
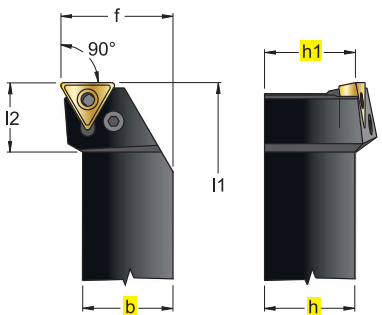
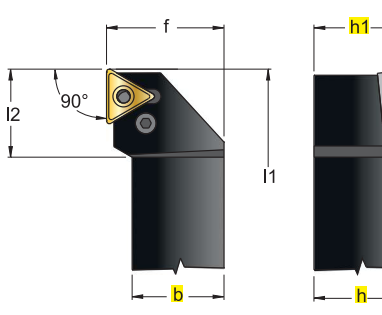
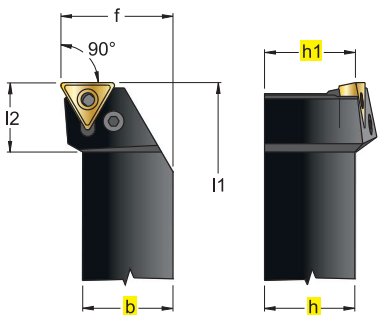
PAG. 132



PAG. 967

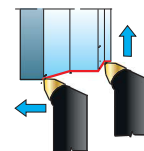
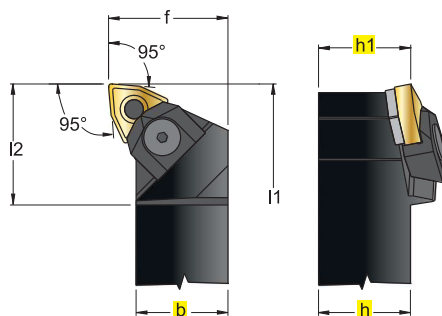


PAG. 992

PTFNR/L $\varnothing 20 \times 20 - 32 \times 32$								PTGNR/L $\varnothing 20 \times 20 - 32 \times 32$							
90°								90°							
															
															
In figura utensile destro - Right-hand shown								In figura utensile destro - Right-hand shown							
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															
															

20x20 - 32x32

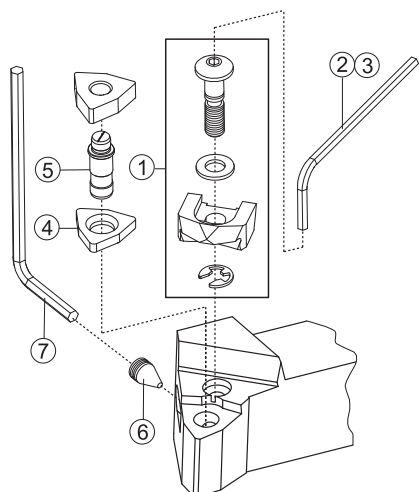
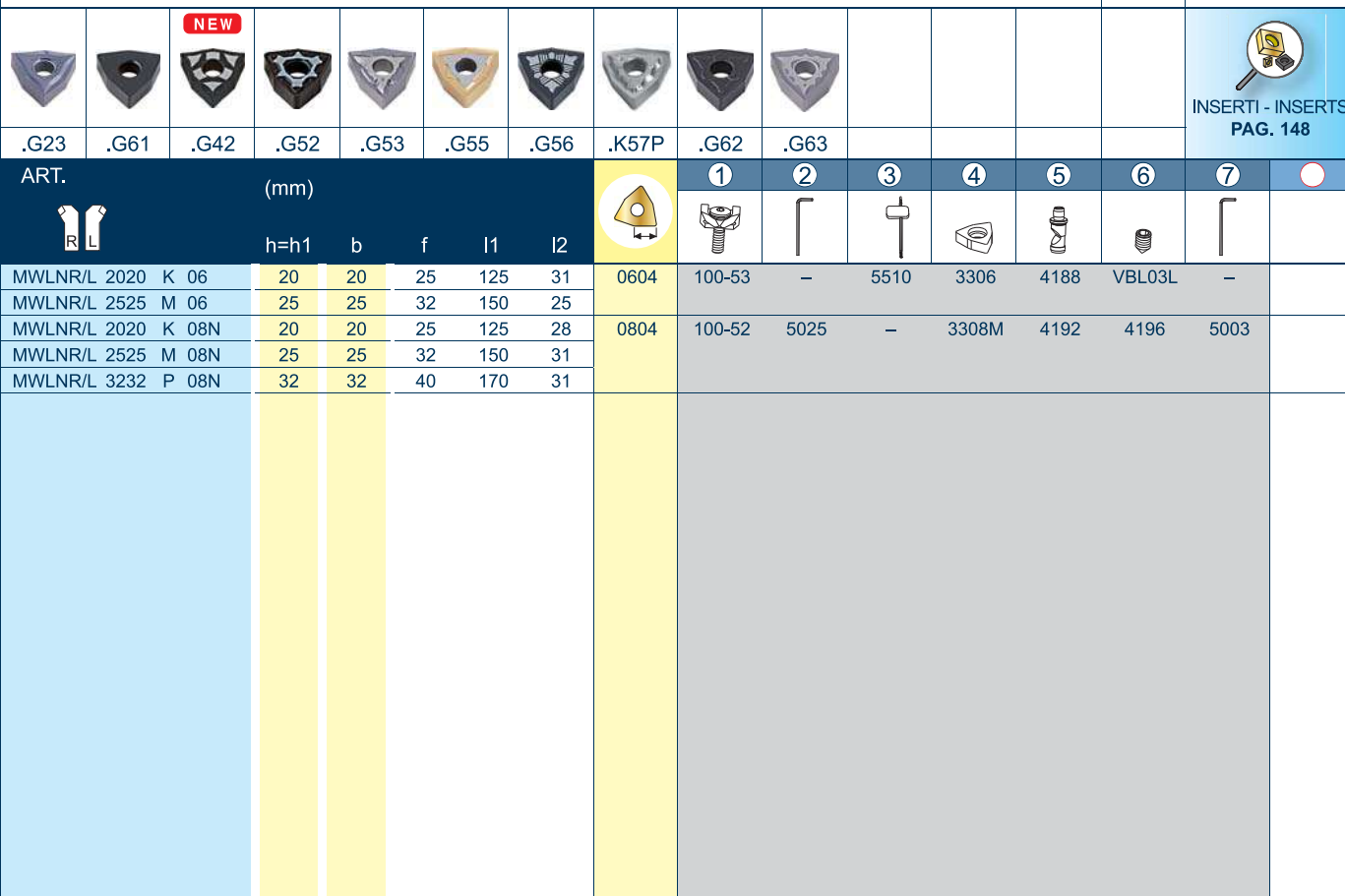
95°



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 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



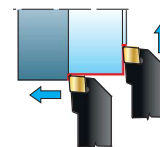
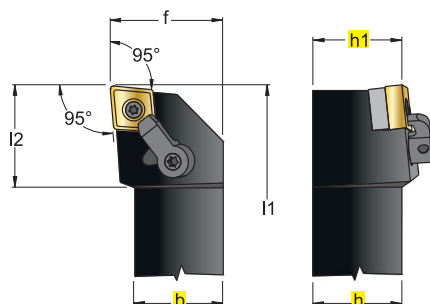
PAG. 967



PAG. 992

⌀ 20x20 - 40x40

95°



M



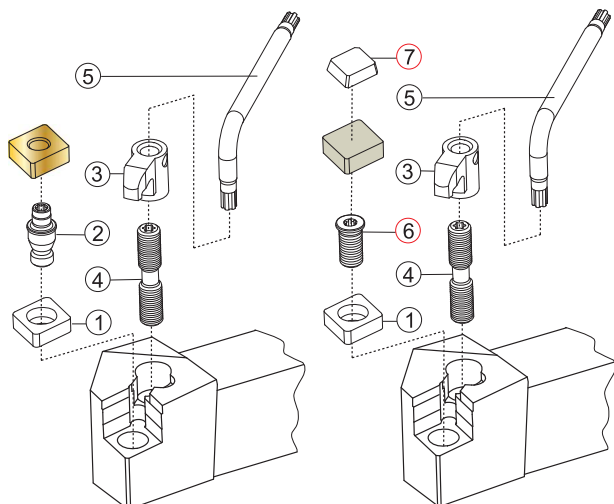
INSERTI - INSERTS
PAG. 143

[illegible]

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

-  - ROMPI TRUCIOLO PER INSERTI CERAMICI E SENZA FORO
-  - CHIP BREAKER FOR CERAMIC INSERTS AND FOR INSERTS WITHOUT BORE
-  - SPANBRECHER FÜR KERAMISCHE WENDEPLATTEN UND FÜR WENDEPLATTEN OHNE KÜHLMITTELBOHRUNG
-  - BRISE-CPEAUX POUR PLAQUETTES CÉRAMIQUES 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

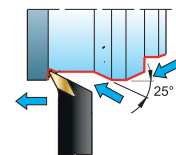
PAG. 136

PAG. 132

PAG. 967

PAG. 992

Ø 20x20 - 32x25

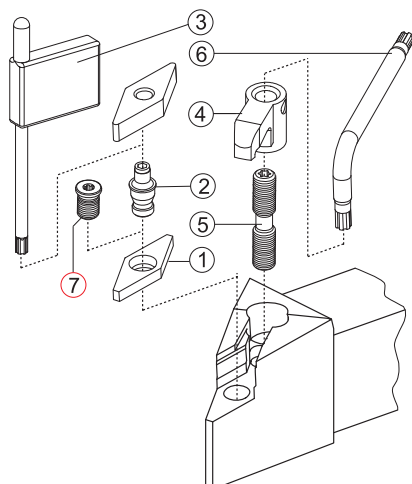
[illegible]**VNMG**

M



		NEW																				
ART.										(mm)										INSERTI - INSERTS PAG. 147		
										h=h1	b	f	l1	l2		① 	② 	③ 	④ 	⑤ 	⑥ 	⑦ 
MVPNR/L	2020	K	16	20	20	25	125	41	1604	KVN323	KLM34L	5508	CKM22	STCM20	5415	KMS 3						
MVPNR/L	2525	M	16	25	25	32	150	41														
MVPNR/L	3225	P	16	32	25	32	170	32														

 - 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

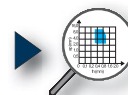


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
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 **TECHNICAL DATA AND SUGGESTIONS**
 **TECHNISCHE DATEN UND EMPFEHLUNGEN**
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

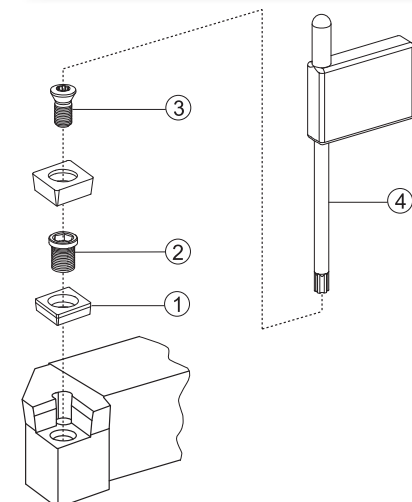


PAG. 967



PAG. 992

SCLCR/L										SCRCR/L									
Ø 08x08 - 25x25										Ø 08x08 - 25x25									
95°										75° NEW									
In figura utensile destro - Right-hand shown										In figura utensile destro - Right-hand shown									
ART. (mm)										1 2 3 4									
h=h1 b f l1 l2 Nm																			
SCLCR/L 0808 D 06										0602									
SCLCR/L 1010 E 06										09T3									
SCLCR/L 1212 F 09										09T3									
SCLCR/L 1616 H 09										1204									
SCLCR/L 2020 K 09																			
SCLCR/L 2525 M 09																			
SCLCR/L 1616 H 12																			
SCLCR/L 2020 K 12																			
SCLCR/L 2525 M 12																			
- 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																			
SCRCR/L 0808 D 06										0602									
SCRCR/L 1010 E 06										09T3									
SCRCR/L 1212 F 09										09T3									
SCRCR/L 1616 H 09										1204									
SCRCR/L 2020 K 09																			
SCRCR/L 1616 H 12																			
SCRCR/L 2020 K 12																			
SCRCR/L 2525 M 12																			
- 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 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



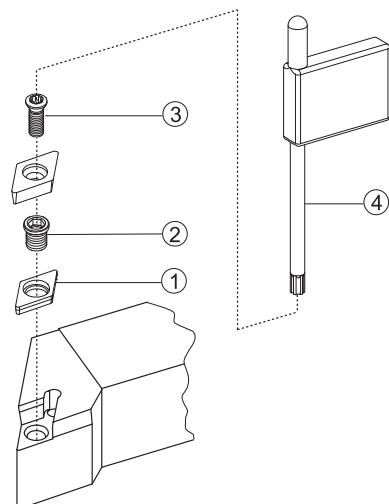
PAG. 967



PAG. 992

SDHCR/L $\varnothing 10 \times 10 - 25 \times 25$							SDJCR/L $\varnothing 08 \times 08 - 25 \times 25$						
107,5°							93°						
In figura utensile destro - Right-hand shown							In figura utensile destro - Right-hand shown						
.G13	.B53	.G57P	.Z57	.G39	.G42	.G52							
ART. (mm)													
h=h1 b f l1 l2 Nm													
SDHCR/L 1010 E 07	10	10	12	70	10	1,1+1,3	0702	—	—	12256P	5508P		
SDHCR/L 1212 F 07	12	12	16	80	12	1,1+1,3							
SDHCR/L 1616 H 11	16	16	20	100	19	3,0+3,5	11T3	3711	BCL7	123511P	5515P		
SDHCR/L 2020 K 11	20	20	25	125	18	3,0+3,5							
SDHCR/L 2525 M 11	25	25	32	150	20	3,0+3,5							
SDJCR/L 0808 D 07	8	8	10	60	14	1,1+1,3	0702	—	—	12256P	5508P		
SDJCR/L 1010 E 07	10	10	12	70	14	1,1+1,3							
SDJCR/L 1212 F 07	12	12	16	80	14	1,1+1,3							
SDJCR/L 1212 F 11	12	12	16	80	21	3,8+5,0	11T3	—	—	12409P	5515P		
SDJCR/L 1616 H 11	16	16	20	100	22	3,0+3,5	11T3	3711	BCL7	123511P	5515P		
SDJCR/L 2020 K 11	20	20	25	125	23	3,0+3,5							
SDJCR/L 2525 M 11	25	25	32	150	27	3,0+3,5							

INSERTI - INSERTS
PAG. 150



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

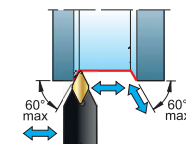


PAG. 967



PAG. 992

Ø 08x08 - 25x25



A cross-sectional diagram of a dovetail joint. It shows a central yellow rectangular piece (the pin) fitted into a gray rectangular hole (the tail) in a larger gray block. The top surface of the gray block is angled downwards at 7 degrees from the horizontal, as indicated by a dimension line and the text "7°".

A cross-sectional diagram of a dovetail joint. It shows a central yellow rectangular piece (the pin) fitted into a corresponding yellow rectangular hole (the tail) within a grey block. The top surface of the joint is angled downwards from the vertical, with a dimension line and an arrow indicating a 7° angle.



INSERTI - INSERTS
PAG. 150

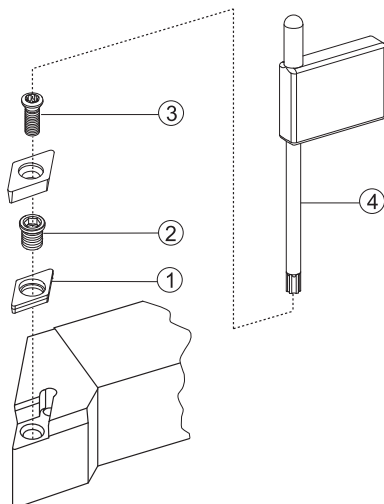
(mm)



h=h1



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					
SDNCN	1212	F	11	12	12	6,0	80	12	3,8÷5,0		11T3	—	—	12409P
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					



PAG. 136



PAG. 132

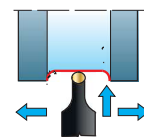
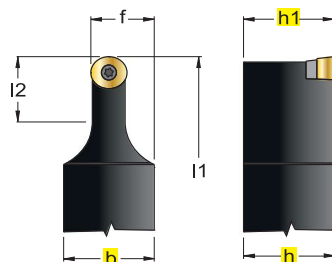
PAG. 967



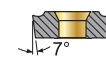
PAG. 992

SRDCN

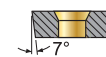
Ø 12x12 - 25x25



RC.T



RC.W



S



.Z57 .G52



INSERTI - INSERTS
PAG. 151

ART.

(mm)



h=h1

b

f

l1

l2

Nm



1

2

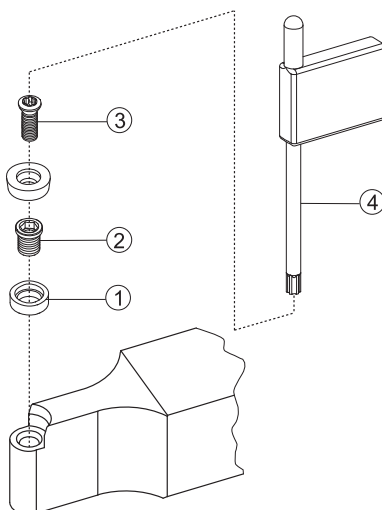
3

4

5



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	0803M0	—	—	123008P	5508P	
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	1003M0	3810	BCL7	123511P	5515P	
SRDCN	1616	H	08	16	16	12,0	100	16,5	1,2+1,5						
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						
SRDCN	2525	M	10	25	25	17,5	150	20,5	3,0+3,5						

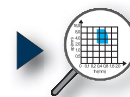


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 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



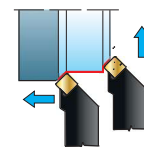
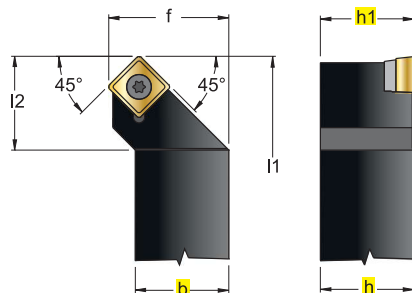
PAG. 967



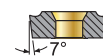
PAG. 992

Ø 12x12 - 25x25

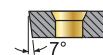
45°



SC.T



SC.W



S



												
.G57P	.Z57	.G52										



INSERTI - INSERTS
PAG. 151

ART.

(mm)



Nm



1

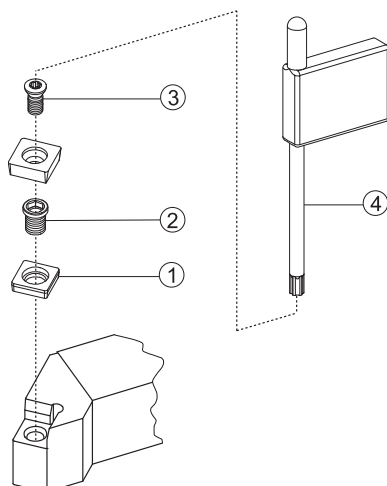
2

3

4



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						

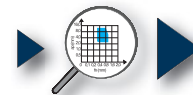


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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

 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
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 DATI TECNICI E CONSIGLI
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PAG. 136



PAG. 132



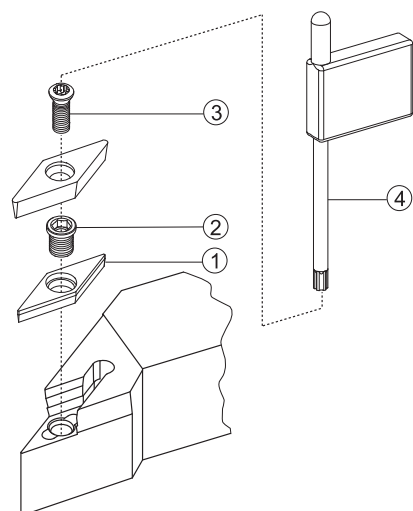
PAG. 967



PAG. 992

SVHCR/L $\varnothing 16 \times 16 - 32 \times 25$					SVJCR/L $\varnothing 12 \times 12 - 32 \times 25$				
107,5°					93°				
In figura utensile destro - Right-hand shown					In figura utensile destro - Right-hand shown				
.G13					.G57P				
.Z57					.G42				
.G52					.G52				
ART. (mm)									
h=h1 b f l1 l2 Nm									
SVHCR/L 1616 H 11					1103				
SVHCR/L 2020 K 11					1103				
SVHCR/L 2525 M 11					1103				
SVHCR/L 2020 K 16					1604				
SVHCR/L 2525 M 16					1604				
SVHCR/L 3225 P 16					1604				
SVJCR/L 1212 F 11					1103				
SVJCR/L 1616 H 11					1103				
SVJCR/L 2020 K 11					1103				
SVJCR/L 2525 M 11					1103				
SVJCR/L 2020 K 16					1604				
SVJCR/L 2525 M 16					1604				
SVJCR/L 3225 P 16					1604				

INSERTI - INSERTS
PAG. 153



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

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TECHNICAL DATA AND SUGGESTIONS
TECHNISCHE DATEN UND EMPFEHLUNGEN
DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132

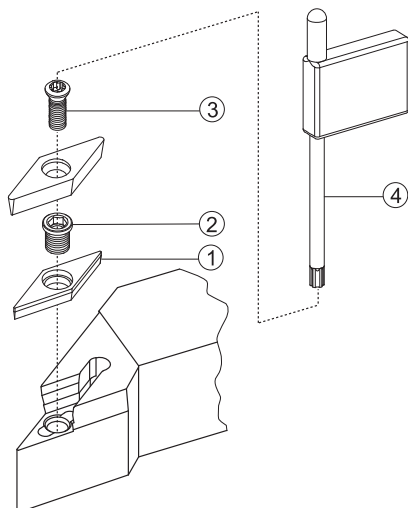


PAG. 967



PAG. 992

SVXCR/L					Ø 20x20 - 25x25					SVVCN					Ø 16x16 - 32x25																								
VC.T					VC.W					VC.T					VC.W																								
S					S					S					S																								
In figura utensile destro - Right-hand shown																																							
.G13 .G57P .Z57 .G42 .G52										INSERTI - INSERTS PAG. 153																													
ART. (mm)																																							
h=h1					b					f					I1					I2					Nm														
SVXCR/L 2020 K 16					20					20					25					125					25					3,0+3,5					1604				
SVXCR/L 2525 M 16					25					25					32					150					25					3,0+3,5									
SVVCN 1616 H 11					16					16					8,0					100					26					1,1+1,3					1103				
SVVCN 2020 K 11					20					20					10,0					125					32					1,1+1,3									
SVVCN 2525 M 11					25					25					12,5					150					40					1,1+1,3									
SVVCN 2020 K 16					20					20					10,0					125					34					3,0+3,5					1604				
SVVCN 2525 M 16					25					25					12,5					150					42					3,0+3,5									
SVVCN 3225 P 16					32					25					12,5					170					42					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

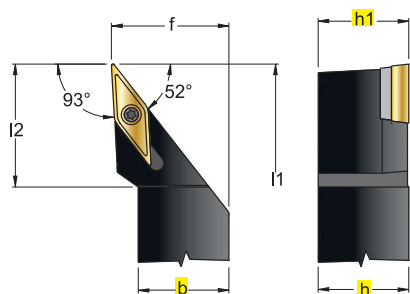


PAG. 992

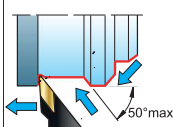
SVJBR/L

∅ 16x16 - 32x25

93°



In figura utensile destro - Right-hand shown



VB.T



VB.W



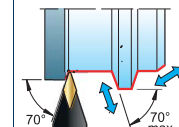
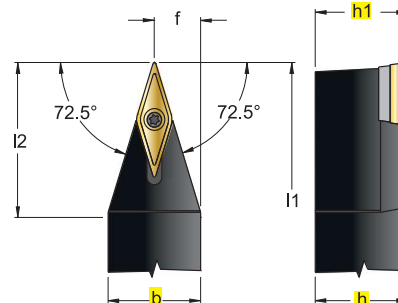
S



SVVBN

∅ 20x20 - 32x25

72,5°



VB.T



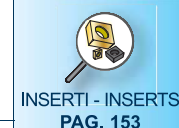
VB.W



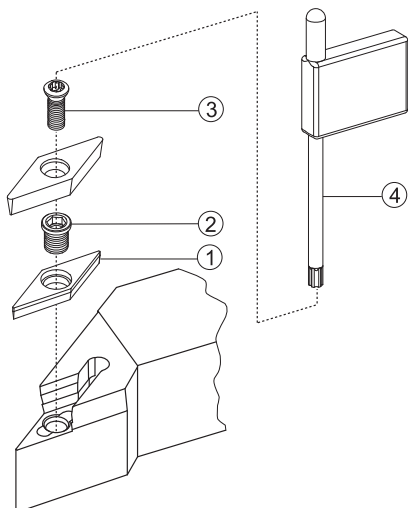
S



.G42 .G52 .G58



ART.		(mm)								①	②	③	④	
		h=h1	b	f	l1	l2	Nm							
SVJBR/L	1616 H 16	16	16	20	100	30	3,0÷3,5	1604		BCL7	123511P	5515P		
SVJBR/L	2020 K 16	20	20	25	125	30	3,0÷3,5							
SVJBR/L	2525 M 16	25	25	32	150	33	3,0÷3,5							
SVJBR/L	3225 P 16	32	25	32	170	33	3,0÷3,5							
SVVBN	2020 K 16	20	20	10,0	125	34	3,0÷3,5	1604		BCL7	123511P	5515P		
SVVBN	2525 M 16	25	25	12,5	150	42	3,0÷3,5							
SVVBN	3225 P 16	32	25	12,5	170	42	3,0÷3,5							

