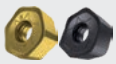
SPIANATURA

SPIANATURA

	SON06C	SHN06C	SHN09C	SPN13		
	43°	45°	45°	57°		
	APMX (mm) 4.0 (7.0)	APMX (mm) 3.0	APMX (mm) 5.0	APMX (mm) 10.0		
	DC (mm) 50 – 250	DC (mm) 25 – 125	DC (mm) 50 – 315	DC (mm) 100 – 315		
Codolo cilindrico						
Weldon		 DC = 25, 32 (mm)				
Modulare						
Fresa a manicotto		 DC = 40 – 125 (mm)				
Pagina	8	13	17	21		
ISO	P M K S H	P M K H	P M K H	P M K S H		
Forma dell'inserto						
Inserti	ONMX 0605 SNMX 1705	HNGX 0604 XNGX 0604	HNGX 0906 XNGX 0906	PNM. 1308 XN.. 1308		
N. di taglienti	16 / 8	12 / 1	12 / 1	10 / 1		
Spianatura 	■	■	■	■		
Smussatura 	■	■	■			
Fresatura a tuffo progressiva 		■	■			
Rampa 	◪	■	■			

■ Uso primario ◪ Uso possibile

SON06C

P M K S H

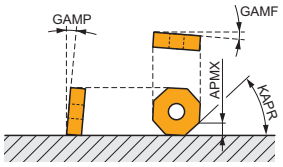
PRAMET

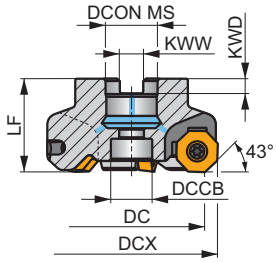
S

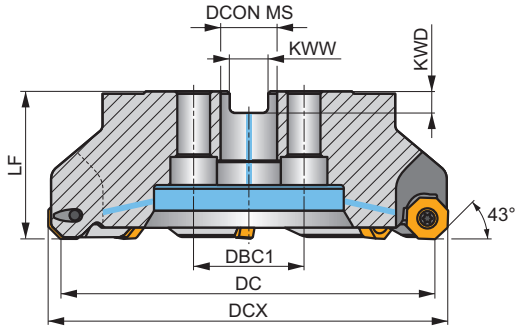
ECON ON06 Fresa per spianatura a 43° con geometria doppio negativa e passaggio refrigerante interno

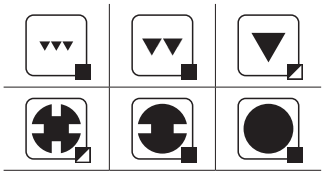
Fresa per operazioni di spianatura altamente produttiva prevede l'utilizzo di due tipologie di inserti negativi bilaterali. Inserti ottagonali economici ON..06 con 16 taglienti e APMX di 4 mm, e inserti quadrati ad alta produttività SN.. 17 inserti con 8 taglienti e APMX di 7 mm. Disponibilità di corpi fresa con passo differenziato dei denti. Corpo trattato per una maggiore vita utensile.