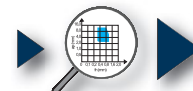


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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



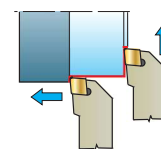
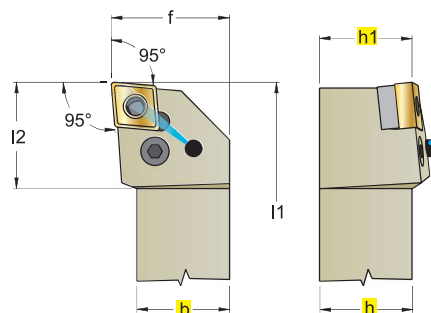
PCLNR/L..TTS

  20x20 - 32x32

95 

NEW

RANGE DI
UTILIZZO
15-80 bar
APPLICATION
RANGE
15-80 bar



CNMA



CNMG



CNMM



P

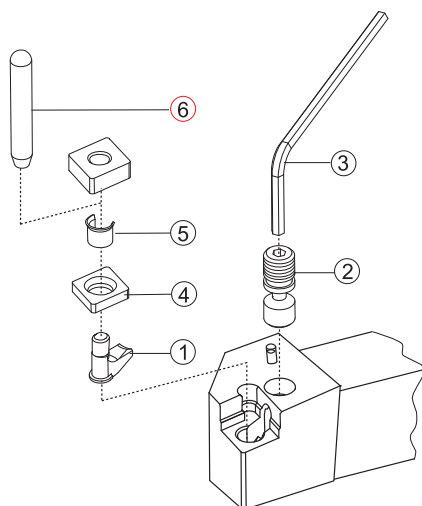


In figura utensile destro - Right-hand shown

.G23	.G61	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82	INSERTI - INSERTS PAG. 143
ART.										(mm)					
										h=h1					
										b					
										f					
										l1					
										l2					
										1204					
										8012					
										1608					
										5003					
										3612					
										4112					
										0012					

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

	• Tubo dritto raccordato Fitted hose, straight		• Tubo dritto raccordato Fitted hose, straight		• Tubo dritto raccordato Fitted hose, straight
PAG. 965		PAG. 965		PAG. 965	
	• Raccordo dritto Straight fitting		• Riduzione Adapter		• Raccordo 90� 90� Fitting
PAG. 965		PAG. 966		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

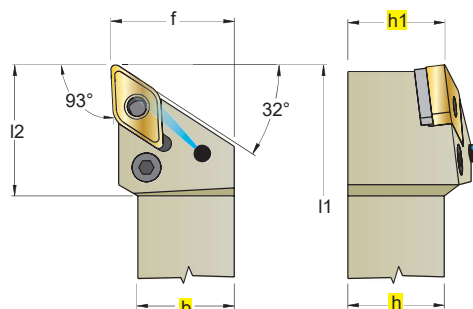
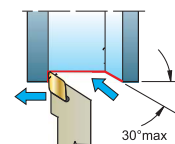


PAG. 992

⌀ 20x20 - 32x32

NEW

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



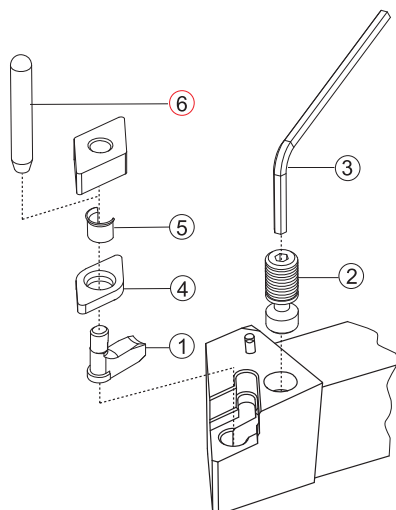
P



														 INSERTI - INSERTS PAG. 145	
.G23	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.G62	.G63	.G68	.G72				
ART. (mm)										①	②	③	④	⑤	⑥
		h=h1		b	f	l1	l2								
PDJNR/L	2020	K	15 TTS	20	20	25	125	35		8415	1638	5003	3715	4112	0012
PDJNR/L	2525	M	15 TTS	25	25	32	150	35							
PDJNR/L	3225	P	15 TTS	32	25	32	170	35							
PDJNR/L	3232	P	15 TTS	32	32	40	170	36							

The image displays six different hydraulic hose fittings arranged in a 2x3 grid. Each fitting is shown in a technical drawing style with dimensions and labels.

- Top Row:** Three straight fittings of different lengths.
 - 150mm: Tubo dritto raccordato / Fitted hose, straight. Part number: PAG. 965.
 - 225mm: Tubo dritto raccordato / Fitted hose, straight. Part number: PAG. 965.
 - 300mm: Tubo dritto raccordato / Fitted hose, straight. Part number: PAG. 965.
- Bottom Row:** Four fittings of different types.
 - Raccordo dritto / Straight fitting. Part number: PAG. 965.
 - Riduzione / Adapter. Part number: PAG. 966.
 - Raccordo 90° / 90° Fitting. Part number: PAG. 966.
 - B-SEAL M10. Part number: PAG. 966.



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



PAG. 136



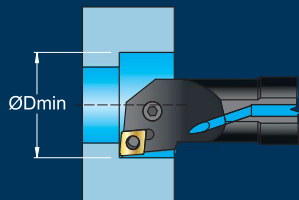
PAG. 132



PAG. 967



PAG. 992

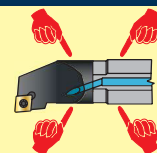


UTENSILI CON STELO IN METALLO DURO

TOOLS WITH CARBIDE SHAFT

WERKZEUGE MIT HM-SCHAFT

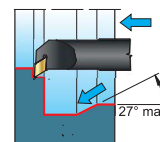
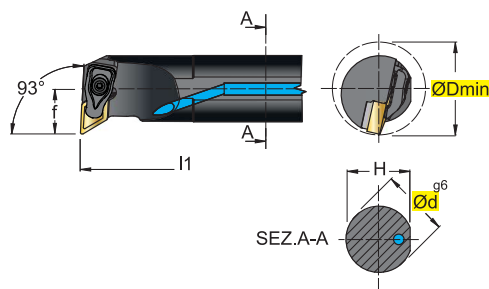
OUTILS AVEC QUEUE EN METAL DUR



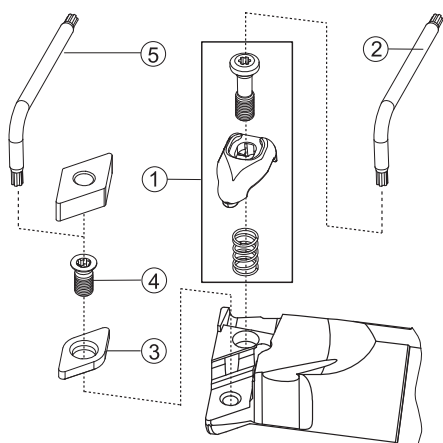
S		S		S		S		S	
A..SCLCR/L Pag.61		A..SDUCR/L Pag.65		A..SDQCR/L Pag.70		A..SVOCR/L Pag.75		A..SSKCR/L Pag.79	
ØDmin 8,5		ØDmin 12,5		ØDmin 16,0		ØDmin 16,0		ØDmin 20,0	
	CC.. 0602..		DC.. 0702..		DC.. 0702.. 11T3..		VC.. 1103.. 1604..		SC.. 09T3.. 1204..
S..SCLCR/L Pag.61		S..SDUCR/L Pag.65		E..SDQCR/L 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

95°



D

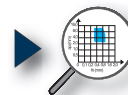
[illegible]

 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 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



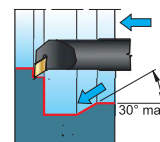
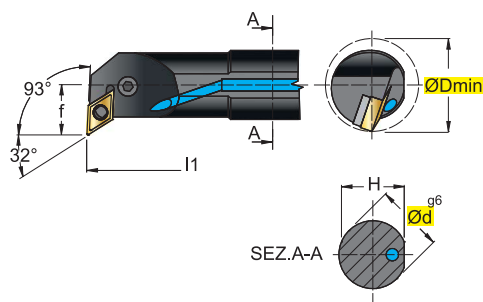
PAG. 967



PAG. 992

Ø20 - Ø50

93°

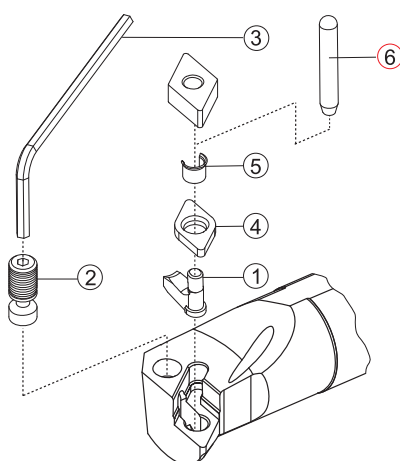


P



INSERTI - INSERTS
PAG. 145

														 INSERTI - INSERTS PAG. 145		
.G23	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.G62	.G63	.G68	.G72					
ART.										①	②	③	④	⑤	⑥	
			(mm)													
			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									
A32S	PDUNR/L	15	40	32	22	31,0	250		1506	8415	1638	5003	3715	4112	0012	
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 V_c
 V_c . CUTTING SPEED
 V_c . SCHNITTGESCHWINDIGKEIT
 V_c . VITESSE DE COUPE

PAG. 132

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

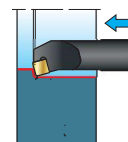
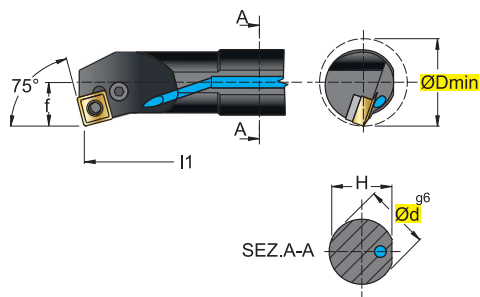
PAG. 967

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

PAG. 992

Ø25 - Ø40

75°



P



INSERTI - INSERTS
PAG. 146



G61	G52	G53	G55	G56	G62	G54	G72	G82
-----	-----	-----	-----	-----	-----	-----	-----	-----

ART. (mm)



$\varnothing D_{min}$	$\varnothing d$	f	H	l1
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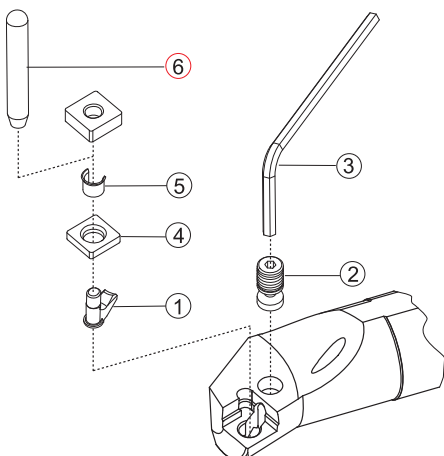


1	2	3	4	5	6
---	---	---	---	---	---



A25R	PSKNR/L	12	32	25	17	24,0	200	1204	8012	1648	5003	3512	4112	0012
------	---------	----	----	----	----	------	-----	------	------	------	------	------	------	------

A32S	PSKNNL	12	40	32	22	31,0	250								
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



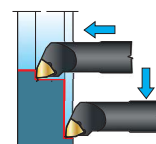
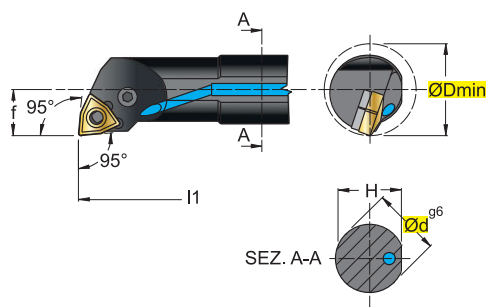
PAG. 967



PAG. 992

Ø16 - Ø40

95°



P



INSERTI - INSERTS
PAG. 148



(mm)



ØDmir

ØDmir

ØDmir

ØDmir

ØDmir

ØDmir

ØDmir

ØDmir

ØDmir



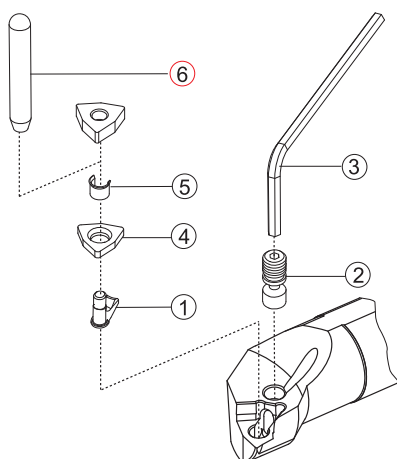
€



5



A16M	PWLNR/L	06	21	16	11	15,25	150	0604	8216	1605	5002	—	—	—
A20Q	PWLNR/L	06	25	20	13	19,0	180		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		8012	1608	5003	3308M	4112	0012
A25R	PWLNR/L	08	32	25	17	24,0	200	0804	8012	1608	5003	3308M	4112	0012
A32S	PWLNR/L	08	40	32	22	31,0	250		8012	1608	5003	3308M	4112	0012
A40T	PWLNR/L	08	50	40	27	38,5	300		8012	1608	5003	3308M	4112	0012

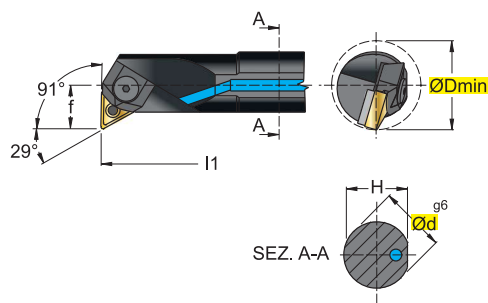


PAG. 992

A..MTFNR/L

Ø25 - Ø50

91°



in figura utensile destro - right-hand shown

TNMA



TNMG



TNMM

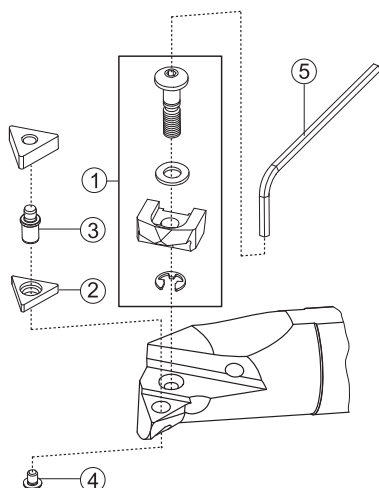


M



INSERTI - INSERTS
PAG. 147

ART. (mm)															
										1	2	3	4	5	
ØDmin	Ød	f	H	l1											
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



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

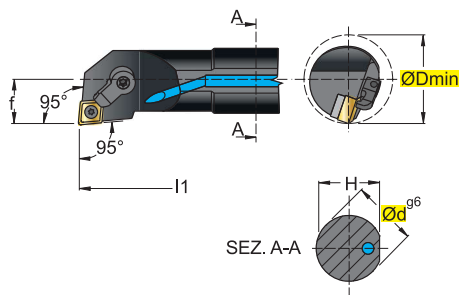


PAG. 992

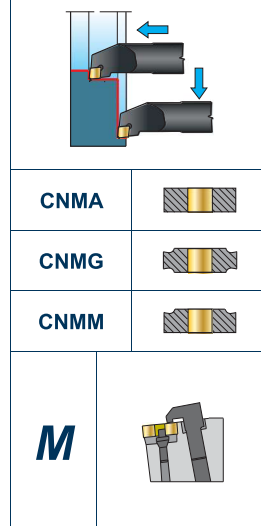
A..MCLNR/L

Ø25 - Ø50

95°



In figura utensile destro - Right-hand shown

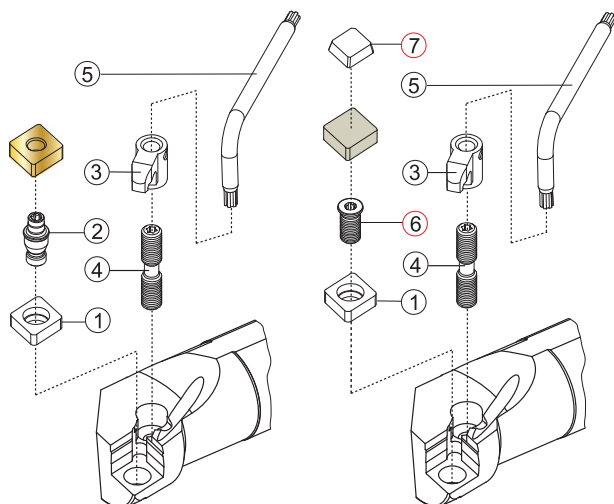


															 INSERTI - INSERTS PAG. 143	
.G23 .G61 .B32 .G39 .G42 .G52 .G53 .G55 .G56 .K57P .G62 .G63 .G68 .G72 .G82																
ART. (mm)										①	②	③	④	⑤	⑥	⑦
																
A25R	MCLNR/L	12	32	25	17	24,0	200	1204		—	KLM 44	CKM 21	STCM 20	5415	—	—
A32S	MCLNR/L	12	40	32	22	31,0	250	1204		KCN 433	KLM 46	CKM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

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

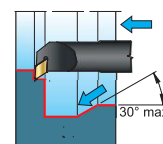
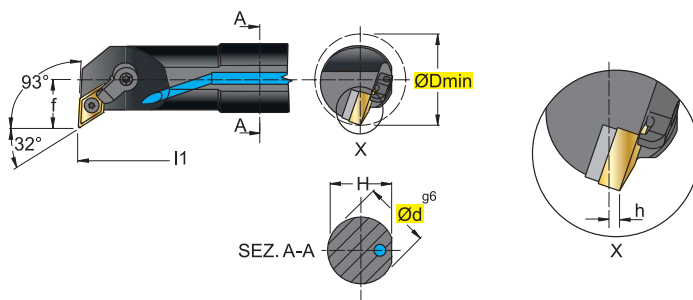
PAG. 132

PAG. 967

PAG. 992

Ø25 - Ø40

93°



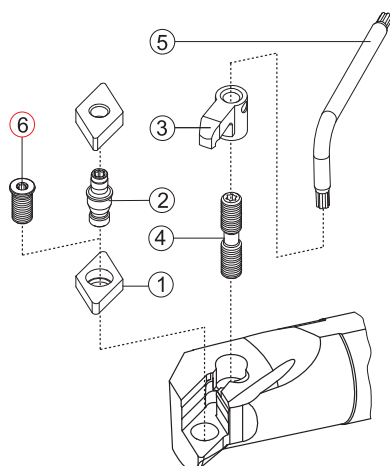
M



INSERTI - INSERTS
PAG. 145

														 INSERTI - INSERTS PAG. 145		
.G23	.B32	.G39	.G42	.G52	.G53	.G55	.G56	.G62	.G63	.G68	.G72					
ART.											①	②	③	④	⑤	⑥
																
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

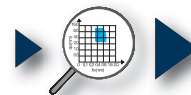


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 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



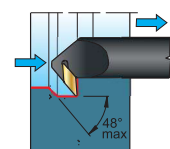
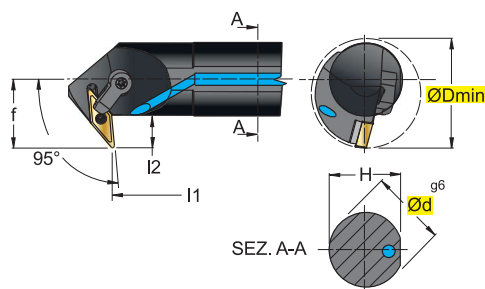
PAG. 967



PAG. 992

A..MVZNR/L

Ø32 - Ø40



VNMG



M



In figura utensile destro - Right-hand shown

NEW															 INSERTI - INSERTS PAG. 147		
																	
.G23	.G42	.G52	.G53	.G55													
ART.										①	②	③	④	⑤	⑥	⑦	
 																	
ØDmin	Ød	f	H	I1	I2												
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									

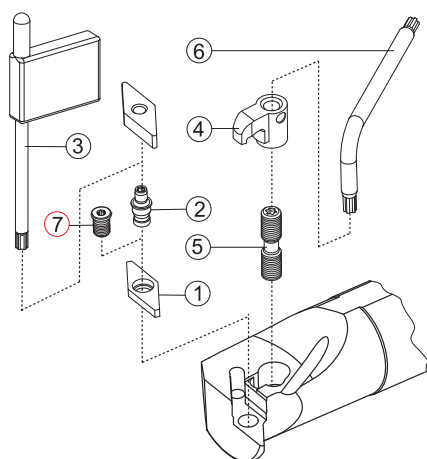
 - VITE DI FISSAGGIO DEL SOTTOPLACCHETTA PER INSERTI SENZA FORO

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



PAG. 136



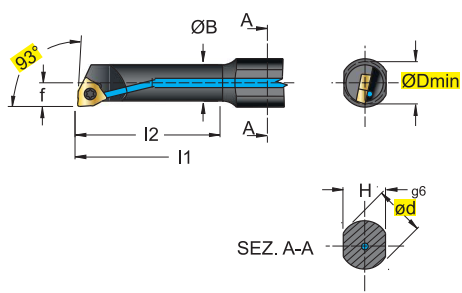
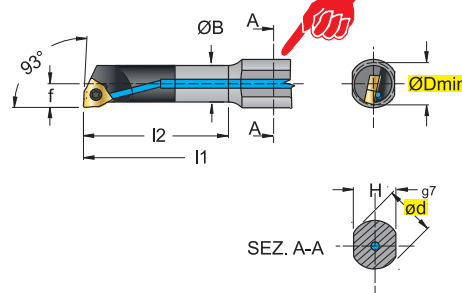
PAG. 132

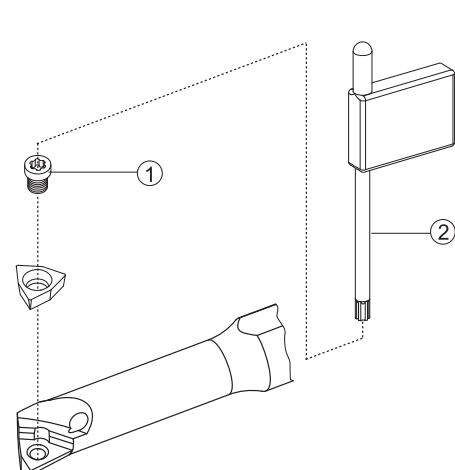


PAG. 967



PAG. 992

A..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										12203 5506									
A0608H SWUCR/L 02										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																			
E05F SWUCR/L 02										12203 5506									
E06G SWUCR/L 02										12203 5506									
E0508H SWUCR/L 02										12203 5506									
E0608H SWUCR/L 02										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																			
																			
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 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

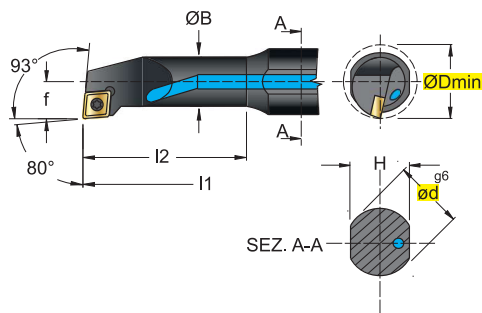


PAG. 992

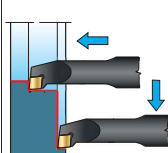
A..SCUPR/L

Ø8 - Ø16

93°



In figura utensile destro - Right-hand shown



CP.T



CP.W



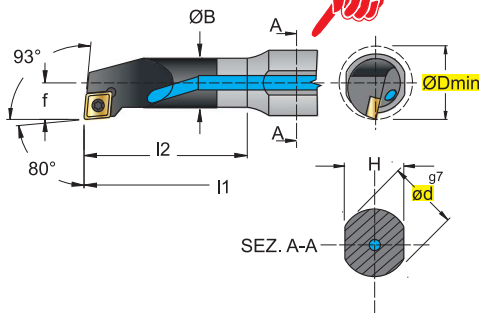
S



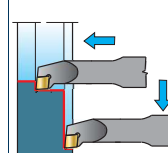
E..SCUPR/L

Ø8 - Ø16

93°



In figura utensile destro - Right-hand shown



CP.T



CP.W



S



NEW



INSERTI - INSERTS
PAG. 150

ART.		(mm)													
		ØDmin	Ød	ØB	f	H	l1	l2	Nm						
A0608H	SCUPR/L 05	8,0	8	6	4,5	7	100	20	0,9+1,0		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						

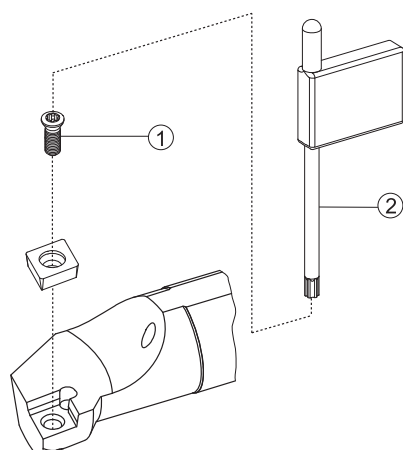
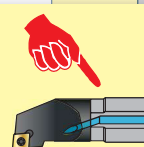
E0608H	SCUPR/L 05	8	8	6	4,5	7	100	30	0,9+1,0		12224	5507		
E0810J	SCUPR/L 05	11	10	8	6,0	9	110	36	0,9+1,0					
E1012K	SCUPR/L 05	13	12	10	7,0	11	125	44	0,9+1,0					
E1216M	SCUPR/L 05	16	16	12	9,0	15	150	55	0,9+1,0					



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



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

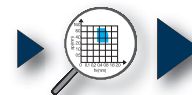


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

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

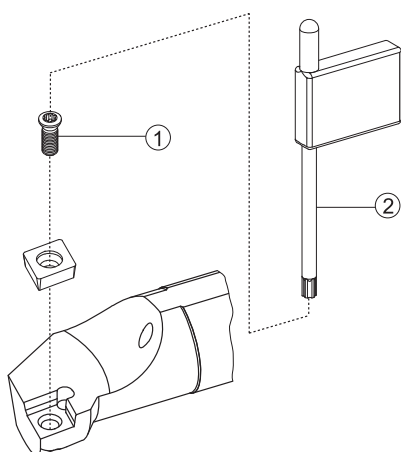


PAG. 967



PAG. 992

A..SCLCR/L Ø8 - Ø16										S..SCLCR/L Ø8 - Ø16									
95°										95°									
In figura utensile destro - Right-hand shown										In figura utensile destro - Right-hand shown									
ART. (mm) 																			
ØDmin Ød ØB f H I1 I2 Nm										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																			
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

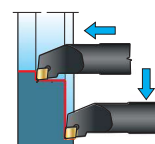
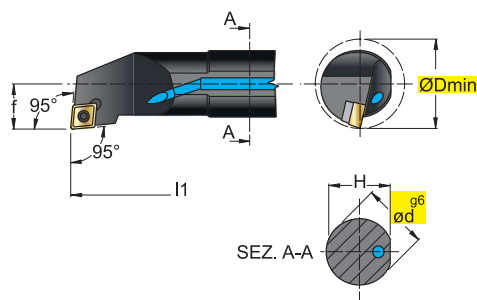
PAG. 967

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



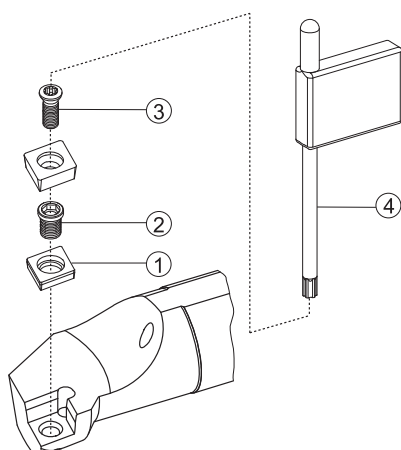
PAG. 132



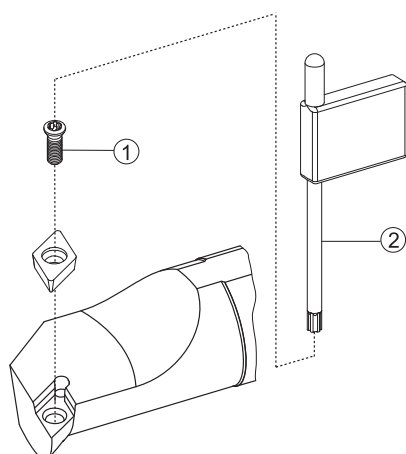
PAG. 967



PAG. 992



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. (mm)										INSERTI - INSERTS PAG. 150									
ØDmin										Ød									
f										a									
H										l1									
l2										Nm									
0702										12254P 5507P									
A0810H SDUCR/L 07										12,5 10 7 4 9 100 22 1,0+1,2									
A1012K SDUCR/L 07										15,5 12 9 5 11 125 28 1,0+1,2									
A1216M SDUCR/L 07										19,5 16 11 5 15 150 36 1,0+1,2									
S0810H SDUCR/L 07										12,5 10 7 4 9 100 22 1,0+1,2									
S1012K SDUCR/L 07										15,5 12 9 5 11 125 28 1,0+1,2									
S1216M SDUCR/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									

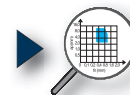


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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
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 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



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PAG. 132



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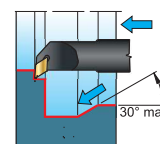
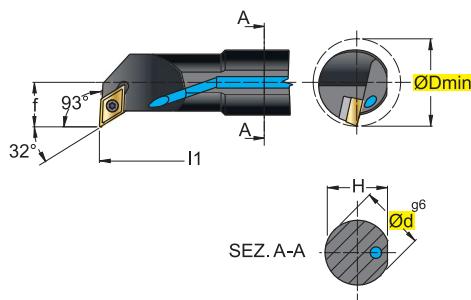


PAG. 992

A..SDUCR/L

Ø10 - Ø40

93°



DC.T



DC.W



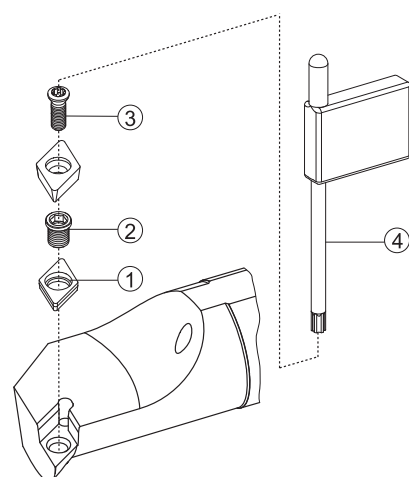
S



in figura utensile destro - right-hand shown

																	
.G13	.B53	.G57P	.Z57	.G39	.G42	.G52									INSERTI - INSERTS PAG. 150		
ART. (mm)													①	②	②	④	
			ØDmin	Ød	f	H	l1	Nm									
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									

INSERTI - INSERTS
PAG. 150



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

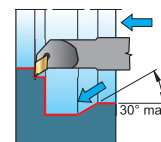
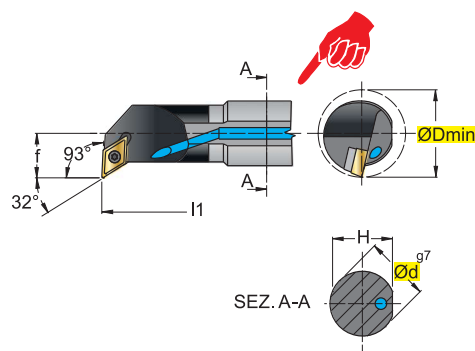


PAG. 992

E..SDUCR/L

Ø10 - Ø20

93°



DC.T



DC.W



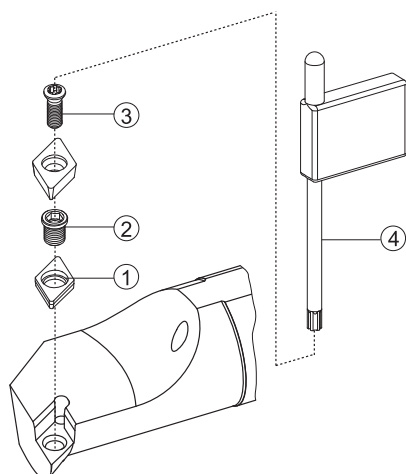
S



in figura utensile destro - right-hand shown

															
.G13	.B53	.G57P	.Z57	.G39	.G42	.G52									INSERTI - INSERTS PAG. 150
ART.		(mm)													
															
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

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

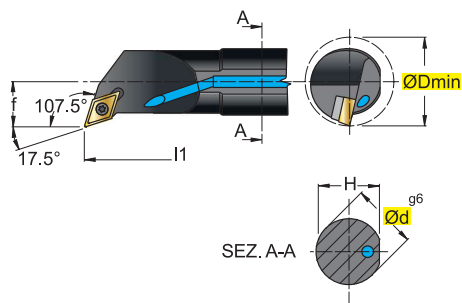


PAG. 992

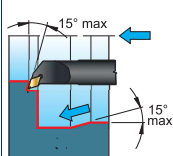
A..SDQCR/L

Ø12 - Ø32

107,5°



In figura utensile destro - Right-hand shown



DC.T



DC.W



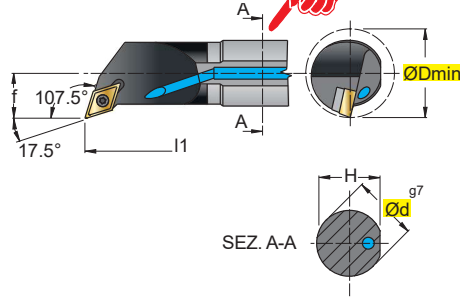
S



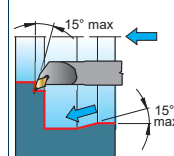
E..SDQCR/L

Ø10 - Ø20

107,5°



In figura utensile destro - Right-hand shown



DC.T



DC.W



S

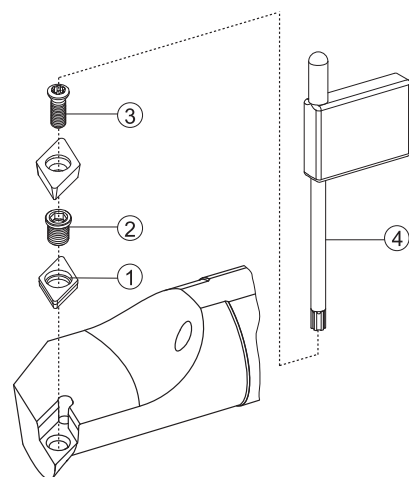
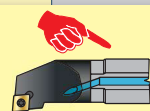


INSERTI - INSERTS
PAG. 150

ART.	(mm)	ØDmin	Ød	f	H	l1	Nm		1	2	3	4	
A12K SDQCR/L 07		16	12	9	11,50	125	1,1+1,3	0702	—	—	12256P	5508P	
A16M SDQCR/L 07		20	16	11	15,25	150	1,1+1,3						
A20Q SDQCR/L 07		25	20	13	19,00	180	1,1+1,3						
A20Q SDQCR/L 11		25	20	13	19,00	180	3,8+5,0	11T3	—	—	12409P	5515P	
A25R SDQCR/L 11		32	25	17	24,00	200	3,8+5,0	11T3	—	—	1240P	5515P	
A32S SDQCR/L 11		40	32	22	31,00	250	3,0+3,5	11T3	3711	BCL7	123511P	5515P	

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	

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

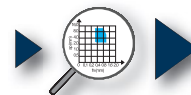


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

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



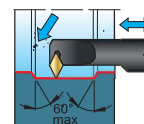
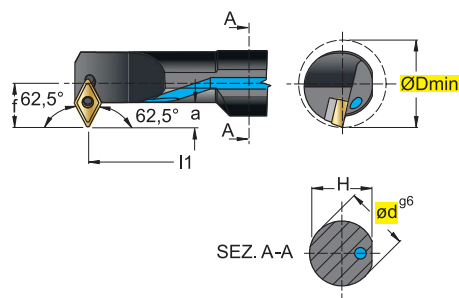
PAG. 967



PAG. 992

Ø16 - Ø25

63°



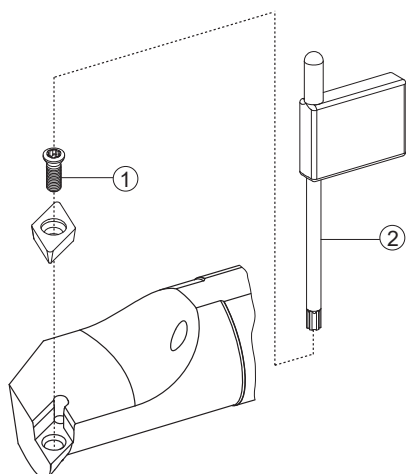
A cross-sectional diagram of a dovetail joint. It shows a yellow rectangular pin being inserted into a grey rectangular slot. The slot has a dovetail shape with a 7-degree angle, indicated by a curved arrow and the text "7°".

A cross-sectional diagram of a dovetail joint. It shows a yellow rectangular pin being inserted into a grey rectangular slot. The top surface of the pin is tapered, and the corresponding bottom surface of the slot is also tapered. An arrow points to the angle of the taper, which is labeled as 7° .

S



														 INSERTI - INSERTS PAG. 150						
.G13	.B53	.G57P	.Z57	.G39	.G42	.G52														
ART. (mm)																				
				ØDmin	Ød	f	a	H	l1	Nm										
A16M	SDNCR/L	07	20	16	11	6	15,25	150	1,1+1,3	0702	12256P	5508P								
A20Q	SDNCR/L	11	25	20	15	9	19,00	180	3,8+5,0	11T3	12409P	5515P								
A25R	SDNCR/L	11	32	25	17	9	24,00	200	3,8+5,0	11T3	1240P	5515P								



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

PAG. 132

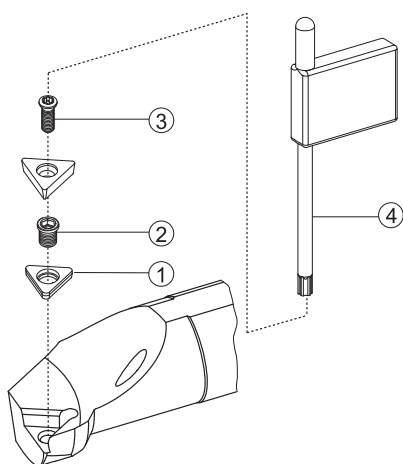
 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

PAG. 967

 DATI TECNICI E CONSIGLI
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PAG. 992

A..STUCR/L		Ø12 - Ø32				A..STFCR/L		Ø10 - Ø40			
93°						90°					
In figura utensile destro - Right-hand shown						In figura utensile destro - Right-hand shown					
.G39 .G57P .Z57 .G39 .S42 .G52										INSERTI - INSERTS PAG. 152	
ART.		(mm)									
		ØDmin Ød f H l1 Nm						1 2 3 4			
A12K	STUCR/L 11	16	12	9	11,50	125	1,1+1,3	1102	—	—	12256P 5508P
A16M	STUCR/L 16	20	16	11	15,25	150	3,8+5,0	16T3	—	—	12409P 5515P
A20Q	STUCR/L 16	25	20	13	19,00	180	3,8+5,0	16T3	—	—	1240P 5515P
A25R	STUCR/L 16	32	25	17	24,00	200	3,8+5,0				
A32S	STUCR/L 16	40	32	22	31,00	250	3,0+3,5	16T3	3415	BCL7	123511P 5515P
A10H	STFCR/L 09	12	10	7	9,50	100	0,9+1,0	0902	—	—	12225P 5507P
A10H	STFCR/L 11	12	10	7	9,50	100	1,1+1,3	1102	—	—	12256P 5508P
A12K	STFCR/L 11	16	12	9	11,50	125	1,1+1,3				
A16M	STFCR/L 11	20	16	11	15,25	150	1,1+1,3				
A16M	STFCR/L 16	20	16	11	15,25	150	3,8+5,0	16T3	—	—	12409P 5515P
A20Q	STFCR/L 16	25	20	13	19,00	180	3,8+5,0	16T3	—	—	1240P 5515P
A25R	STFCR/L 16	32	25	17	24,00	200	3,8+5,0				
A32S	STFCR/L 16	40	32	22	31,00	250	3,0+3,5	16T3	3415	BCL7	123511P 5515P
A40T	STFCR/L 16	50	40	27	38,50	300	3,0+3,5				

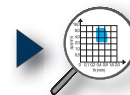


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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
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 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 136



PAG. 132



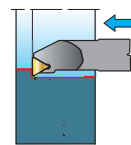
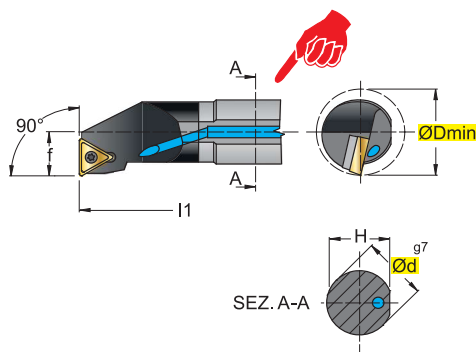
PAG. 967



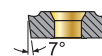
PAG. 992

Ø10 - Ø20

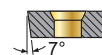
90°



TC.T



TC.W

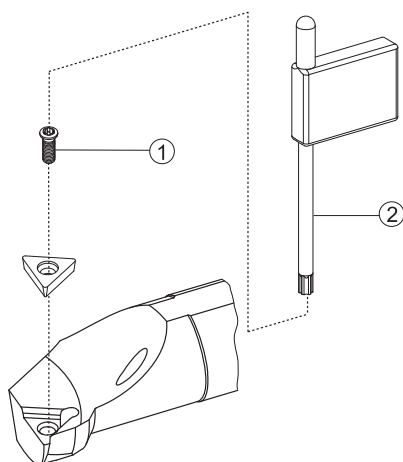
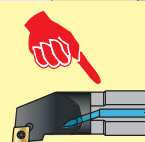


S

[illegible]

ART.		(mm)								①	②	●	⦿
		ØDmin	Ød	f	H	I1	Nm						
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

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

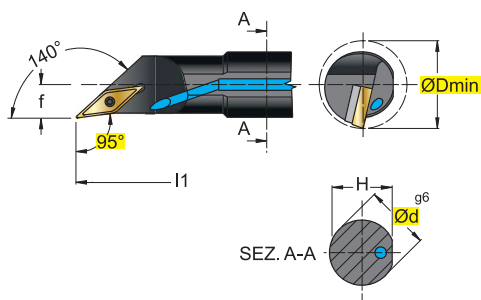
PAG. 967

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

PAG. 992

Ø12 - Ø25

140°



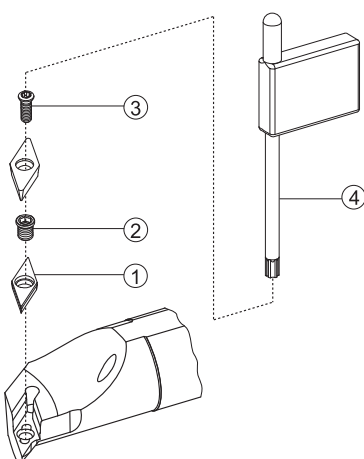


INSERTI - INSERTS
PAG. 153

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							

The diagram shows a cross-section of a ballpoint pen tip. A blue rectangular block represents the paper or substrate. A semi-circular indentation is shown in the block, with a red line indicating the contact area. A black pen tip with a gold-colored ball is shown in contact with the surface. Red arrows point from the center of the ball to the contact area. A horizontal line with arrows at both ends is labeled 'ap', representing the distance from the center of the contact area to the center of the ball.

A diagram showing a stylus tip writing a horizontal line on a surface. The line is composed of several parallel horizontal strokes, each starting from a common point on the left and extending to the right. The stylus is positioned at the end of the line, and a dimension line indicates the width of the line as ap .



PAG. 136

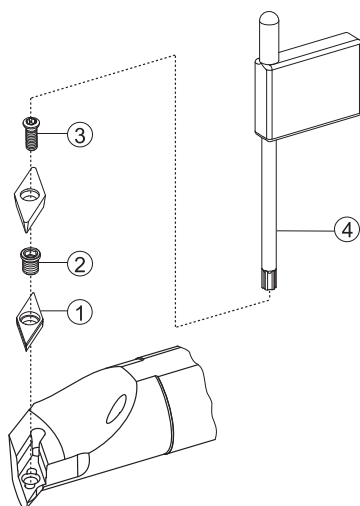
PAG. 132



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PAG. 992

A..SVXCR/L					Ø16 - Ø25		A..SVQCR/L					Ø16 - Ø40				
VC.T					VC.T		VC.T					VC.T				
VC.W					VC.W		VC.W					VC.W				
S					S		S					S				
In figura utensile destro - Right-hand shown					In figura utensile destro - Right-hand shown		In figura utensile destro - Right-hand shown					In figura utensile destro - Right-hand shown				
.G13					.G57P		.Z57		.G42		.G52		INSERTI - INSERTS PAG. 153			
ART.					(mm)											
					ØDmin		Ød		f		H		l1		Nm	
A16M SVXCR/L 11					20		16		11		15,25		150		1,1+1,3	
A20Q SVXCR/L 11					25		20		13		19,00		180		1,1+1,3	
A25R SVXCR/L 16					32		25		17		24,00		200		3,0+3,5	
A16M SVQCR/L 11					20		16		11		15,25		150		1,1+1,3	
A20Q SVQCR/L 11					25		20		13		19,00		180		1,1+1,3	
A25R SVQCR/L 16					32		25		17		24,00		200		3,0+3,5	
A32S SVQCR/L 16					40		32		22		31,00		250		3,0+3,5	
A40T SVQCR/L 16					50		40		27		38,50		300		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
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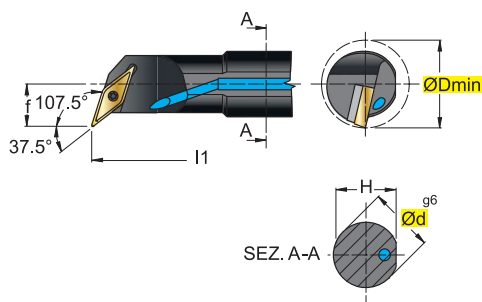
PAG. 967

PAG. 992

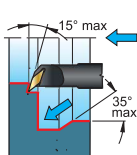
A..SVQBR/L

Ø25 - Ø40

107,5°



In figura utensile destro - Right-hand shown



VB.T



VB.W



S

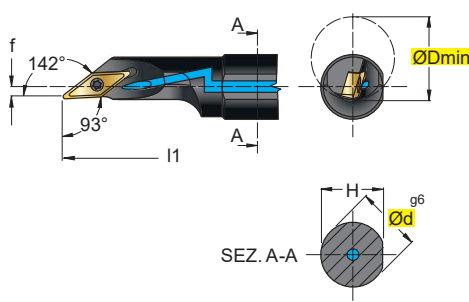


A..SVJBR/L

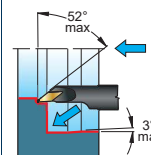
Ø25

142°

NEW



In figura utensile destro - Right-hand shown



VB.T



VB.W



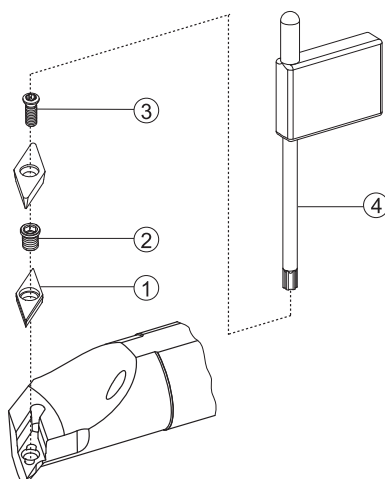
S



.G42 .G52 .G58

INSERTI - INSERTS
PAG. 153

ART.		(mm)						Nm						
		ØDmin	Ød	f	H	l1				1	2	3	4	
A25R	SVQBR/L 16	32	25	17	24,0	200	3,0+3,5	1604		—	—	123509P	5515P	
A32S	SVQBR/L 16	40	32	22	31,0	250	3,0+3,5	1604		3716	BCL7	123511P	5515P	
A40T	SVQBR/L 16	50	40	27	38,5	300	3,0+3,5							
A25R	SVJBR/L 16	32	25	4,6	24	200	1,1+1,3	1604		—	—	12256P	5508P	

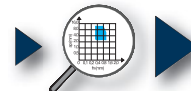


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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Vc. CUTTING SPEED
Vc. SCHNITTGESCHWINDIGKEIT
Vc. VITESSE DE COUPE

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PAG. 132



PAG. 967

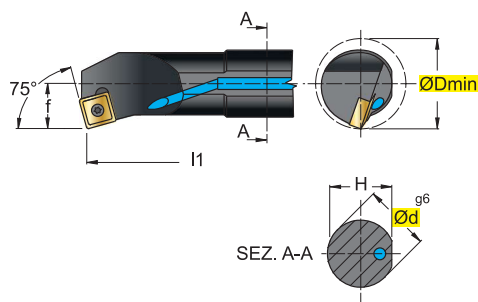


PAG. 992

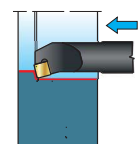
A..SSKCR/L

Ø16 - Ø25

75°



In figura utensile destro - Right-hand shown



SC.T



SC.W

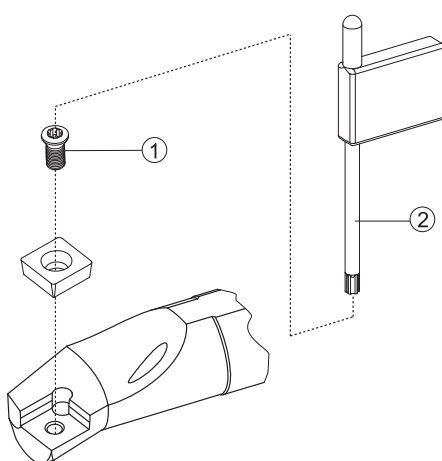


S



INSERTI - INSERTS
PAG. 151

ART.	(mm)	ØDmin	Ød	f	H	l1	Nm		1	2		
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		

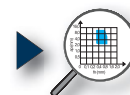


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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

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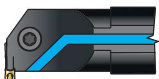
PAG. 132



PAG. 967

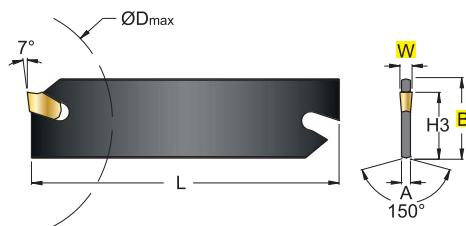
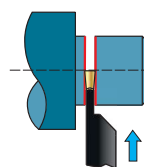


PAG. 992

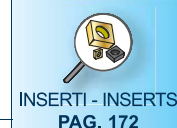
LGIH Pag.82		TRL Pag.84		TMSDR/L Pag.86		STGR/L Pag.90			
									
ØDmax = 50 - 120		ØDmax = 70 - 100		□ 16x16 - 25x25		□ 20x20 - 25x25			
	STN W=2,2-6,4		TRL..N W=3,0-4,0		GX16 W=3-5		154.. W=1,1-4,15		
				TMSIR/L Pag.86		A..STIR/L Pag.90			
									
				ØDmin = 20,5 - 42		ØDmin = 20 - 40			
			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

W +/-0,1

B

A

ØDmax

L

H3



1

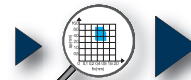


STN..

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 NUTENDREHWENDEPLATTEN
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

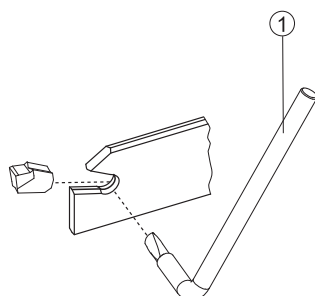


PAG. 967

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

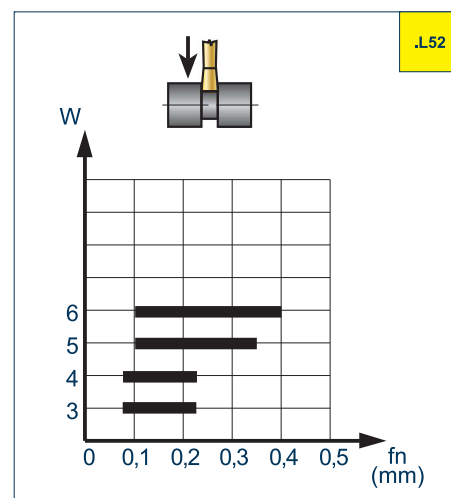


PAG. 995



SCELTA VELOCE - QUICK PICK																		HT	HW	HC		±0,1 W r a°																		
																		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 ¹⁾		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

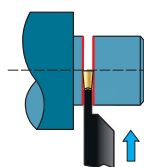
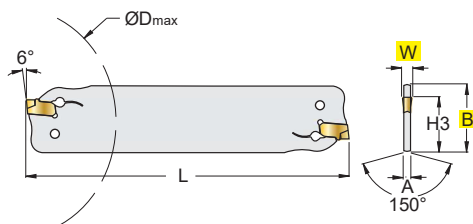
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

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

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

26 - 32

Pag.98



TRLN..



.G52

G56

.G57P

(mm)

 $W \pm 0,1$

B

A

 $\varnothing D_{\max}$

L

H3



1

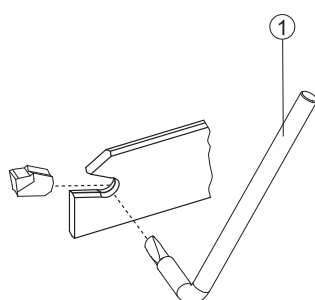


INSERTI - INSERTS
PAG. 172

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

SCELTA VELOCE - QUICK PICK

Tenacità +
Toughness -



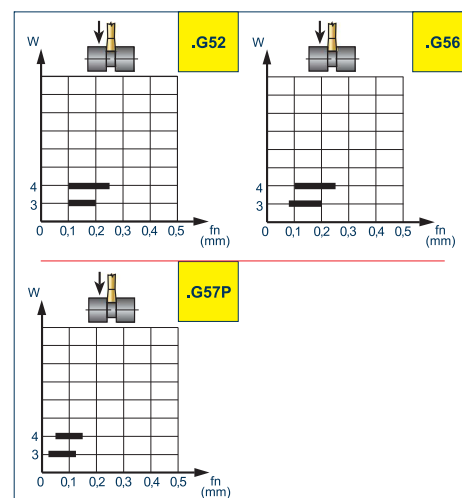
Pag. 156

COD.	P			M			K			N			S			H			T115			F4645			T5235				W	r	a°
	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R													
TRLN 3.00-0.20N .G52	○	●	●					○	●	●												■				■			3,0*	0,2	0°
TRLN 4.00-0.30N .G52	○	●	●																			■						4,0*	0,3	0°	
TRLN 3.00-0.30N .G56	○	●	●					○	●	●												■				■			3,0*	0,3	0°
TRLN 4.00-0.40N .G56	○	●	●					○	●	●												■				■			4,0*	0,4	0°
TRLN 3.00-0.30N .G57P									●	●	○											■							3,0*	0,3	0°
TRLN 4.00-0.40N .G57P									●	●	○											■							4,0*	0,4	0°

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	T5235	
	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 ¹⁾				
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

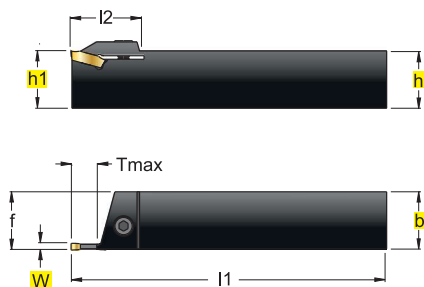
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

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

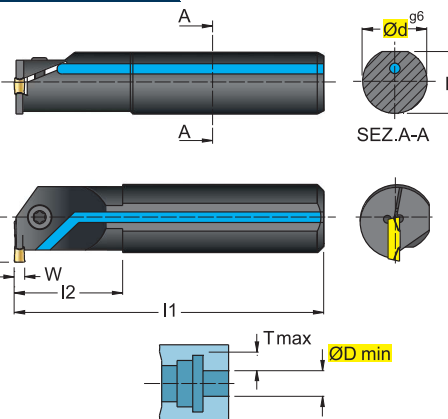
$$Vf = fn \cdot n = \text{mm/min}$$

□ 16x16 - 25x25

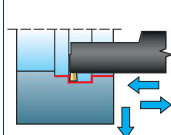


GX
16..

Ø16 - Ø32



In figura utensile destro - Right-hand shown



GX	
16..	

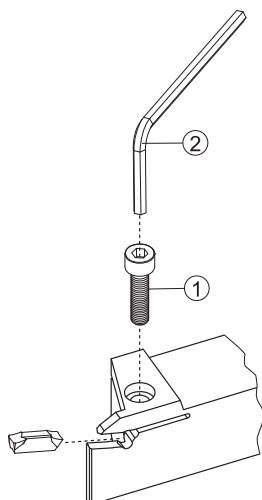


.Z32	.Z42	.Z52	.Z47P	.Z47P
------	------	------	-------	-------



INSERTI - INSERTS
PAG. 171

ART.		(mm)										①	②	
 R	 L	W	Ød	Ødmin	f	H	Tmax	l1	l2	Nm 				
TMSIR/L	16-16-1	2-2,5	16	20,5	13,5	15,25	5,5	150	28	5,0÷6,0	GX16.1	SM 523	5520	
TMSIR/L	16-16-2	3-3,5	16	20,5	13,5	15,25	5,5	150	28	5,0÷6,0	GX16.2	SM 523	5520	
TMSIR/L	20-16-2	3-3,5	20	25	15,5	19,00	5,5	180	35	5,0÷6,0	GX16.2	SM 521	5520	
TMSIR/L	25-16-2	3-3,5	25	32	20,5	24,00	8,0	200	40	5,0÷6,0	GX16.2	SM 522	5520	
TMSIR/L	25-16-3	4-5	25	32	22,5	24,00	10,0	200	40	5,0÷6,0	GX16.3	SM 522	5520	
TMSIR/L	32-16-2	3-3,5	32	42	27,5	31,00	11,0	250	50	5,0÷6,0	GX16.2	SM 522	5520	
TMSIR/L	32-16-3	4-5	32	42	27,5	31,00	11,0	250	50	5,0÷6,0	GX16.3	SM 522	5520	



PAG. 166



PAG. 164

PAG. 967

PAG. 995

SCelta VELOCE - QUICK PICK



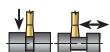
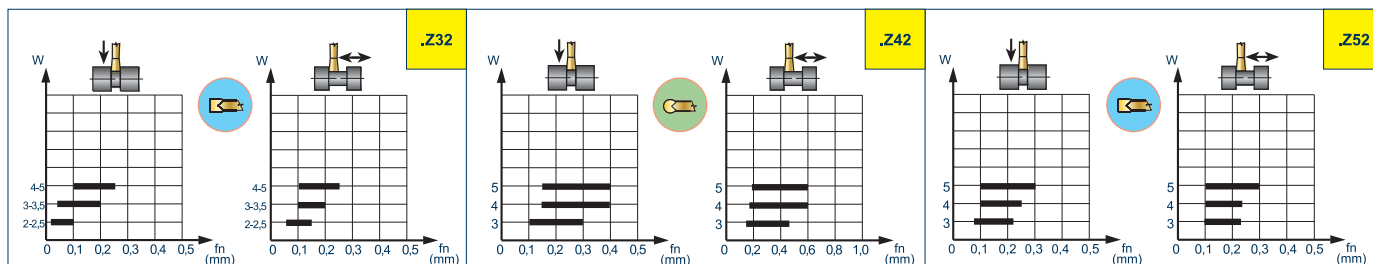
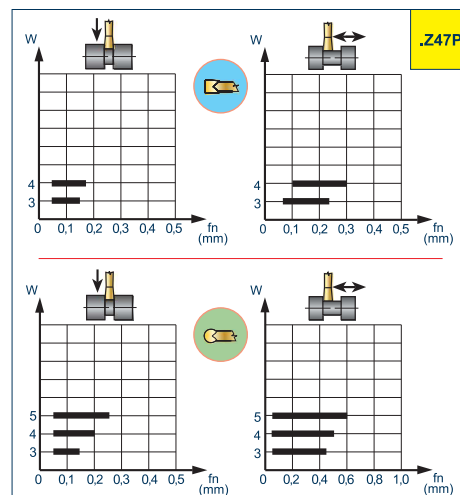
Pag. 156

COD.	P			M			K			N			S			H			HT	HW	HC							
	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	T115	F4645	T5226	W	r	l	T	a°		
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°		
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°		
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°			
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°		
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°		

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		120	150
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325		90	135
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240		90	170
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		/	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

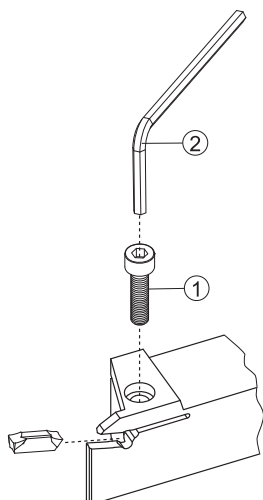
Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

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

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

TMSDR/L				Ø 25x25				TMSIR/L				Ø32 - Ø40			
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
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



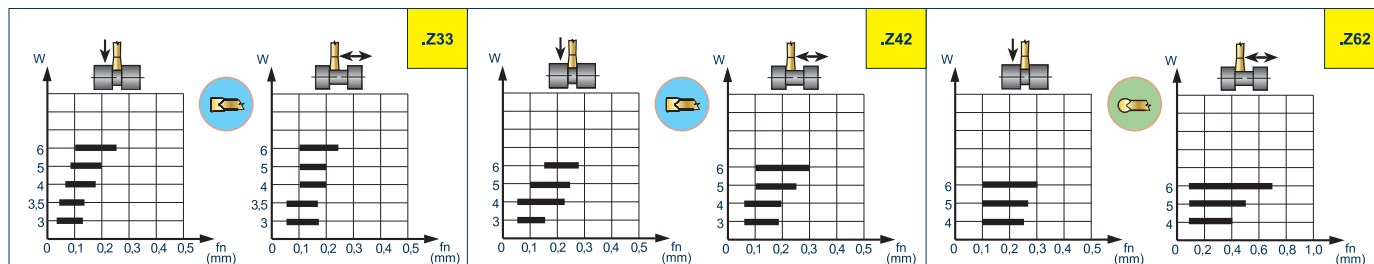
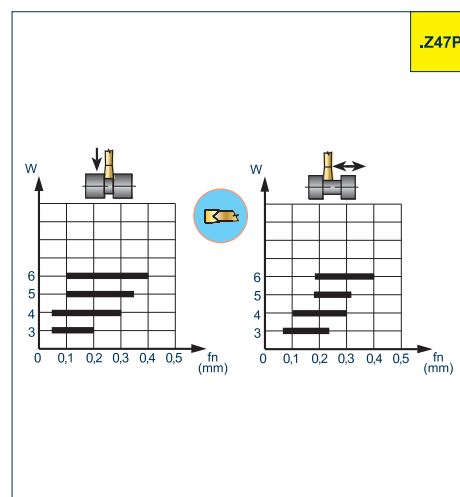
Pag. 156

COD.		P			M			K			N			S			H			T115	F4530	F4645	T5226	T5235		W	r	l	T	a°
		F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R											
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		●			●									○												4,0	0,4	24	3,05	6°
GX24-3E5.00N-0.40 .Z33		●			●									○												5,0	0,4	24	3,05	6°
GX24-4E6.00N-0.50 .Z33		●			●									○												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°
		●	○		○	○		●	○					○	○															
		●	○		○	○		●	○					○	○															
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°
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°

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	F4530	F4645	T5226	T5235
	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					
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	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 ¹⁾		40	30		
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ²⁾					



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

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

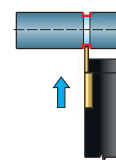
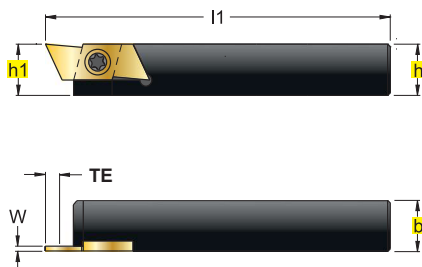
$$Vf = fn \cdot n = \text{mm/min}$$

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

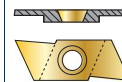
□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW
 ○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

THE...THS...

8x8 - 25x25



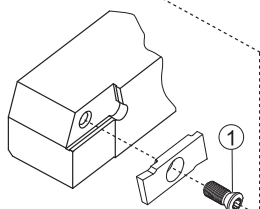
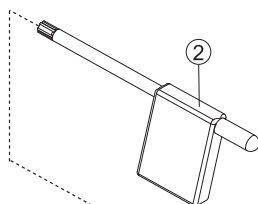
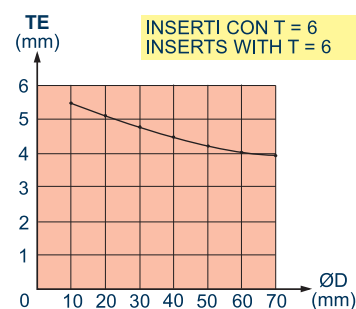
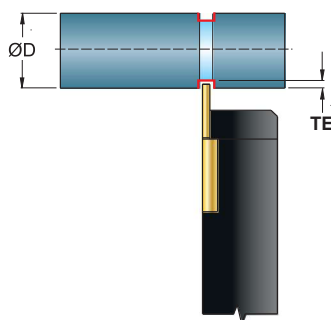
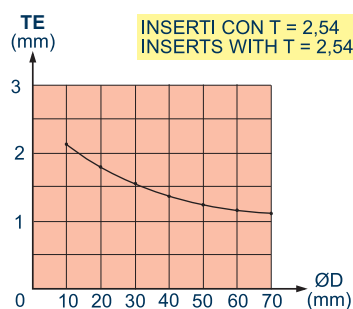
GIE-7-..



In figura utensile destro - Right-hand shown



INSERTI - INSERTS
PAG. 173



 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

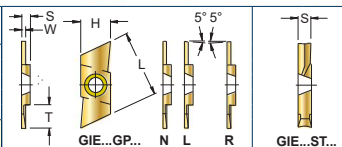
PAG. 164

 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							HT	HW	HC							
Tenacità $\uparrow$ Toughness $\downarrow$							CERMET	NON RIV. CEMENTED CARBIDE GRADES	RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS							
COD.	P	M	K	N	S	H										
GIE - 7 - GP - 1.0 R - N	●	●														
GIE - 7 - GP - 1.0 L - N	●	●														
GIE - 7 - GP - 1.5 R - N	●	●														
GIE - 7 - GP - 1.5 R - R	●	●														
GIE - 7 - GP - 1.5 L - N	●	●														
GIE - 7 - GP - 1.5 L - R	●	●														
GIE - 7 - GP - 1.5 L - L	●	●														
GIE - 7 - GP - 2.0 R - N	●	●														
GIE - 7 - GP - 2.0 R - R	●	●														
GIE - 7 - GP - 2.0 L - N	●	●														
GIE - 7 - ST - 3.0 R	●	●														
GIE - 7 - ST - 3.0 L	●	●														
GIE - 7 - SG - 0.5 R	●	●														
GIE - 7 - SG - 0.5 L	●	●														
GIE - 7 - SG - 0.7 R	●	●														
GIE - 7 - SG - 0.7 L	●	●														
GIE - 7 - SG - 0.8 R	●	●														
GIE - 7 - SG - 0.8 L	●	●														
GIE - 7 - SG - 0.9 R	●	●														
GIE - 7 - SG - 0.9 L	●	●														
GIE - 7 - SG - 1.1 R	●	●														
GIE - 7 - SG - 1.1 L	●	●														
GIE - 7 - SG - 1.3 R	●	●														
GIE - 7 - SG - 1.3 L	●	●														
GIE - 7 - SG - 1.6 R	●	●														
GIE - 7 - SG - 1.6 L	●	●														
GIE - 7 - SG - 1.85 R	●	●														
GIE - 7 - SG - 1.85 L	●	●														
GIE - 7 - GR - 1.0 R	●	●														
GIE - 7 - GR - 1.0 L	●	●														
GIE - 7 - GR - 1.5 R	●	●														
GIE - 7 - GR - 1.5 L	●	●														
GIE - 7 - GR - 2.0 R	●	●														
GIE - 7 - GR - 2.0 L	●	●														
GIE - 7 - GW - 60 R	●	●														
GIE - 7 - GW - 60 L	●	●														
GIE - 7 - GW - 55 R	●	●														
GIE - 7 - GW - 55 L	●	●														
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 ¹⁾													
H	ACCIAIO TEMPRATO - HARDENED STEEL	38--41	45-60 ²⁾													



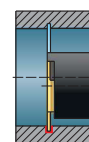
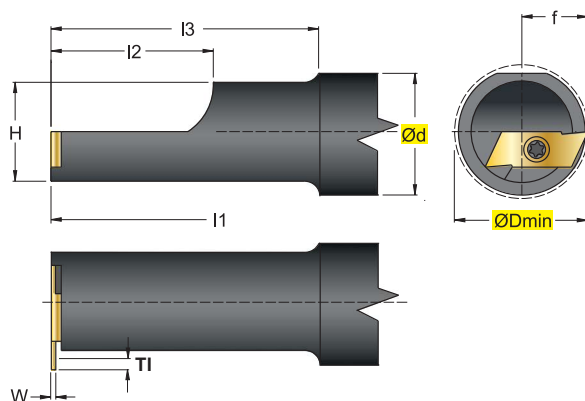
Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

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

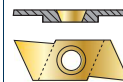
$$Vf = fn \cdot n = \text{mm/min}$$

THI..

Ø20 - Ø32



GIE-7-..

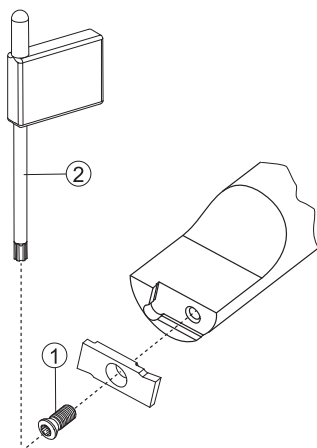
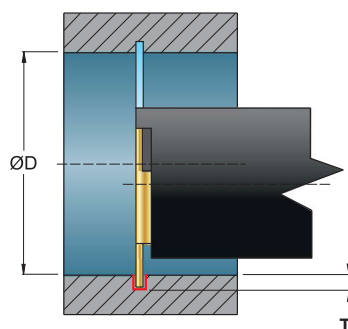
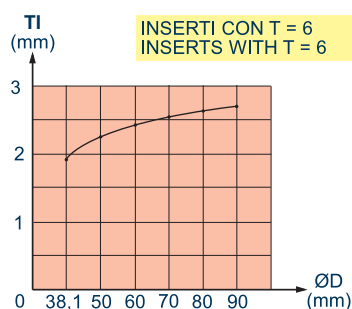


In figura utensile destro - Right-hand shown



INSERTI - INSERTS
PAG. 173

-GP/-ST	-SG	-GR	-GW															PAG. 173	
ART.																			
		(mm)																	
		ØDmin	Ød	f	H	l1	l2	l3	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							HT	HW	HC	Pag. 156						
							CERMET	NON RIV. CEMENTED CARBIDE GRADES	RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS							
COD.	P	M	K	N	S	H										
GIE - 7 - GP - 1.0 R - N	●	●														
GIE - 7 - GP - 1.0 L - N	●	●														
GIE - 7 - GP - 1.5 R - N	●	●														
GIE - 7 - GP - 1.5 R - R	●	●														
GIE - 7 - GP - 1.5 L - N	●	●														
GIE - 7 - GP - 1.5 L - R	●	●														
GIE - 7 - GP - 1.5 L - L	●	●														
GIE - 7 - GP - 2.0 R - N	●	●														
GIE - 7 - GP - 2.0 R - R	●	●														
GIE - 7 - GP - 2.0 L - N	●	●														
GIE - 7 - ST - 3.0 R	●	●														
GIE - 7 - ST - 3.0 L	●	●														
GIE - 7 - SG - 0.5 R	●	●														
GIE - 7 - SG - 0.5 L	●	●														
GIE - 7 - SG - 0.7 R	●	●														
GIE - 7 - SG - 0.7 L	●	●														
GIE - 7 - SG - 0.8 R	●	●														
GIE - 7 - SG - 0.8 L	●	●														
GIE - 7 - SG - 0.9 R	●	●														
GIE - 7 - SG - 0.9 L	●	●														
GIE - 7 - SG - 1.1 R	●	●														
GIE - 7 - SG - 1.1 L	●	●														
GIE - 7 - SG - 1.3 R	●	●														
GIE - 7 - SG - 1.3 L	●	●														
GIE - 7 - SG - 1.6 R	●	●														
GIE - 7 - SG - 1.6 L	●	●														
GIE - 7 - SG - 1.85 R	●	●														
GIE - 7 - SG - 1.85 L	●	●														
GIE - 7 - GR - 1.0 R	●	●														
GIE - 7 - GR - 1.0 L	●	●														
GIE - 7 - GR - 1.5 R	●	●														
GIE - 7 - GR - 1.5 L	●	●														
GIE - 7 - GR - 2.0 R	●	●														
GIE - 7 - GR - 2.0 L	●	●														
GIE - 7 - GW - 60 R	●	●														
GIE - 7 - GW - 60 L	●	●														
GIE - 7 - GW - 55 R	●	●														
GIE - 7 - GW - 55 L	●	●														
CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY																
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY																

MATERIALI - MATERIALS		VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	fn mm			Vc m/min Pag. 164									
Pag. 1063				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 ¹⁾													
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

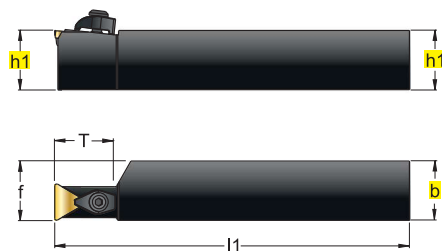
$$n = \frac{Vc \cdot 1000}{\phi D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

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

■ 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

Ø 25x25



TPMR

C

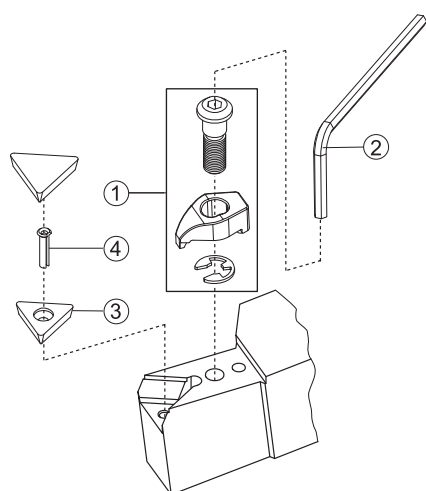


S44

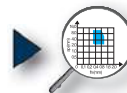


INSERTI - INSERTS
PAG. 152

ART.							(mm)		①	②	③	④	
SCTFPR/L	2525	M 11	25	25	25	150	22	1103	2304C	5025	-	-	
SCTFPR/L	2525	M 16	25	25	25	150	25	1603	2305C	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
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PAG. 995

Pag. 156

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

.S44

Diagram illustrating a mechanical joint and a corresponding graph.

The diagram shows a cross-section of a joint with a central blue component, a yellow triangular component, and a grey component. A downward arrow indicates a force.

The graph plots I (mm) on the y-axis against f_n (mm) on the x-axis.

The y-axis has labels 11 and 16. The x-axis has labels 0, 0,1, 0,2, 0,4, 0,8, 1,6, 2,0.

Two horizontal bars are shown:

- One bar at $I=16$ from $f_n=0,1$ to $0,2$.
- Another bar at $I=11$ from $f_n=0,1$ to $0,2$.



= 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

L = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

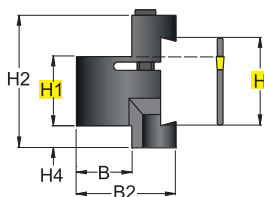
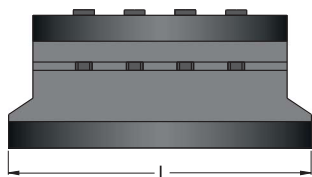
$$V_f = f_n \cdot n = \text{mm/min}$$

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

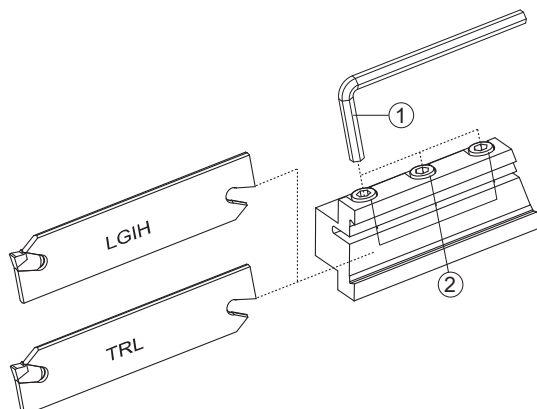
■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
● EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

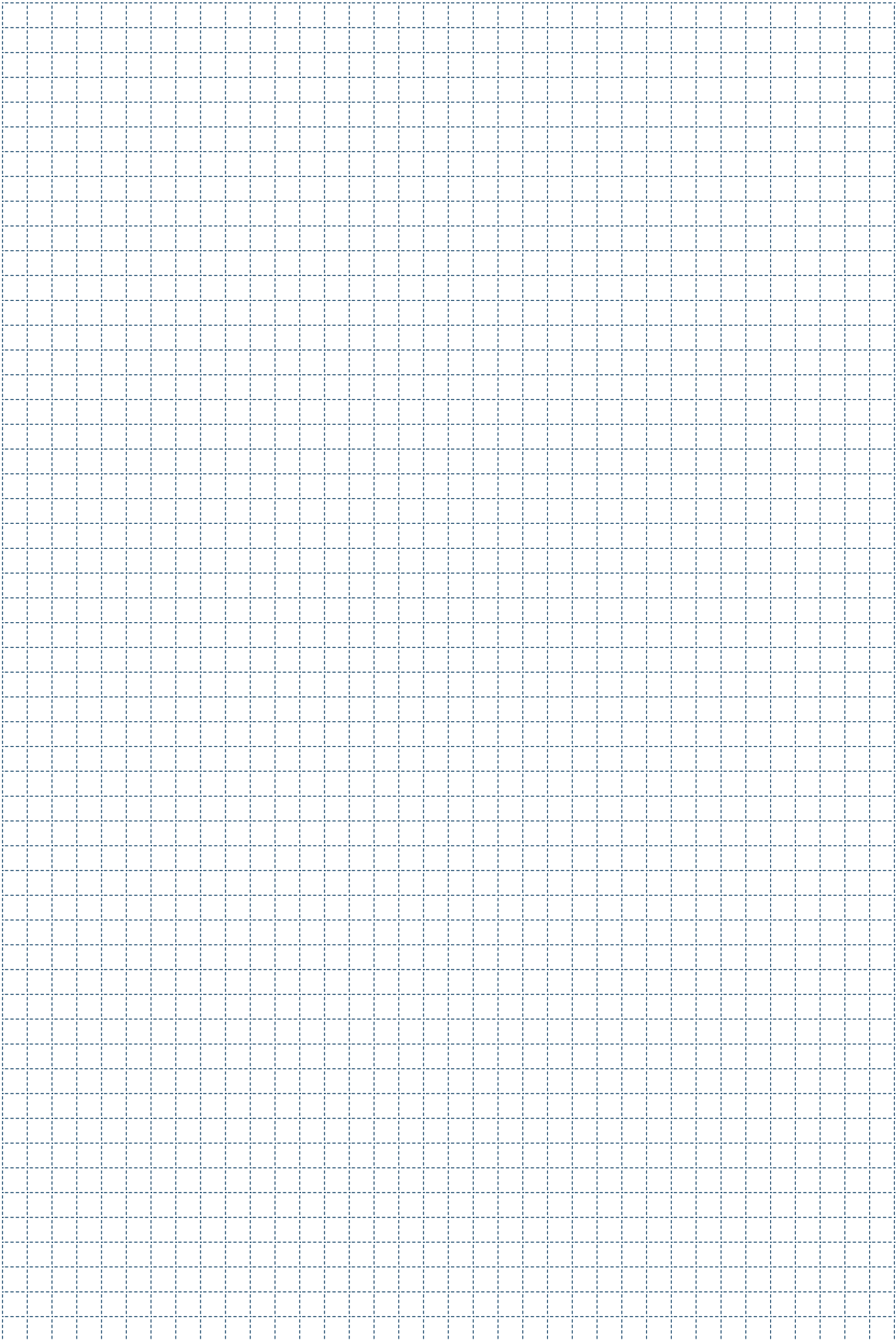
☐ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / ☐ NEW
☐ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

LGTBN

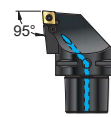
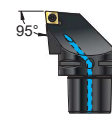
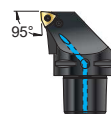
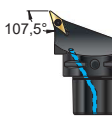
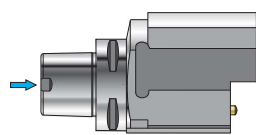
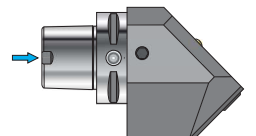


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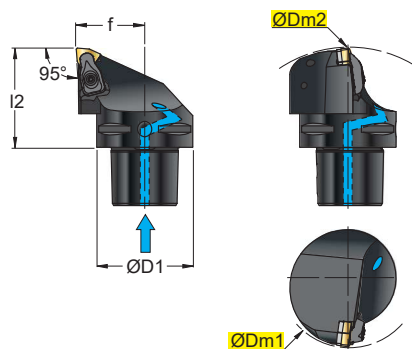




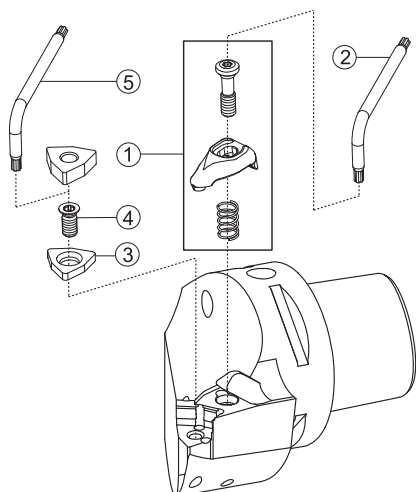
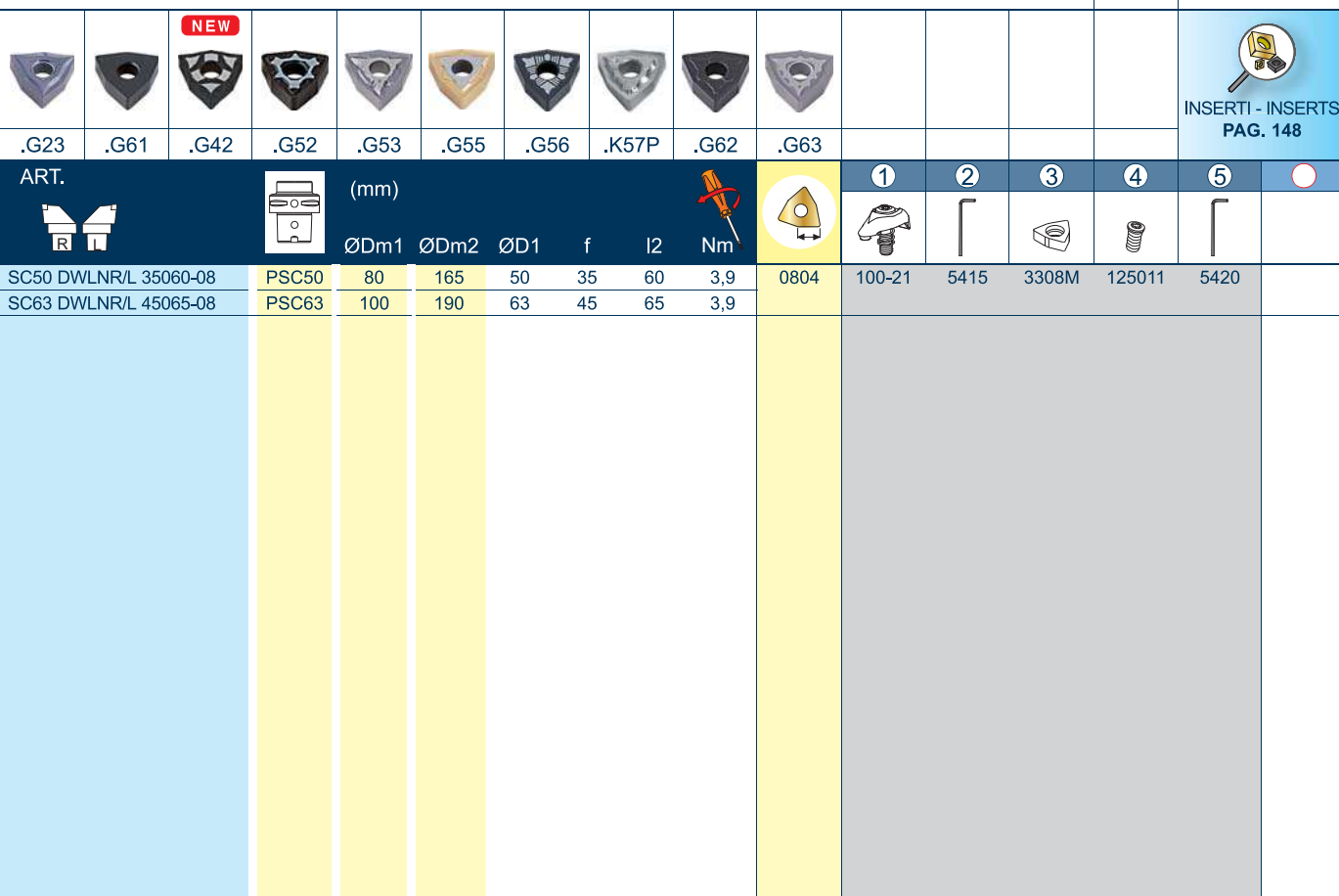


D 		D 		P 		S 		S 	
SC.. DCLNR/L Pag.102		SC63 DCMNN Pag.104		SC.. PCLNR/L Pag.106		SC.. SCLCR/L Pag.109		SC63 SCMCN Pag.113	
									
	CNM. 1204..		CNM. 1204..		CNM. 1204..		CC.. 1204..		CC.. 1204..
PSC50 - PSC63		PSC63		PSC40 - PSC50 - PSC63		PSC40 - PSC50 - PSC63		PSC63	
SC.. DWLNR/L Pag.103		SC63 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..		
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								PSC.C63.PAR/L Pag.899	
									
								PSC.C63.U45 Pag.899	
									

93°

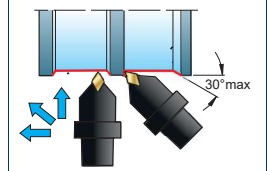
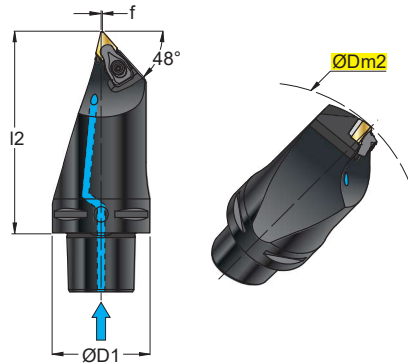


D



48°

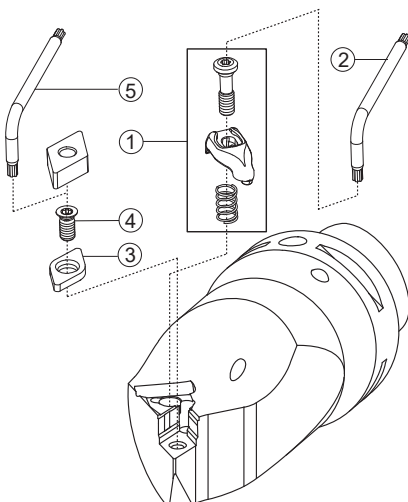
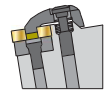
93°



A cross-sectional diagram of a butt joint. Two plates, represented by hatched areas, are joined by a square groove weld. The weld metal is shown as a solid yellow area filling the groove.

A cross-sectional diagram of a butt joint. Two plates, represented by hatched patterns, are joined by a square groove weld. The weld metal is shown as a solid yellow area filling the groove between the two plates.

D

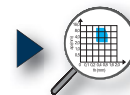


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 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



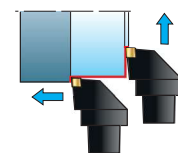
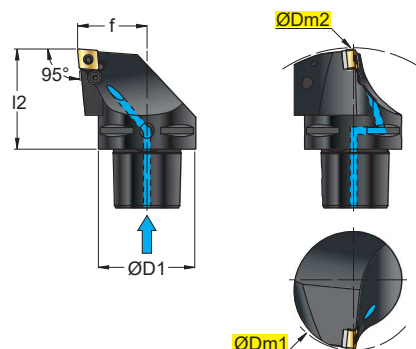
PAG. 967



PAG. 992

SC.. PCLNR/L

95°



CNMA



CNMG



CNMM

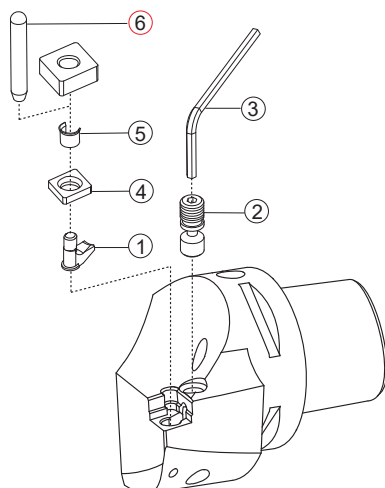


P



In figura utensile destro - Right-hand shown

															 INSERTI - INSERTS PAG. 143	
.G23	.G61	.B32	.G39	NEW .G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	NEW .G68	.G72	.G82		
ART.											①	②	③	④	⑤	⑥
			(mm)													
			ØDm1	ØDm2	ØD1	f	l2									
SC40 PCLNR/L 27050-12		PSC40	70	140	40	27	50									
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		

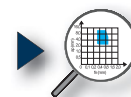


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
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PAG. 136



PAG. 132

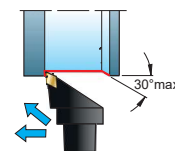
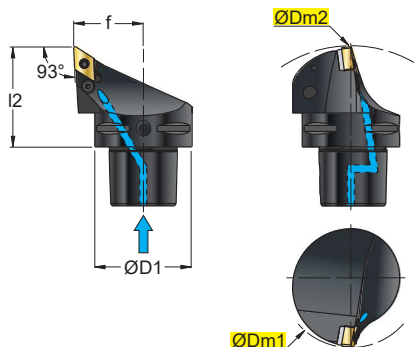


PAG. 967

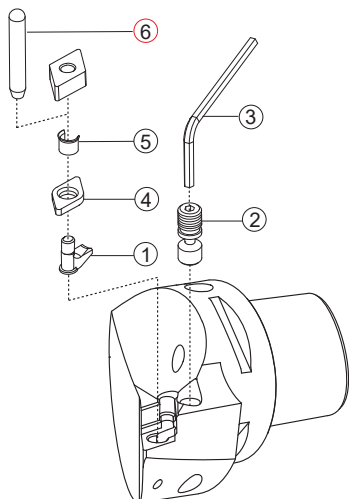


PAG. 992

93°



P



 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 V_c
 V_c. CUTTING SPEED
 V_c. SCHNITTGESCHWINDIGKEIT
 V_c. VITESSE DE COUPE

PAG. 132

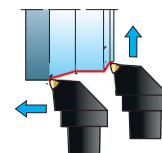
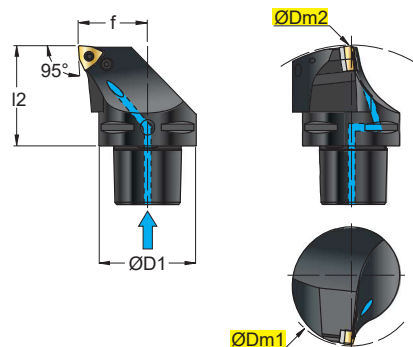
 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

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 DATI TECNICI E CONSIGLI
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95°



P



INSERTI - INSERTS
PAG. 148



ART.

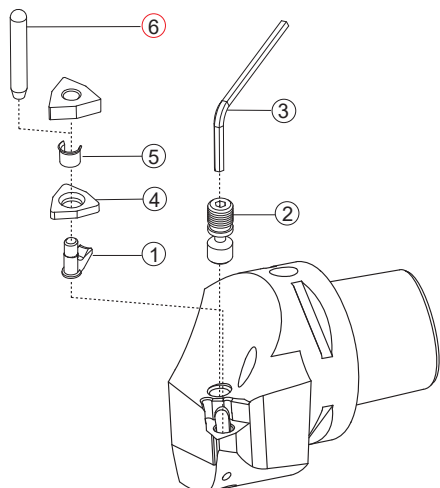


(mm)

 $\varnothing D_{m1} \quad \varnothing D_{m2} \quad \varnothing D_1 \quad f \quad l_2$ 

1	2	3	4	5	6
					

SC40 PwLNR/L 27050-08	PSC40	70	140	40	27	50	0804	8012	1608	5003	3308M	4112	0012
SC50 PwLNR/L 35060-08	PSC50	80	165	50	35	60							
SC63 PwLNR/L 45065-08	PSC63	100	190	63	45	65							

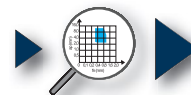


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
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 V_c. CUTTING SPEED
 V_c. SCHNITTGESCHWINDIGKEIT
 V_c. VITESSE DE COUPE

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



PAG. 136



PAG. 132

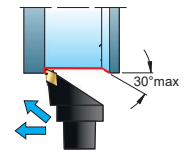
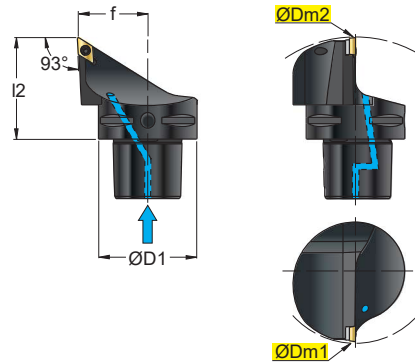


PAG. 967



PAG. 992

93°



A technical drawing 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 by a dimension line and the text 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. The angle between the vertical centerline and the side of the tail is labeled as 7° .

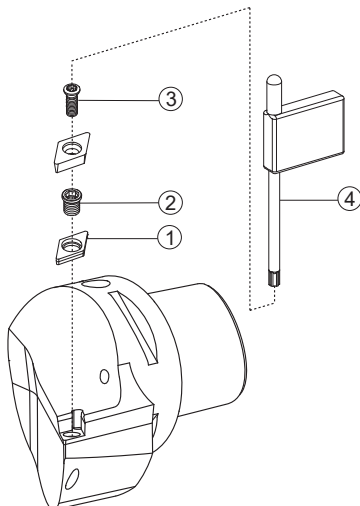


INSERTI - INSERTS
PAG. 150



150

1000



PAG. 136

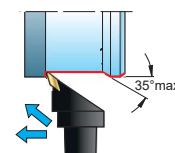
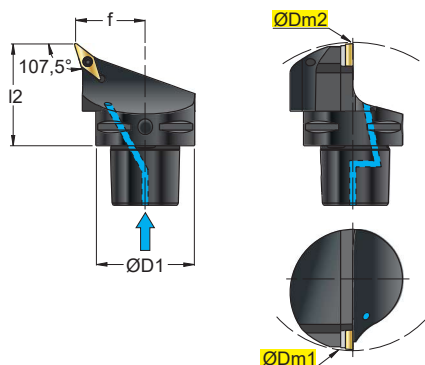


PAG. 132

PAG. 967

PAG. 992

107,5°



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

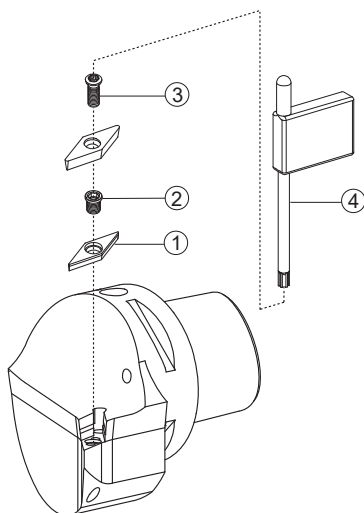
A cross-sectional diagram of a fillet weld joint. Two plates, represented by hatched areas, are joined by a weld metal (yellow). The weld metal is applied to the beveled edges of the plates. The bevel angle is indicated as 5° .

S



																	
																	
.G42	.G52	.G58															


 INSERTI - INSERTS
PAG. 153

[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 V_c
 V_c . CUTTING SPEED
 V_c . SCHNITTGESCHWINDIGKEIT
 V_c . VITESSE DE COUPE

PAG. 132

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

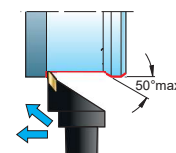
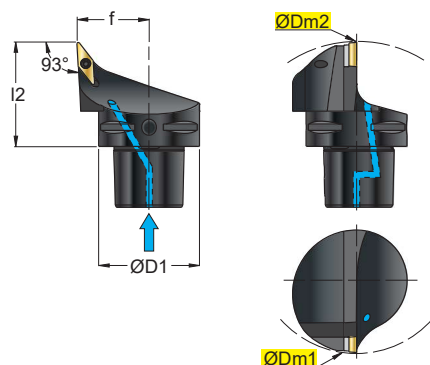
PAG. 967

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

PAG. 992

SC.. SVJBR/L

93°



VB.T



VB.W

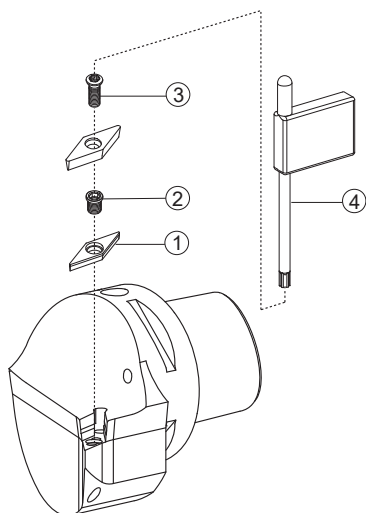


S



In figura utensile destro - Right-hand shown

NEW													INSERTI - INSERTS PAG. 153				
.G42 .G52 .G58																	
ART.			(mm)										1	2	3	4	
R			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										

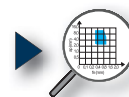


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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

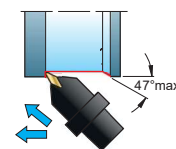
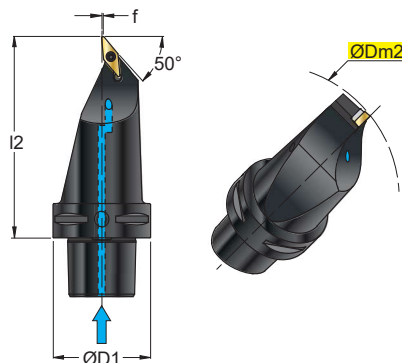


PAG. 967



PAG. 992

50° 95°



VB.T



VB.W



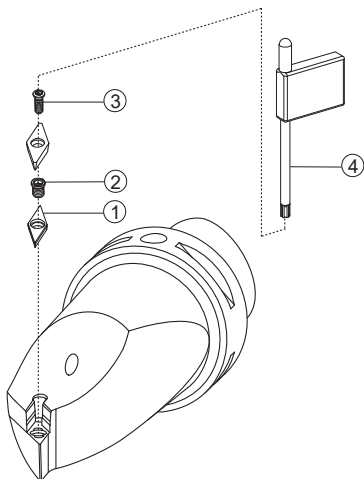
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NEW	NEW	
		
.G42	.G52	.G58



INSERTI - INSERTS
PAG. 153

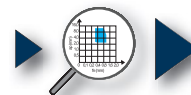
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 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

 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



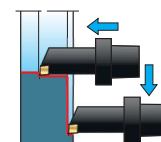
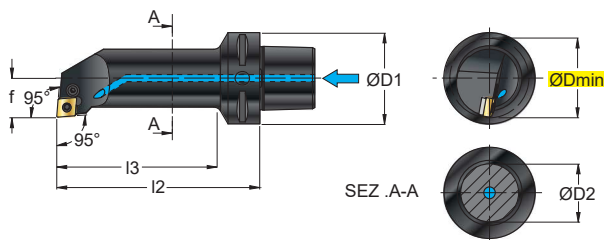
PAG. 967



PAG. 992

SC.. PCLNR/L

95°



CNMA



CNMG



CNMM

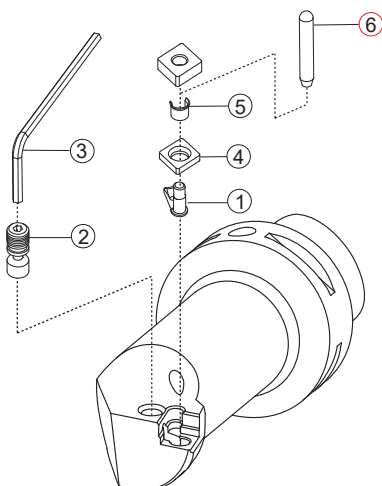


P



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	1204	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

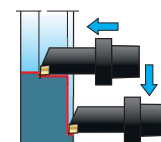
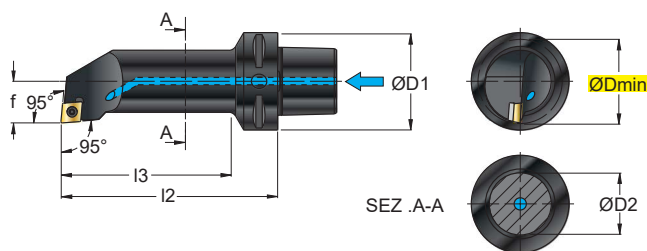
DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 992

SC.. SCLCR/L

95°



CC.T



CC.W

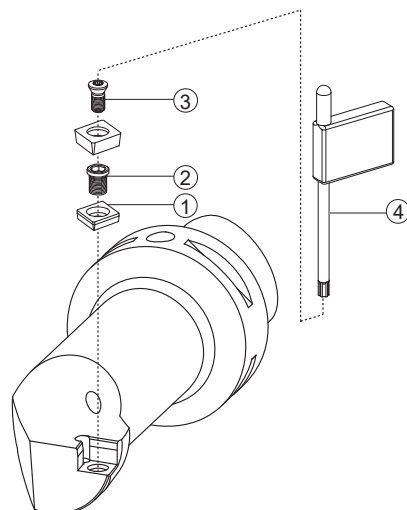


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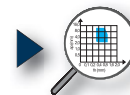


In figura utensile destro - Right-hand shown

																		 INSERTI - INSERTS PAG. 149
.B22	.G13	.B33	.G57P	.Z57	.G39	.G42	.G52											
ART.				(mm)										1	2	3	4	
SC40 SCLCR/L 11070-09 New		PSC40		20	40	16	11	70	47	3,8+5,0	09T3			—	—	12409P	5515P	
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	1204			—	—	124510	5520	
SC40 SCLCR/L 22110-12		PSC40		39	40	32	22	110	87	4,0+5,0	1204			3611	BCL15	124513P	5520P	
SC50 SCLCR/L 17090-12		PSC50		30	50	25	17	90	68	4,0+5,0	1204			—	—	124510	5520	
SC50 SCLCR/L 22110-12		PSC50		39	50	32	22	110	87	4,0+5,0	1204			3611	BCL15	124513P	5520P	
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								



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



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

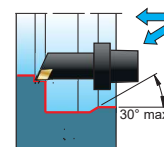
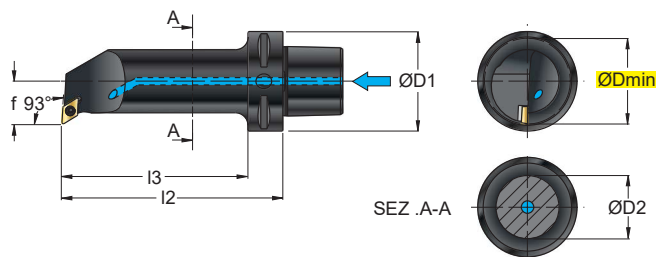
DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 992

SC.. SDUCR/L

93°



DC.T



DC.W

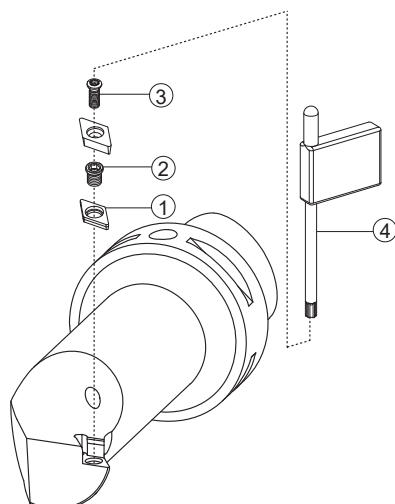


S



in figura utensile destro - right-hand shown

																
.G13	.B53	.G57P	.Z57	.G39	.G42	.G52										INSERTI - INSERTS PAG. 150
ART.				(mm)												
				ØDmin	ØD1	ØD2	f	l2	l3	Nm						
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



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



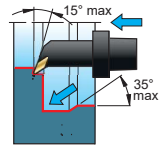
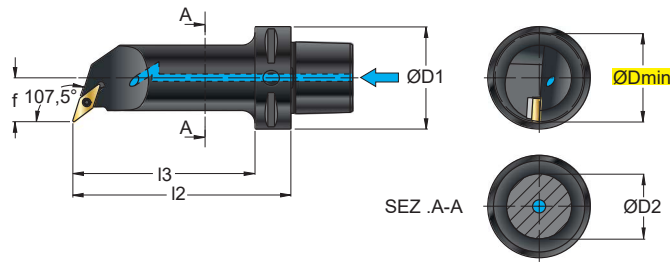
PAG. 967

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



PAG. 992

107,5°



A cross-sectional diagram of a tapered roller bearing. The central shaft is shown in yellow, and the surrounding housing is in grey with diagonal hatching. The contact surface between the shaft and the housing is tapered. An arrow indicates the angle of this taper, which is labeled as 5° .

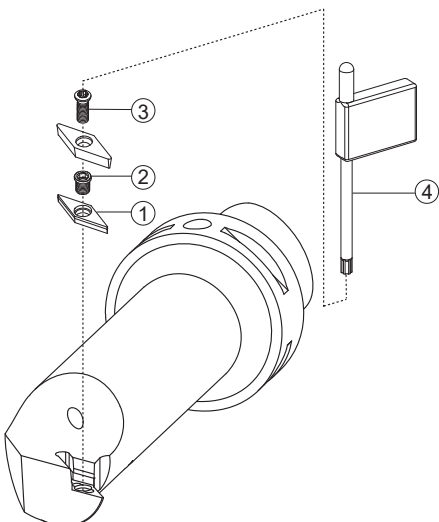
A technical drawing of a dovetail joint. It shows a cross-section of two pieces of wood joined together. The joint is a dovetail, characterized by its trapezoidal shape. The angle of the dovetail is labeled as 5°.

INSERTI - INSERTS
PAG. 153

11

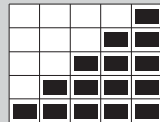
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SCELTA VELOCE QUICK PICK

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

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

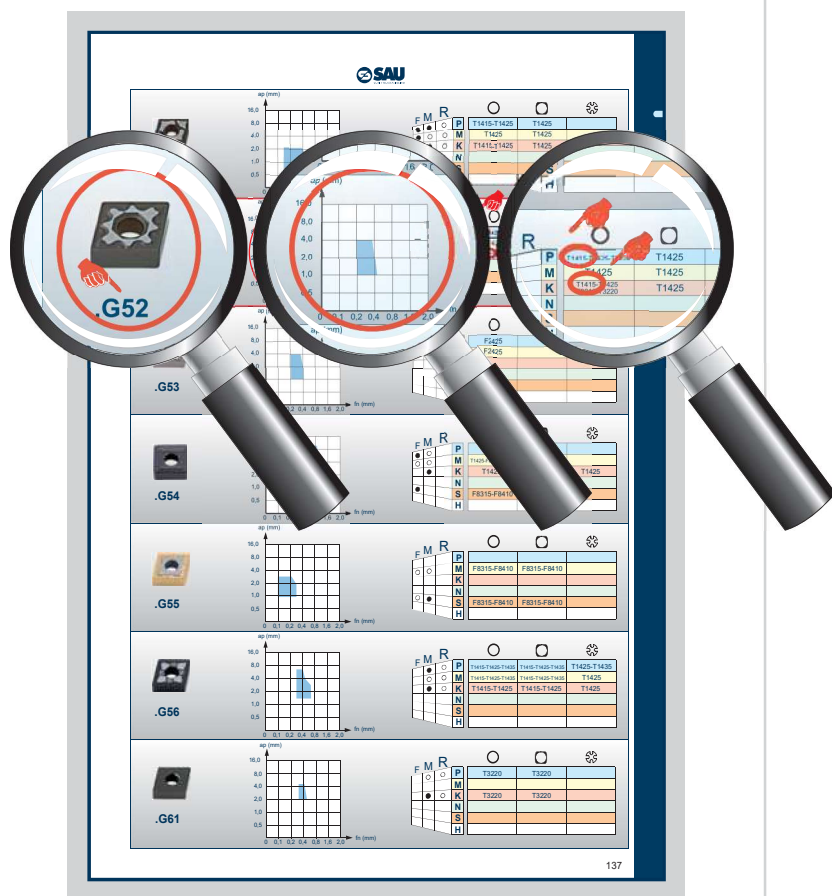
	HOW TO CHOOSE CUTTING DATA	Pag. 123
	GENERAL VIEW OF THE TURNING GRADE	Pag. 125
	APPLICATION OF THE TURNING GRADE	Pag. 126
	CUTTING SPEED OF TURNING GRADES	Pag. 132
	FIELDS OF APPLICATION FOR CHIP BREAKERS	Pag. 136
	INSERTS DESIGNATION FOR TURNING	Pag. 142
	INSERTS STOCK CATALOGUE	Pag. 143

	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 QUALITÉS 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
	DÉNOMINATION DES LES PLAQUETTES POUR LE TOURNAGE	Pag. 142
	CATALOGUE DE DISPONIBILITÉ PLAQUETTES	Pag. 143

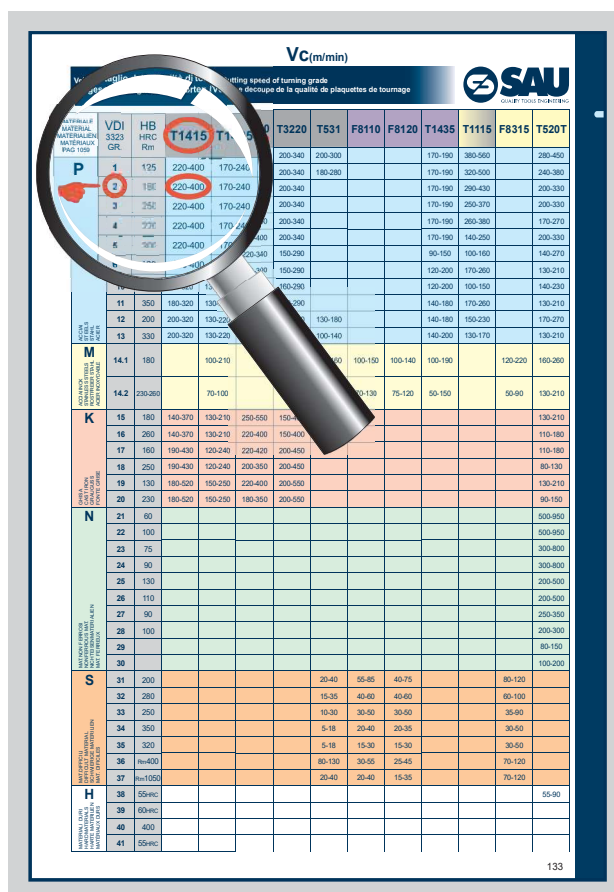
FASE 3 - PHASE 3

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			
HC		T3210										T3210	NEW		
							F8410								
		T1115													
		T1415										T1415			
							F8315								
							T520T					T520T			
							F2120					F2120			
		T3220										T3220			
	NEW	T1625					T1625					T1625			
		T1425					T1425					T1425			
							F2425								
							T531								
							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				HC				
	METALLO DURO NON RICOPERTO UNCOATED CARBIDE UNBESCHICHTETES HARTMETALL MÉTAL DUR PAS RECOUVERT										METALLO DURO RICOPERTO COATED CARBIDE BESCHICHTETES HARTMETALL MÉTAL DUR RECOUVERT				

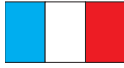
SAU	DIN ISO 513		MATERIALE - MATERIAL MATERIALIEN - MATÉRIAUX PAG. 1063						QUICK PICK PAG. 120	Tenacità Toughness	INDICAZIONI - USO
			P	M	K	N	S	H			
			ACCI STEELS STAHL ACIER	ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	GHISA CAST IRON GRAUGUSS FONTE GRISE	MAT NON FERROSI NON FERROUS MAT. NICH-ISENMATERIALIEN MAT. FERREUX	MAT DIFFICILI DIFFICULT MATERIAL SCHWERIGE MATERIALIEN MAT. DIFILES	MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATÉRIAUX 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	-HÖHE 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 ELEVÉE, 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 SORTA 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	- SORTA 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. - SORTA 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.

HT

CERMET

HW

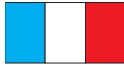
METALLO DURO NON RICOPERTO
UNCOATED CARBIDE
UNBESCHICHTETES HARTMETALL
MÉTAL DUR PAS RECOUVERT

HC

METALLO DURO RICOPERTO
COATED CARBIDE
BESCHICHTETES HARTMETALL
MÉTAL DUR RECOUVERT

SAU	DIN ISO 513		MATERIALE - MATERIAL MATÉRIEL - MATÉRIEL PAG. 1063						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	MAT NON FERROSI NON FERROUS MAT. NICH-TEISENMATERIALIEN MAT. FERREUX	MAT DIFFICILI DIFFICULT MATERIAL SCHWERGE MATERIALIEN MAT. DIFCILES	MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATERIAUX DURS			
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	●	○	○						- VASTA GAMMA DI IMPIEGHI, IDEALE PER TUTTE LE LEGHE DI ACCIAIO E GHISA, BUONE PRESTAZIONI ANCHE SU INOX
	CVD	M10-25 K25-35									
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	○	●			●				- QUALITA' MICROGRANO TENACE CON BUONA RESISTENZA AGLI URTI ED AGLI SHOCK TERMICI - INDICATO PER MEDIE E MEDIO-BASSE VELOCITÀ DI TAGLIO
	CVD	M20-40									
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	●	○							- GRADO INSERTO TENACE PER LAVORAZIONI DIFFICILI CON CONDIZIONI INSTABILI E A TAGLIO INTERROTTO
	CVD	M20-30									
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 MEME A 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

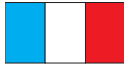
SAU	DIN ISO 513		MATERIALE - MATERIAL MATERIALIEN - MATÉRIAUX						PAG. 1063	QUICK PICK PAG. 120	 INDICAZIONI - USO	
			P	M	K	N	S	H				
			ACCIAI STEELS STAHL ACIER	ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	GHISA CAST IRON GRAUGUSS FONTE GRISE	MAT.NON FERROSI NON-FERROUS MAT. NICHT-EISENMATERIALIEN MAT. FERREUX	MAT.DIFFICILI DIFFICULT MATERIAL SCHWIERIGE MATERIALIEN MAT. DIFFICILES	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 TENACITA'. - INDICATO PER MEDIO-BASSE VELOCITA' DI TAGLIO E MEDIO-ALTI AVANZAMENTI
	CVD	M10-30 K15-35										
T2335	HC	M25-45		●							●	- BUONA TENACITA' E RESISTENZA ALL'USURA. - QUALITA', IDEALE PER LA TORNITURA DI ACCIAI AUSTENITICI INOSSIDABILI.
	CVD											
T540	HC	P25-45	●	●		○	○			●	●	- ALTA TENACITA' , BUONA RESISTENZA ALL'USURA E ALLO SHOCK TERMICO - INDICATO PER BASSE VELOCITA' DI TAGLIO E ALTI AVANZAMENTI IN SGROSSATURA PESANTE ANCHE IN CONDIZIONI PRECARIE.
	CVD	M25-40										

● APPLICAZIONE CONSIGLIATA
RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ
APPLICATION CONSEILLÉE

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POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG
APPLICATION POSSIBLE

● APPLICAZIONE CONSIGLIATA
RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ
APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE
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APPLICATION POSSIBLE

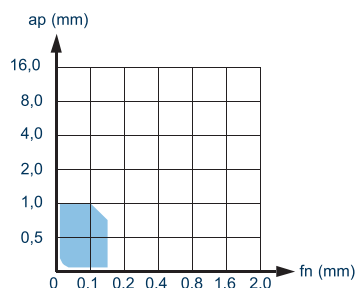
 INDICATIONS - USE	 GEBRAUCHSANWEISUNGEN	 INDICATION - USAGE
-MICROGRAIN GRADE, PVD-COATED -SUITABLE FOR SUPER-ALLOYS	- MIKROKORNSORTE, PVD-BESCHICHTET - ZUR BEARBEITUNG VON SUPER-LEGIERUNGEN GEEIGNET	- QUALITE MICROGRAIN EN PVD - PREVUE POUR L'USINAGE DES SUPER-ALLIAGES
-EXCELLENT RESISTANCE TO WEAR 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.

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 ACCAI 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 ACCAI 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 MAT/IRON FERROSI NONFERROUS MAT. NICH-TEISENMATERIALIEN 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 MAT/DIFFICILI 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 ACCI 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 ACCI 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 NON FERROUS MAT. NICH EISENMATERIALIEN 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. DIFCILES	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 MATERIALEN MATERIAUX 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. NICH-TEISENMATERIALIEN 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. DIFCILES	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 MATERIAUX DURS	38	55HRC										
	39	60HRC										
	40	400										
	41	55HRC										

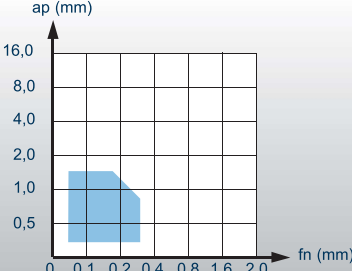
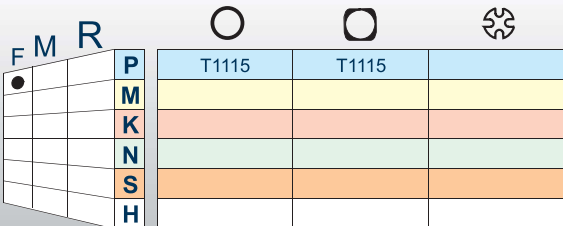
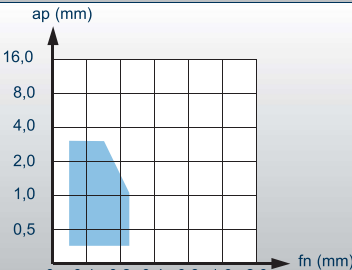
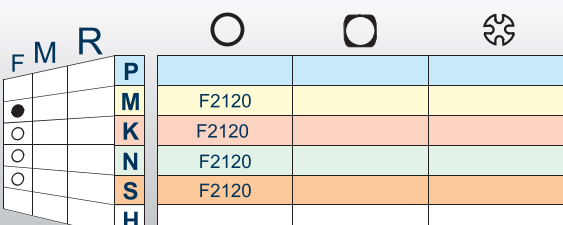
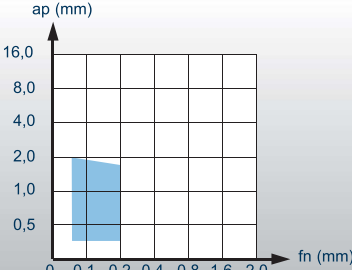
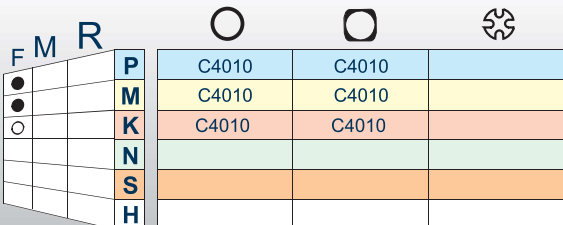
MATERIALE MATERIAL MATERIALIEN MATERIAUX PAG 1063	VDI 3323 GR.	HB HRC Rm											
P ACCIAI STEELS STAHL ACIER	1	125											
	2	180											
	3	250											
	4	220											
	5	300											
	6	180											
	7-8	250-300											
	9	350											
	10	200											
	11	350											
	12	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 GRISSE	15	180											
	16	260											
	17	160											
	18	250											
	19	130											
	20	230											
N MAT. NON FERROSI NON FERROUS 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. DIFCILES	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		

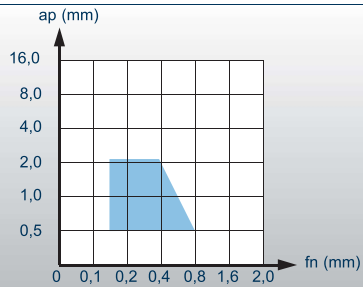
GRADI CONSIGLIATI
 RECOMMENDED GRADES
 EMPFOHLENE SORTEN
 DEGRÉS CONSEILLÉS

				
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		
 .G23		
 .G39		



.G42
NEW



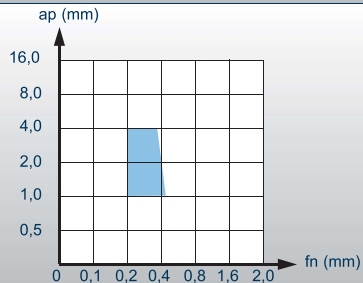
F	M	R
●	●	○
●	○	○
●	●	○

P
M
K
N
S
H

○	□	⊗
T1415-T1425	T1425	
T1425	T1425	
T1415-T1425	T1425	



.G52



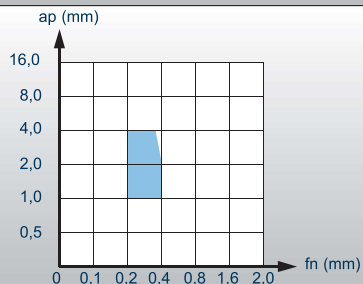
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○	○	
○	●	

P
M
K
N
S
H

○	□	⊗
T1415-T1425-T3220	T1425	
T1425	T1425	
T1415-T1425 T3210-T3220	T1425	



.G53



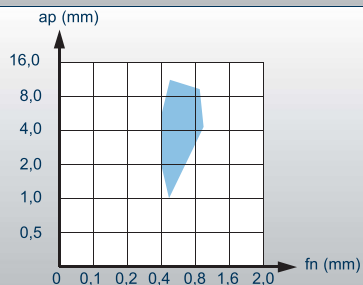
F	M	R
○	○	
●		

P
M
K
N
S
H

○	□	⊗
F2425		
F2425		



.G54



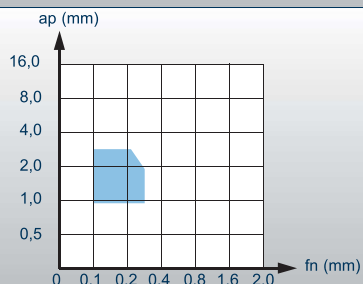
F	M	R
○	○	
○	○	
●		
●		

P
M
K
N
S
H

○	□	⊗
T1425	T1425	
T1425-F8315-F8410	T1425-F8315	
T1425	T1425	T1425
F8315-F8410	F8315	



.G55



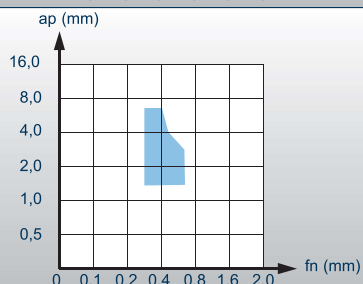
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○	○	
○		
○	●	

P
M
K
N
S
H

○	□	⊗
F8315-F8410	F8315-F8410	
F8315-F8410	F8315-F8410	



.G56



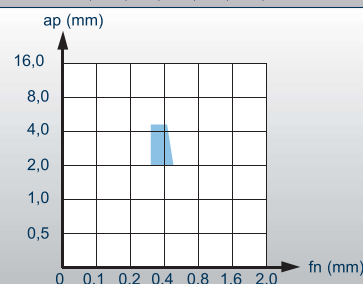
F	M	R
●	○	
○	○	
●	○	

P
M
K
N
S
H

○	□	⊗
T1415-T1425-T1435	T1415-T1425-T1435	T1425-T1435
T1415-T1425-T1435	T1415-T1425-T1435	T1425
T1415-T1425	T1415-T1425	T1425



.G61



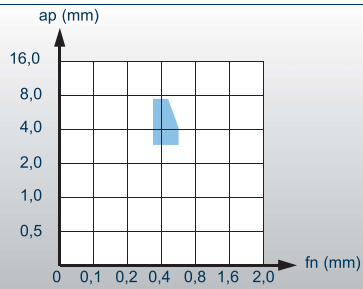
F	M	R
○	○	
○		
●	○	

P
M
K
N
S
H

○	□	⊗
T3220	T3220	
T3220	T3220	



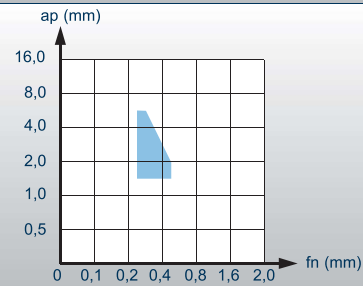
.G62



F	M	R			
	●	●	P	T1415-T1425 T1435-T3220	T1425-T1435
	○	○	M	T1415-T1425-T1435	T1425-T1435
	●	○	K	T1415-T1425 T3210-T3220	T1425-T3220
			N		
			S		
			H		



.G63

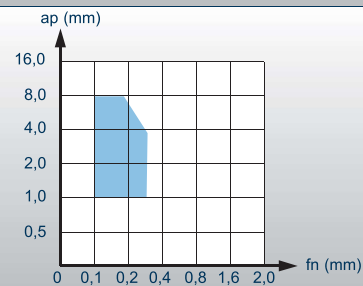


F	M	R			
		○	P	F2425	F2425
		●	M	F2425	F2425
			K		
			N		
			S		
			H		



.G68

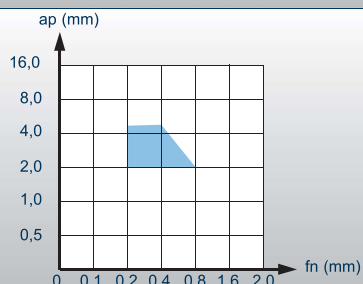
NEW



F	M	R			
	●	○	P	T1425	T1425
	○	○	M	T1425	T1425
	●	○	K	T1425	T1425
			N		
			S		
			H		



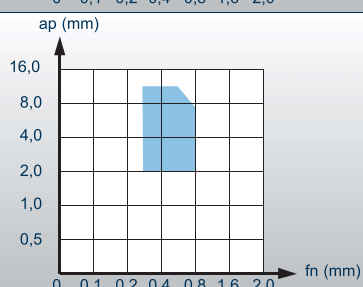
.G69



F	M	R			
	●	●	P	T1425	T1425
	○	○	M	T1425	T1425
	○	○	K	T1425	T1425
			N		
			S		
			H		



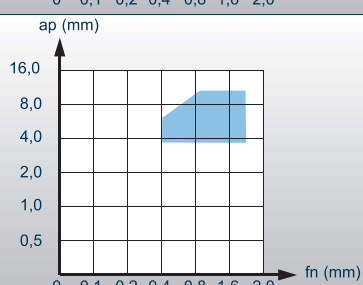
.G72



F	M	R			
	●	○	P	T1415-T1425-T1435	T1415-T1425-T1435
	○	○	M	T1415-T1425-T1435	T1415-T1425-T1435
		●	K	T1415-T1425-T1435	T1425-T1435
			N		
			S		
			H		



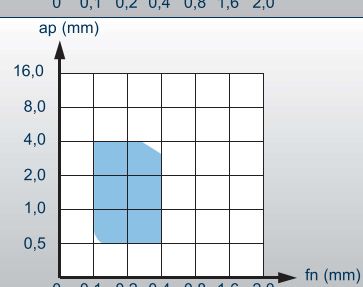
.G82



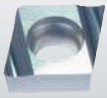
F	M	R			
		●	P	T1425	T1425
		○	M	T1425	T1425
		●	K	T1425	T1425
			N		
			S		
			H		



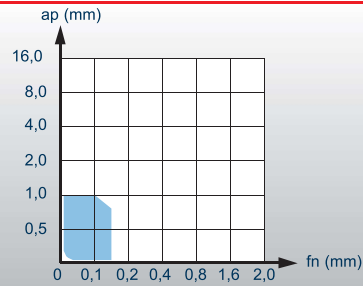
.K57P



F	M	R			
			P		
			M		
			K		
○	●	●	N	T110	T110
			S		
			H		



.B22

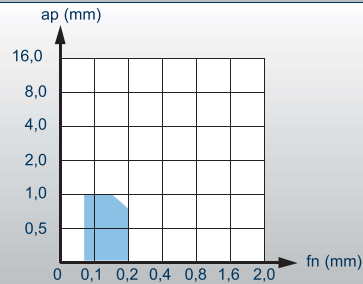


F	M	R
●		
●		

	○	□	⊗
P	DT63		
M	DT63-T531	T531	T531
K	DT63		
N			
S			
H			



.B33

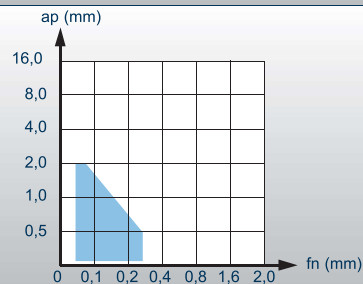


F	M	R
●		
●		

	○	□	⊗
P			
M	F8110	F8110	
K			
N			
S	F8110	F8110	
H			



.B53

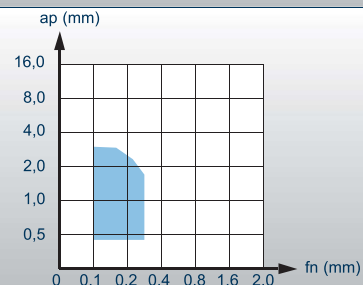


F	M	R
	●	
	●	

	○	□	⊗
P			
M			F8120
K			
N			
S			F8120
H			



.B56

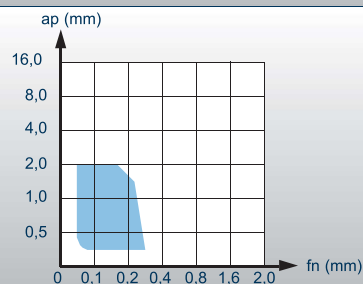


F	M	R
○	●	○
○	●	○

	○	□	⊗
P	DT63		
M	DT63-T2335	T2335	
K			
N			
S			
H			



.D34

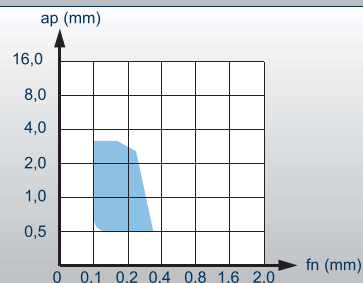


F	M	R
●		
●		

	○	□	⊗
P	DT61T		
M	DT61T		
K			
N			
S			
H			



.D42

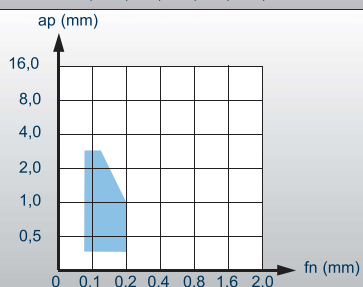


F	M	R
●	●	
●	●	
●	●	

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



.G13

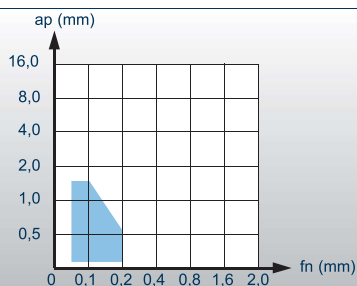


F	M	R
●		
○		
○		
○		

	○	□	⊗
P			
M	F2120	F2120	
K	F2120	F2120	
N	F2120	F2120	
S	F2120	F2120	
H			



.G39

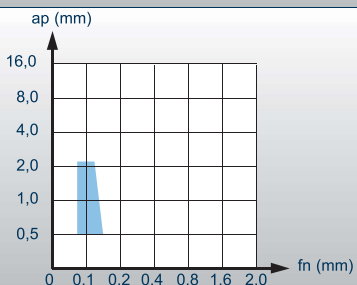


F	M	R			
○			P	○	○
●			M	○	○
○			K	○	○
			N	○	○
			S	○	○
			H	○	○

C4010		
C4010		
C4010		



.G42

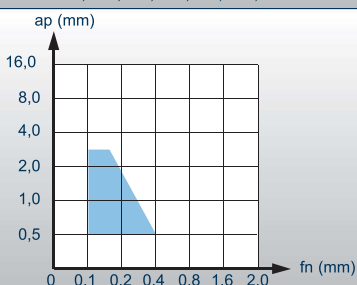


F	M	R			
○			P	○	○
●			M	○	○
○			K	○	○
			N	○	○
			S	○	○
			H	○	○

T1415-T1425-F2425	T1415-T1425-F2425	
T1425-F2425	T1425-F2425	
T1415-T1425	T1415-T1425	



.G52

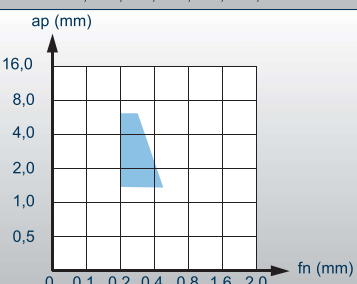


F	M	R			
○	●		P	○	○
○	●		M	○	○
○	●		K	○	○
			N	○	○
			S	○	○
			H	○	○

F2425-F2435-T1415 T1425-T1435-T3220	F2425-F2435-T1425 T1435-T3220	F2435-T1435
F2425-F2435 T1425-T1435	F2425-F2435 T1425-T1435	F2435-T1435
T3220-T1415-T1425	T3220-T1425	



.G57P

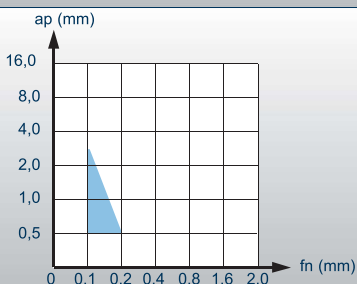


F	M	R			
○			P	○	○
○			M	○	○
○	○		K	○	○
○	○		N	○	○
○	○		S	○	○
			H	○	○

T115	T115	
T115	T115	
T115	T115	



.G58

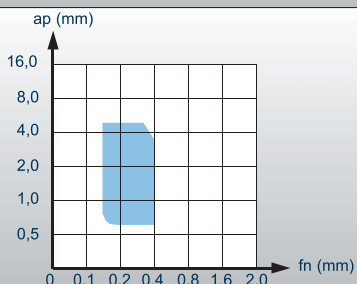


F	M	R			
○	●		P	○	○
○	○		M	○	○
○	○		K	○	○
			N	○	○
			S	○	○
			H	○	○

T1425-F2435	T1425-F2435	
T1425-F2435	T1425-F2435	
T1425-F2435	T1425-F2435	



.S42

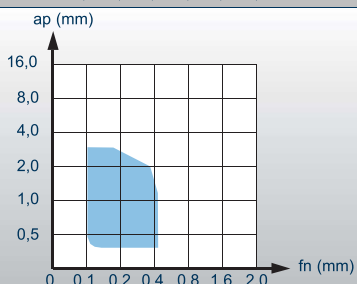


F	M	R			
●	●		P	○	○
●	●		M	○	○
●	●		K	○	○
●	●		N	○	○
			S	○	○
			H	○	○

T540	T540	T540
T540	T540	T540
T120	T120	
T120	T120	T120



.S44

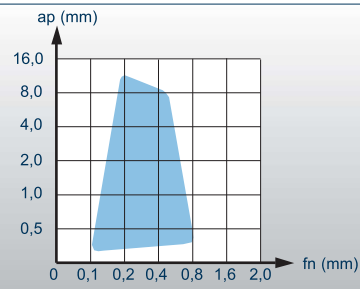


F	M	R			
●	●		P	○	○
●	○		M	○	○
●	○		K	○	○
			N	○	○
			S	○	○
			H	○	○

T520T-T1625	T520T-T1625	
T520T-T1625	T520T-T1625	
T520T-T1625	T520T-T1625	



.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

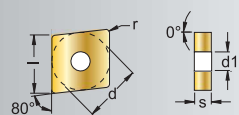
SGROSSATURA ROUGHING	7
GENERIC GENERIC	6
FINITURA FINISHING	5
TAGLIANTE AFFILATO SHARP CUTTING EDGE	4
SUPERFINITURA SUPER-FINISHING	3
1	2

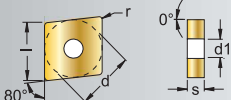
12 PREPARAZIONE TAGLIANTE
CUTTING EDGE PREPARATION

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 GENERICO INTERMEDIATE FOR GENERAL USE
4 =	
5 =	
6 =	
8 =	

13

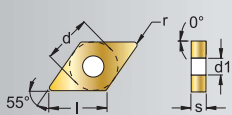
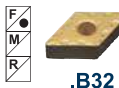
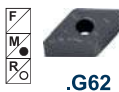
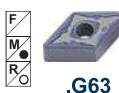
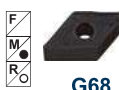
P =	LUCIDATO POLISH
W =	GEOMETRIA CON WIPER GEOMETRY WITH WIPER

CNGP CNMA CNMG		HT		HW		HC																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
		CERMET		NON RIVESTITI CEMENTED CARBIDE GRADES		RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
INSERTI NEGATIVI - NEGATIVE INSERTS - NEGATIVE WENDEPLATTEN - PLAQUÉTTES NEGATIVES														C4010																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							</

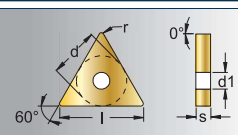
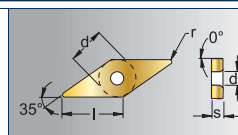
CNMG CNMM							HT		HW		HC																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
							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

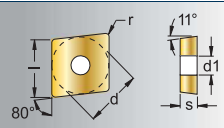
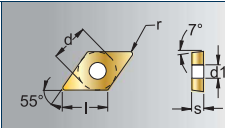
DNGP DNMG DNMM								HT CERMET	HW NON RIVESTITI CEMENTED CARBIDE GRADES			HC RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS															
		INSERTI NEGATIVI - NEGATIVE INSERTS - NEGATIVE WENDEPLATTEN - PLAQUÉTTES NEGATIVES						C4010																			
ART.	COD.	l	d	s	d1	r																					
 .G23	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																				
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																										

146

TNMA TNMG		VNGP VNMG		HT CERMET				HW NON RIVESTITI CEMENTED CARBIDE GRADES				HC 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 RÉSISTANTES À LA CHALEUR																					
H	MATERIALI DURI E TEMPRATI - HARD AND HARDENED MATERIAL - HARTE UND GEHÄRTETE MATERIALIEN - MATERIAUX DURS ET TREMPÉS																					

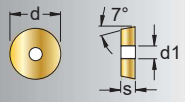
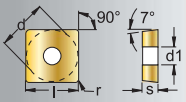
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■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW □ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW
● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION-
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE ○ APPLICAZIONE POSSIBILE - POSSIBLE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

CPGT CPMT		DCGT DCMT		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	DT61T			T110	T115	T120	F2120	F2425	T1415	T1425	T3220			F8120	T1435						
 .D34	CPGT 05T102 EN .D34	5,6	5,56	1,97	2,5	0,2		■																				
	CPGT 05T104 EN .D34	5,6	5,56	1,97	2,5	0,4		■																				
 .D42	CPGT 05T102 FN .D42	5,6	5,56	1,97	2,5	0,2							■															
	CPGT 05T104 FN .D42	5,6	5,56	1,97	2,5	0,4							■															
 .G42	CPMT 05T102 EN .G42	5,6	5,56	1,97	2,5	0,2												■										
	CPMT 05T104 EN .G42	5,6	5,56	1,97	2,5	0,4												■										
	NEW																											
 .G13	DCGT 070200 .G13	7,8	6,35	2,38	2,8	0,0									■													
	DCGT 070201 .G13	7,8	6,35	2,38	2,8	0,1									■													
	DCGT 11T300 .G13	11,6	9,52	3,97	4,4	0,0									■													
	DCGT 11T301 .G13	11,6	9,52	3,97	4,4	0,1									■													
 .B53	DCGT 070202 .B53	7,8	6,35	2,38	2,8	0,2																	■					
	DCGT 070204 .B53	7,8	6,35	2,38	2,8	0,4																	■					
	DCGT 11T302 .B53	11,6	9,52	3,97	4,4	0,2																	■					
	DCGT 11T304 .B53	11,6	9,52	3,97	4,4	0,4																	■					
 .G57P	DCGT 070201 .G57P	7,8	6,35	2,38	2,8	0,1						■																
	DCGT 070202 .G57P	7,8	6,35	2,38	2,8	0,2						■																
	DCGT 070204 .G57P	7,8	6,35	2,38	2,8	0,4						■																
	DCGT 070208 .G57P	7,8	6,35	2,38	2,8	0,8						■																
	DCGT 11T302 .G57P	11,6	9,52	3,97	4,4	0,2						■																
	DCGT 11T304 .G57P	11,6	9,52	3,97	4,4	0,4						■																
	DCGT 11T308 .G57P	11,6	9,52	3,97	4,4	0,8						■																
 .Z57	DCGT 070202 FN .Z57	7,8	6,35	2,38	2,8	0,2					■																	
	DCGT 070204 FN .Z57	7,8	6,35	2,38	2,8	0,4					■																	
	DCGT 11T302 FN .Z57	11,6	9,52	3,97	4,4	0,2					■																	
	DCGT 11T304 FN .Z57	11,6	9,52	3,97	4,4	0,4					■																	
	DCGT 11T308 FN .Z57	11,6	9,52	3,97	4,4	0,8					■																	
 .G39	DCMT 070204 .G39	7,8	6,35	2,38	2,8	0,4	■																					
	DCMT 11T304 .G39	11,6	9,52	3,97	4,4	0,4	■																					
 .G42	DCMT 070202 .G42	7,8	6,35	2,38	2,8	0,2									■			■										
	DCMT 070204 .G42	7,8	6,35	2,38	2,8	0,4									■			■										
	DCMT 11T302 .G42	11,6	9,52	3,97	4,4	0,2									■			■										
	DCMT 11T304 .G42	11,6	9,52	3,97	4,4	0,4									■			■										
	DCMT 11T308 .G42	11,6	9,52	3,97	4,4	0,8									■			■										
 .G52	DCMT 070204 .G52	7,8	6,35	2,38	2,8	0,4									■			■	■				■					
	DCMT 070208 .G52	7,8	6,35	2,38	2,8	0,8									■			■					■					
	DCMT 11T304 .G52	11,6	9,52	3,97	4,4	0,4									■	■	■	■	■				■					
	DCMT 11T308 .G52	11,6	9,52	3,97	4,4	0,8									■	■	■	■	■				■					
MATERIALE - MATERIAL - MATERIALIEN - MATÉRIAUX							C4010	DT61T			T110	T115	T120	F2120	F2425	F2435	T1415	T1425	T3220			F8120	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 - MATÉRIAUX DURS ET TREMPÉS																											

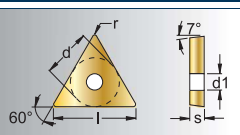
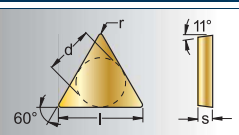
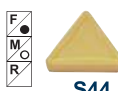
■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
 ● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION-
 EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

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

RCGT RCMT			SCGT SCMT			HT CERMET		HW NON RIVESTITI CEMENTED CARBIDE GRADES		HC RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
INSERTI POSITIVI - POSITIVE INSERTS - POSITIVE WENDEPLATTEN - PLAQUÉTTES POSITIVES																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								

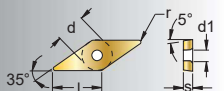
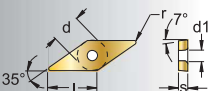
■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
 ● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION-
 EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

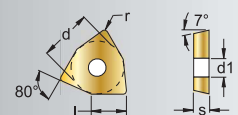
□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW
 ○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION -
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

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								C4010				T110	T115	T120	T1625 €12	F2425	F2435	T1415	T1425	T3220		T1435		T520T	T540	
ART.	COD.	l	d	s	d1	r																				
 .G39	TCGT 110202 .G39	11,0	6,35	2,38	2,8	0,2	■																			
 .G57P	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																									
 .Z57	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						■														
 .G39	TCMT 110204 .G39	11,0	6,35	2,38	2,8	0,4	■																			
 .S42	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							■													
 .G52	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									■			■			■					
 .S44	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 €12	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
 ● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION-
 EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

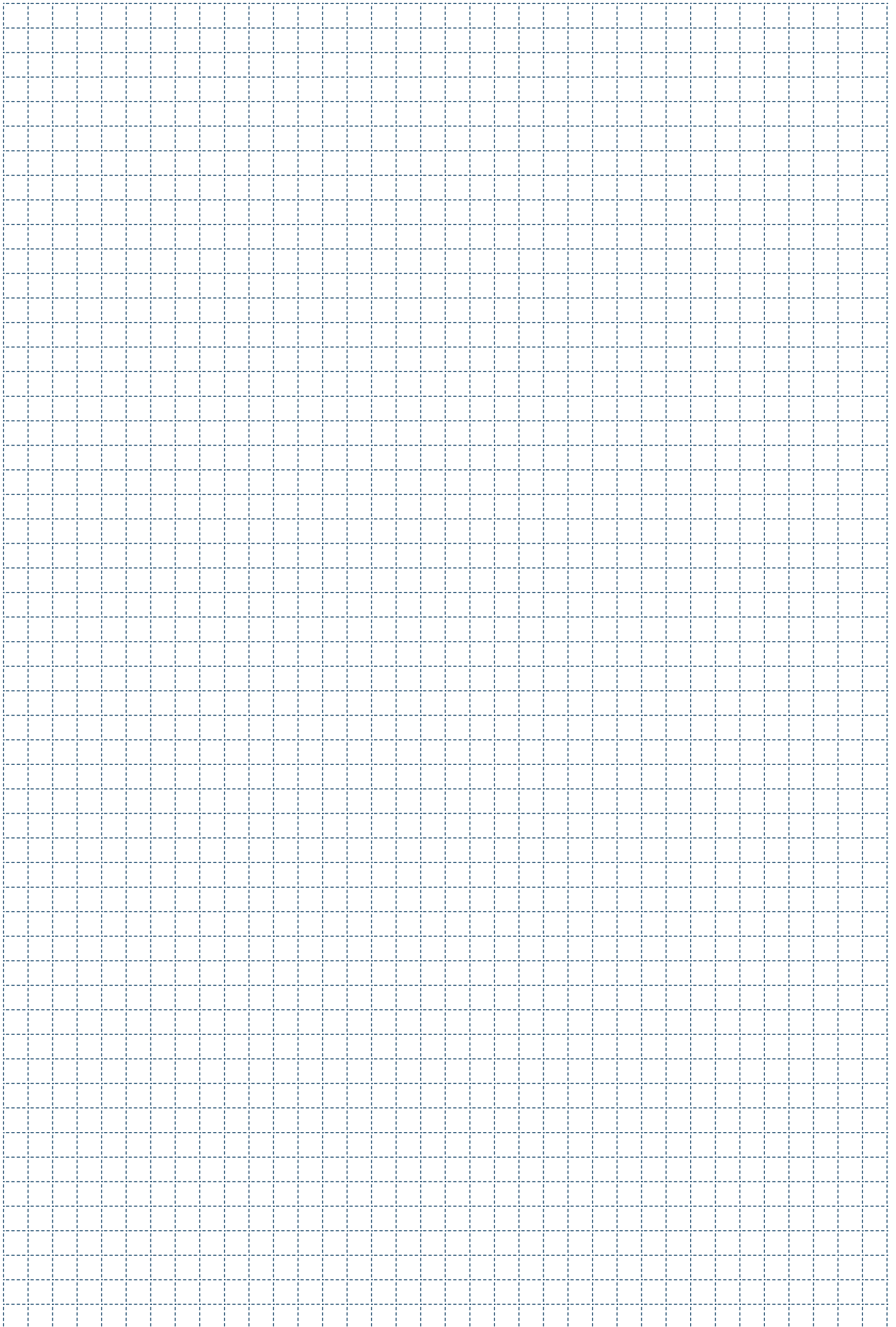
□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW
 ○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION -
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

VBMT		VCGT VCMT		HT		HW		HC																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
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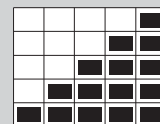
■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
 ● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION-
 EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

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 ○ 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

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

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

SAU QUALITY TOOLS ENGINEERING

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

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



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	PANORAMICA QUALITÀ TAGLIO-SCANALATURA	Pag. 161
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COME SCEGLIERE I PARAMETRI DI LAVORO
HOW TO CHOOSE CUTTING DATA
EINSTELLUNG DER SCHNITTDATEN
COMMENT CHOISIR LES PARAMETRES DE SERVICE

FASE 1 - PHASE 1

SCELTA GR. VDI IN FUNZIONE DEL MATERIALE
 CHOICE OF VDI GR. DEPENDING ON MATERIAL
 WAHL VDI-SORTE JE NACH WERKSTOFF
 CHOIX GR. VDI EN FONCTION DU MATERIEL

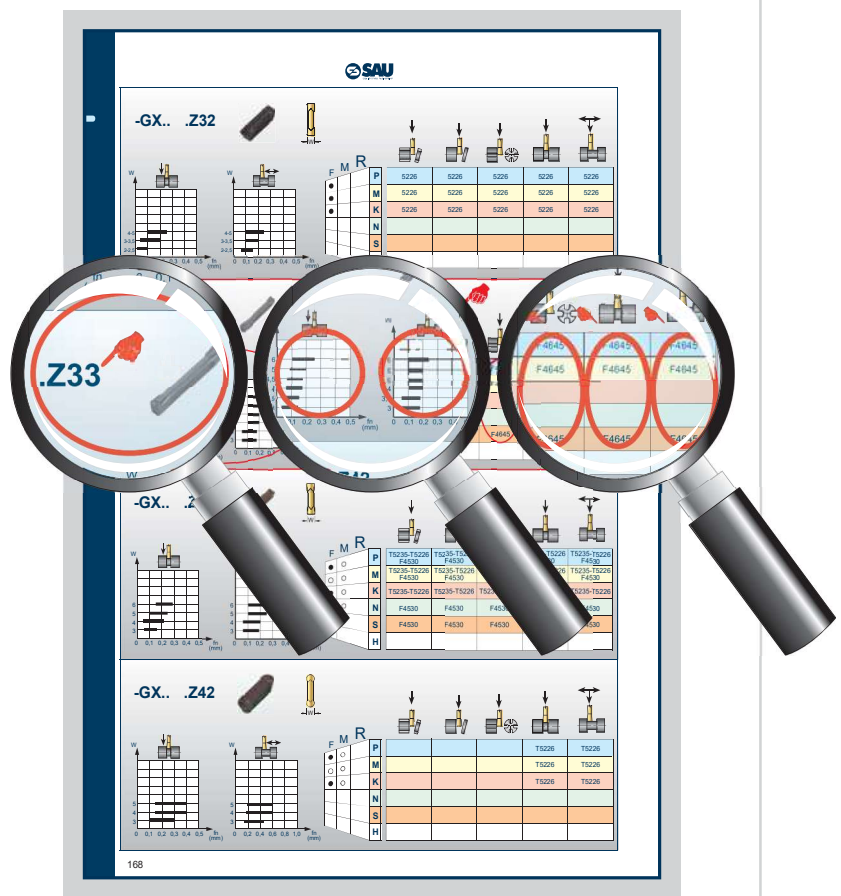
Tabella comparativa dei materiali - Materials comparison table
Material vergleichstabelle - Tableau comparatif des matériaux

UNI	WISTOFF	DIN	AISI	BS	AFNOR	JIS	Ac1,1	mc	VDI 3323 GR.
ACCIAIO NON LEGATO RICOTTO ANNEALED NOT-ALLOY STEEL									
C < 0,15% 125 HB									
CF 10 SPn 20	1.0722	10 SPn 20	11 L 08	-	10 PnF 2	-	-	-	0,22
CF 9 SMn 28	1.0715	9 SMn 28	12 L 13	230 M 07	S 250	SUM22	-	-	0,22
CF 9 SMn 36	1.0736	9 SMn 36	12 L 15	240 M 07	S 300	SUM22	-	-	0,22
CF 9 SMn 36	1.0718	9 SMn 36	12 L 13	-	S 250 Pb	-	-	-	0,22
CF 9 SMn 36	1.0737	9 SMn 36	12 L 14	-	S 300 Pb	-	-	-	0,22
C 15; C 16	1.0401	C 15	10 M 15	080 M 15	AF 7 C 12; XC 18	-	-	-	0,22
C 20; C 21	1.0402	C 20	10 M 20	090 A 20	AF 42 C 20	-	-	-	0,22
C 25	1.0403	C 25	10 M 25	090 M 25	XC 15; XC 18	-	-	-	0,22
ACCIAIO NON LEGATO RICOTTO ANNEALED NOT-ALLOY STEEL									
C 0,15-0,55% 180									
-	-	28 M 6	1330	150 M 28	20 M 5	-	-	-	0,22
-	-	35 S 20	1140	212 M 36	35 MF 4	-	-	-	0,22
-	-	50 M 5	-	-	-	-	-	-	0,22
-	-	50 M 4	1039	150 M 36	35 M 5	-	-	-	0,22
-	-	C 35	1015	080 A 35	AF 55 C 35	-	-	-	0,22
-	-	C 45	1045	080 M 45	AF 55 C 45	-	-	-	0,22
-	-	58 Cr 45	1045	080 M 46	XC 42	-	-	-	0,22
-	-	C 75	-	-	-	-	-	-	0,22
-	-	C 53	-	-	-	-	-	-	0,22
ACCIAIO BONIFICATO TEMPERED NOT-ALLOY STEEL									
C 0,15-0,55% 250									
-	-	28 M 6	1330	150 M 28	20 M 5	-	-	-	0,22
-	-	35 S 20	1140	212 M 36	35 MF 4	-	-	-	0,22
-	-	50 M 5	-	-	-	-	-	-	0,22
-	-	50 M 4	1039	150 M 36	35 M 5	-	-	-	0,22
-	-	C 35	1015	080 A 35	AF 55 C 35	-	-	-	0,22
-	-	C 45	1045	080 M 45	AF 55 C 45	-	-	-	0,22
-	-	58 Cr 45	1045	080 M 46	XC 42	-	-	-	0,22
-	-	C 75	-	-	-	-	-	-	0,22
-	-	C 53	-	-	-	-	-	-	0,22
ACCIAIO RICOTTO NOT-ALLOY STEEL									
C > 0,55% 300 HB									
C 38 KU	1.1001	W 110	W 110	-	SK3	1600	0,24	-	4
C 50	1.0503	W 112	W 112	-	SK2	1600	0,24	-	4
C 55	1.0501	10505	070 M 55	-	SUP4	1600	0,24	-	4
C 60	1.1274	10506	080 A 60	-	SSPC	1600	0,24	-	4
C 70	1.1203	10507	070 M 70	-	BS5C	1600	0,24	-	4
C 80	1.1221	10508	080 A 80	-	S48C	1600	0,24	-	4
C 90	1.1270	10509	080 A 90	-	BS5C	1600	0,24	-	4
C 100	1.1271	10510	080 A 100	-	SNC236	1600	0,24	-	4
C 110	1.1272	10511	080 A 110	-	1600	0,24	-	-	4
ACCIAIO NON LEGATO RICOTTO QUENCHED AND TEMPERED NOT-ALLOY STEEL									
C > 0,55% 300 HB									
C 38 KU	1.1545	C 100 W 11	W 110	-	Y 100 C 6	SK3	1700	0,24	5
C 50	1.0503	C 125 W 12	W 112	-	Y 100 C 6	SK2	1700	0,24	5
C 55	1.0506	C 85	10505	070 M 55	-	SUP4	1700	0,24	5
C 60	1.0501	10506	080 A 60	-	C 55	SSPC	1700	0,24	5
C 70	1.1274	C 101	10508	080 A 80	-	SUP4	1700	0,24	5
C 80	1.1203	C 80	10507	070 M 70	-	BS5C	1700	0,24	5
C 90	1.1221	C 90	10508	080 A 90	-	S48C	1700	0,24	5
C 100	1.1270	C 100	10509	080 A 100	-	BS5C	1700	0,24	5
C 110	1.1271	C 110	10510	080 A 110	-	SNC236	1700	0,24	5
C 120	1.1520	C 120	10511	080 A 120	-	1700	0,24	-	5
ACCIAIO DEBOLMENTE LEGATO RICOTTO ANNEALED LOW ALLOY STEEL									
180 HB									
-	1.2067	10007 C	L 3	BL 3	Y 100 C 6	-	0,24	-	6
-	1.2419	105 W 6 C	A 182-F22	101-422 G 31	105 W 5 C	-	0,24	-	6
-	1.7280	12 C 40 A 9 10	A 182-F11	1501-420 G 27	15 CD 3 5	-	0,24	-	6
-	1.7335	13 C 40 A 4	A 182-F11	1501-420 G 27	15 CD 3 5	-	0,24	-	6
-	1.7715	A 182-F11	101-422 G 31	101-422 G 31	105 W 5 C	-	0,24	-	6
-	1.5622	14 N 6 E	A 350-LF 5	-	18 N 6	-	0,24	-	6
-	16 N 10 C 12	16 N 10 C 12	3415	822 M 13	14 N 12 C 1	-	0,24	-	6
-	1.5752	14 N 10 C 14	3310-3314	822 M 13	12 N 15	-	0,24	-	6
-	1.6857	16 N 10 C 34	3015	822 M 13	12 C 20	-	0,24	-	6
-	1.7015	15 Cr 3	5015	822 M 15	12 C 20	-	0,24	-	6

1060

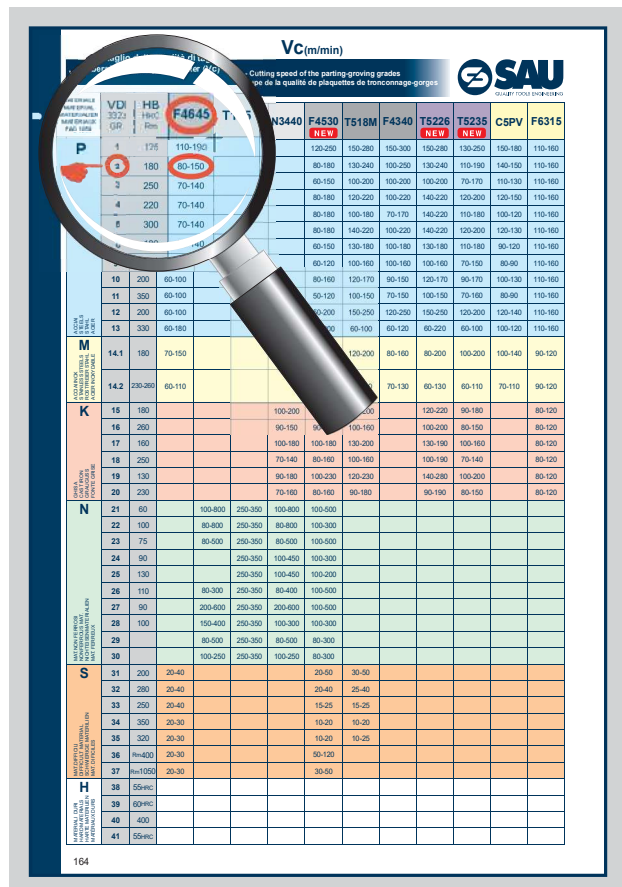
FASE 3 - PHASE 3

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



FASE 4 - PHASE 4

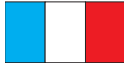
SCELTA DI VC IN FUNZIONE DEL GR. VDI
CHOICE OF VC DEPENDING ON VDI GR.
WAHL VC JE NACH WERKSTOFF
CHOIX DE VC EN FONCTION DU GR. VDI



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						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				

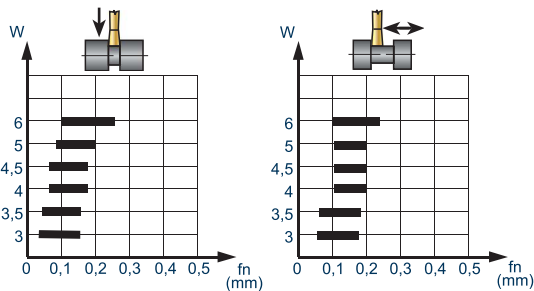
SAU	DIN ISO 513		MATERIALE - MATERIAL MATÉRIEL - MATÉRIEL						PAG. 1063	QUICK PICK		PAG. 156		INDICAZIONI - USO
			P	M	K	N	S	H						
			ACCI STEELS STAHL ACIER	ACCI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	GHISA CAST IRON GRAUGUSS FONTE GRISSE	MAT. NON FERROSI NON-FERROUS MAT. NICH-TEISENMATERIALIEN MAT. FERREUX	MAT. DIFFICILI DIFFICULT MATERIAL SCHWERGE MATERIALIEN MAT. DIFFICILES	MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATÉRIEL 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 GUSS 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/IRON 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. DIFFILES	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 MAT/IRON 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

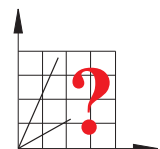
-TORNITURA
-TURNING
-DREHEN
-TOURNAGE

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

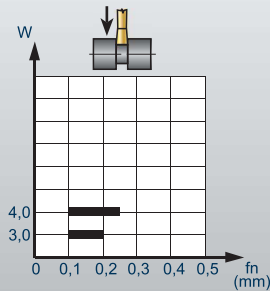
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	F4645	F4645	F4645	F4645	F4645
	F4645	F4645	F4645	F4645	F4645

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	ROHRABSTECHEN	TRONÇONNAGE TUYAUX
	TRONCATURA BARRE	PARTING OF BARS	STANGENABSTECHEN	TRONÇONNAGE BARRES
	TRONCATURE DIFFICILI	DIFFICULT PARTING OPERATION	SCHWIERIGES ABSTECHEN	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



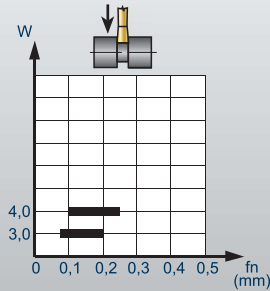
-TRLN..G52



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

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

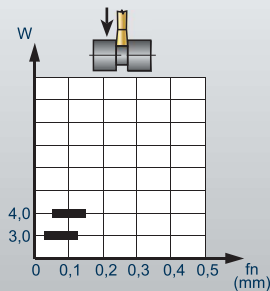
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F	M	R	
○	●	●	P
○	●	●	M
○	●	●	K
			N
			S
			H

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

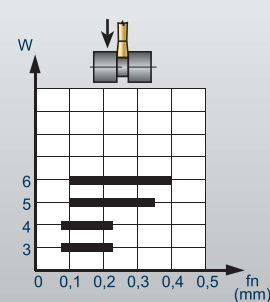
-TRLN..G57P



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

T115	T115	T115	T115	

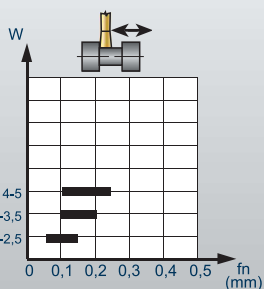
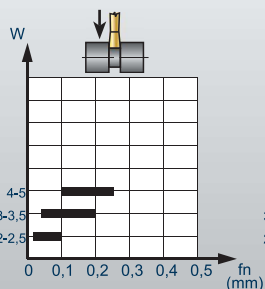
-STN .L52



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	

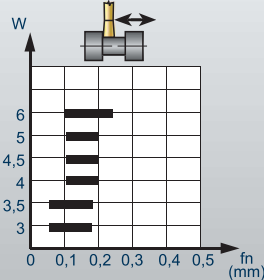
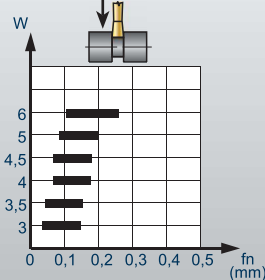
-GX.. .Z32



F	M	R
●		
●		
●		

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

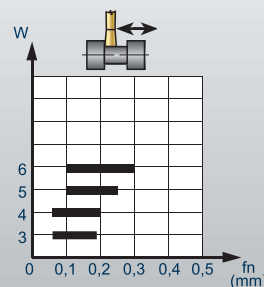
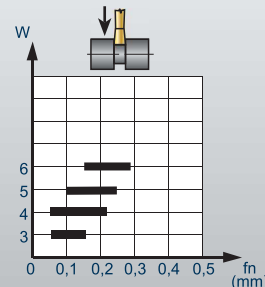
-GX.. .Z33



F	M	R
●		
○		

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

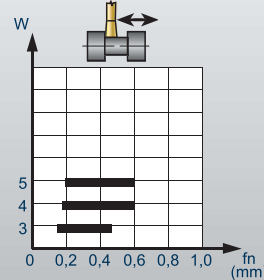
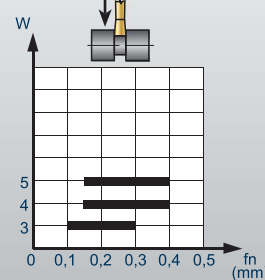
-GX.. .Z42



F	M	R
●	○	
○	○	
●	○	
○	○	
○	○	

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

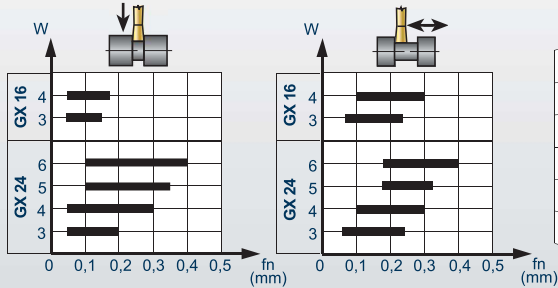
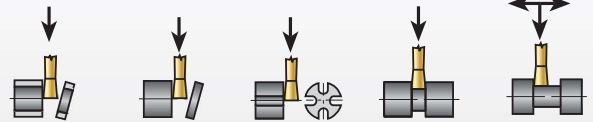
-GX.. .Z42



F	M	R
●	○	
○	○	
●	○	

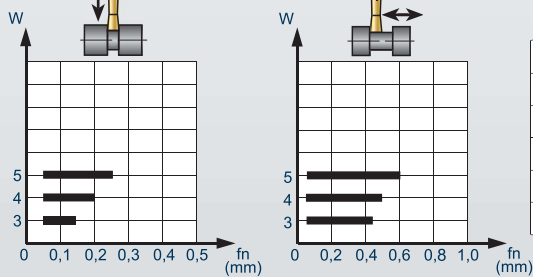
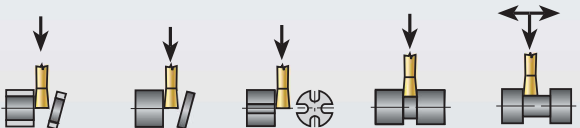
P				T5226	T5226
M				T5226	T5226
K				T5226	T5226
N					
S					
H					

-GX.. .Z47P



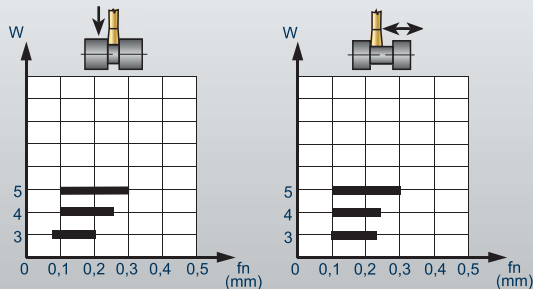
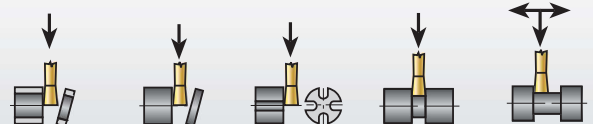
F	M	R

-GX.. .Z47P



F	M	R

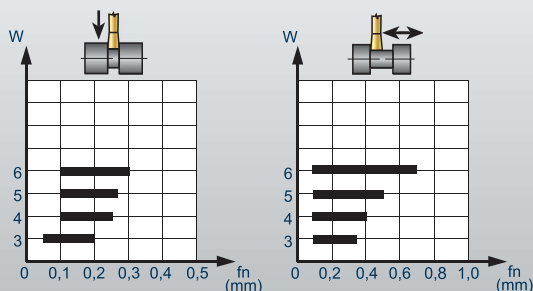
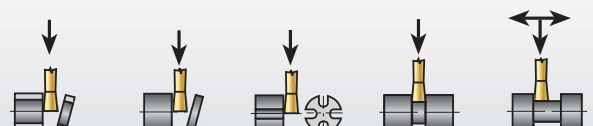
-GX.. .Z52



F	M	R

	F4645	F4645	F4645	F4645	F4645
	F4645	F4645	F4645	F4645	F4645

-GX.. .Z62



F	M	R

				T5235	T5235
				T5235	T5235
				T5235	T5235

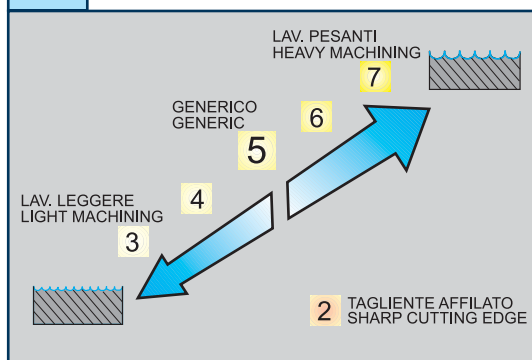
GX 24 - 2E 3.00 N - 0.30

-	-	-	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	F4340				T5226	F6315							
ART.		COD.	W	r/s	l	d	M/T	a°/d1													
 		TOLLERANZA W - W TOLERANCE	+0,05 -0,05																		
		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	+0,05 +0,01																		
		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												
 		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												
		 		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°										
				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°										
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°												
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°												
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	F4340	T5226	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																				

Taglio
Scanalatura

Parting
Grooving

Abstechen
Nutendreihen

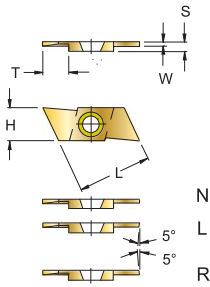
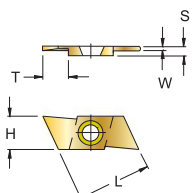
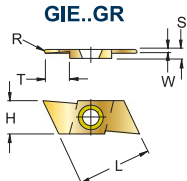
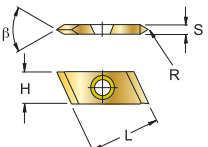
Tronçonnage
Gorges

Corte
Ranuras

GX..		STN..		TRLN..		HW		HC	
NON RIVESTITI CEMENTED CARBIDE GRADES		RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS							
INSERTI NEGATIVI - NEGATIVE INSERTS - NEGATIVE WENDEPLATTEN - PLAQUÉTTES NEGATIVES									
ART.	COD.	W	r/s	l	d	M/T	a°/d1	T115	
 .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°		
 .Z42	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°		
 .G56	TRLN 3.00-0.30N .G56	3,0*	0,3	—	—	—	0°		
	TRLN 4.00-0.40N .G56	4,0*	0,4	—	—	—	0°		
 .G57P	TRLN 3.00-0.30N .G57P	3,0*	0,3	—	—	—	0°		
	TRLN 4.00-0.40N .G57P	4,0*	0,4	—	—	—	0°		
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 RESISTANTES 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
● 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

MINI GROOVE									HW		HC			
									NON RIVESTITI CEMENTED CARBIDE GRADES		RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS			
ART.	COD.	W ^{+0,02} ₀	β	R	T	H	S	L						
Scanalatura e Taglio Grooving and parting GIE..GP 	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					■	
Tornitura - Turning GIE..ST 	GIE - 7 - ST - 3.0 R	3,17	—	—	—	7	3,17	17					□	
	GIE - 7 - ST - 3.0 L	3,17	—	—	—	7	3,17	17					□	
Scanalatura per anelli Grooving for Rings GIE..SG 	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					□	
Scanalatura raggiata e profilatura Radial Grooving and profiling GIE..GR 	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					■	
Filettatura - Threading GIE..GW 	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					□	
MATERIALE - MATERIAL - MATERIALIEN - MATÉRIAUX													C5PV	
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													