KAPR	43°
APMX	4.0 (7.0) mm

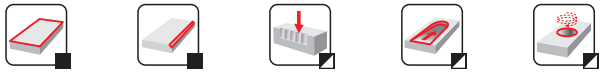








h_m 0.04 - 0.25



	Codice prodotto	DC (mm)	DCX (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
	50A04R-S45ON06-C	50	60.8	22	16.5	–	40	10.4	6.3	-10	-5	4	✓	9400	✓	0.42	GI342	C0621	–
	50A05R-S45ON06-C	50	60.8	22	16.5	–	40	10.4	6.3	-10	-5	5	–	9400	✓	0.39	GI342	C0621	–
	63A05R-S45ON06-C	63	73.8	22	18.1	–	40	10.4	6.3	-10	-5	5	✓	8400	✓	0.71	GI342	C0621	–
	63A06R-S45ON06-C	63	73.8	22	18.1	–	40	10.4	6.3	-10	-5	6	✓	8400	✓	0.55	GI342	C0621	–
	80A06R-S45ON06-C	80	90.8	27	22.1	–	50	12.4	7	-10	-5	6	✓	7500	✓	1.27	GI342	C0622	–
	80A08R-S45ON06-C	80	90.8	27	22.1	–	50	12.4	7	-10	-5	8	–	7500	✓	1.19	GI342	C0622	–
	100A08R-S45ON06-C	100	110.8	32	30.1	–	50	14.4	8	-10	-5	8	✓	6700	✓	1.88	GI342	C0620	AC002
	100A10R-S45ON06-C	100	110.8	32	30.1	–	50	14.4	8	-10	-5	10	–	6700	✓	1.81	GI342	C0620	AC002
ISO 6462 DIN 8030	**125A08R-S45ON06-C**	125	135.8	40	56.1	–	63	16.4	9	-10	-5	8	✓	6000	✓	3.80	GI342	C0620	AC003
	125A10R-S45ON06-C	125	135.8	40	56.1	–	63	16.4	9	-10	-5	10	✓	6000	✓	3.65	GI342	C0620	AC003
	125A12R-S45ON06-C	125	135.8	40	56.1	–	63	16.4	9	-11	-5	12	–	6000	✓	3.70	GI342	C0620	AC003
	160C08R-S45ON06-C	160	170.8	40	–	66.7	63	16.4	9.25	-10	-5	8	✓	5700	✓	6.48	GI342	C0623	–
	160C12R-S45ON06-C	160	170.8	40	–	66.7	63	16.4	9.25	-10	-5	12	✓	5700	✓	5.74	GI342	C0623	–
	160C14R-S45ON06-C	160	170.8	40	–	66.7	63	16.4	9.25	-11	-5	14	–	5700	✓	5.65	GI342	C0623	–
	200C12R-S45ON06-C	200	210.8	60	–	101.6	63	25.8	14.25	-10	-5	12	✓	4700	✓	9.06	GI342	C0624	–
	200C16R-S45ON06-C	200	210.8	60	–	101.6	63	25.8	14.25	-10	-5	16	–	4700	✓	9.02	GI342	C0624	–
	250C14R-S45ON06-C	250	260.8	60	–	101.6	63	25.8	14.25	-10	-5	14	✓	4300	✓	15.71	GI342	C0625	–
	250C18R-S45ON06-C	250	260.8	60	–	101.6	63	25.8	14.25	-10	-5	18	–	4300	✓	15.51	GI342	C0625	–

GI342	ONMX 0605..	ONMX 0605..-W..	SNMX 1705..

C0620	US 45013A-T20P	5.0 Nm	M 5	13	SDR T20P-T	–	–	–	–

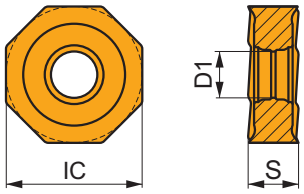
		Nm							
C0621	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1030C	–	–	–
C0622	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1230C	–	–	–
C0623	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5
C0624	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1655C	CAC 200C	HSD 1025C	HXK 7
C0625	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1655C	CAC 250C	HSD 1025C	HXK 7

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

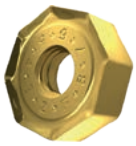
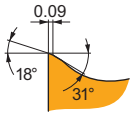
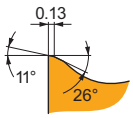
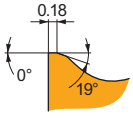
ONMX 06

PRAMET

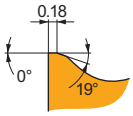
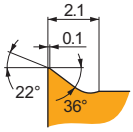
	IC (mm)	D1 (mm)	S (mm)
0605	17.000	5.70	7.08



Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
F la geometria positiva è utilizzata per la finitura, adatta per sbalzi elevati o per applicazioni caratterizzate da pareti e pezzi da lavorare sottili. Progettata con un angolo di taglio altamente positivo, T-land stretto e arrotondamento del tagliente per lavorazioni leggere.																			
ONMX 060508SR-F:8215	0.8	275	0.10	2.0	165	0.09	2.0	–	–	–	–	–	–	65	0.07	1.6	–	–	–
ONMX 060508SR-F:M6330	0.8	230	0.10	2.0	165	0.09	2.0	–	–	–	–	–	–	65	0.07	1.6	–	–	–
ONMX 060508SR-F:M8330	0.8	270	0.10	2.0	160	0.09	2.0	–	–	–	–	–	–	65	0.07	1.6	–	–	–
ONMX 060508SR-F:M8340	0.8	245	0.10	2.0	145	0.09	2.0	–	–	–	–	–	–	60	0.07	1.6	–	–	–
ONMX 060508SR-F:M9340	0.8	320	0.10	2.0	190	0.09	2.0	–	–	–	–	–	–	80	0.07	1.6	–	–	–
																			
M la geometria versatile rappresenta la prima scelta per una vasta gamma di condizioni di lavoro. Progettata con un angolo di taglio positivo, T-land medio e arrotondamento del tagliente per lavorazioni medie.																			
ONMX 060508SR-M:8215	0.8	230	0.20	2.0	135	0.18	2.0	–	–	–	–	–	–	55	0.14	1.6	45	0.14	1.0
ONMX 060508SR-M:M6330	0.8	195	0.20	2.0	140	0.18	2.0	–	–	–	–	–	–	55	0.14	1.6	–	–	–
ONMX 060508SR-M:M8330	0.8	230	0.20	2.0	135	0.18	2.0	–	–	–	–	–	–	55	0.14	1.6	45	0.14	1.0
ONMX 060508SR-M:M8340	0.8	210	0.20	2.0	125	0.18	2.0	–	–	–	–	–	–	50	0.14	1.6	–	–	–
ONMX 060508SR-M:M9325	0.8	285	0.20	2.0	–	–	–	–	–	–	–	–	–	–	–	–	55	0.14	1.0
ONMX 060508SR-M:M9340	0.8	255	0.20	2.0	150	0.18	2.0	–	–	–	–	–	–	60	0.14	1.6	–	–	–
																			
R la geometria robusta è utilizzata per la sgrossatura e condizioni di lavoro pesanti. Progettata con un angolo di taglio leggermente positivo, T-land ampio e arrotondamento del tagliente per lavorazioni di sgrossatura.																			
ONMX 060508SR-R:8215	0.8	210	0.30	2.0	–	–	–	195	0.30	2.0	–	–	–	–	–	–	40	0.21	1.0
ONMX 060508SR-R:M5315	0.8	255	0.30	2.0	–	–	–	240	0.30	2.0	–	–	–	–	–	–	50	0.21	1.0
ONMX 060508SR-R:M8330	0.8	210	0.30	2.0	–	–	–	195	0.30	2.0	–	–	–	–	–	–	40	0.21	1.0

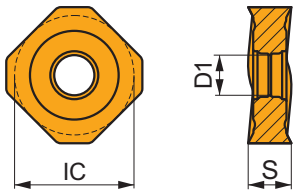
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
R la geometria robusta è utilizzata per la sgrossatura e condizioni di lavoro pesanti. Progettata con un angolo di taglio leggermente positivo, T-land ampio e arrotondamento del tagliente per lavorazioni di sgrossatura.																			
ONMX 060508SR-R:M8340	0.8	190	0.30	2.0	–	–	–	180	0.30	2.0	–	–	–	–	–	–	–	–	–
ONMX 060508SR-R:M9325	0.8	250	0.30	2.0	–	–	–	235	0.30	2.0	–	–	–	–	–	–	50	0.21	1.0
 																			
W design raschiante volto a garantire una migliore finitura superficiale durante la lavorazione con frese di grandi dimensioni e avanzamenti elevati.																			
ONMX 060508SR-W:8215	0.8	340	0.10	0.3	200	0.09	0.3	–	–	–	–	–	–	–	–	–	–	–	–
ONMX 060508SR-W:M8330	0.8	325	0.10	0.3	195	0.09	0.3	–	–	–	–	–	–	–	–	–	–	–	–

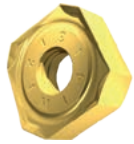
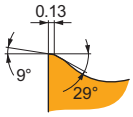
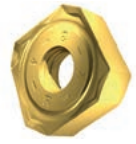
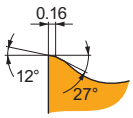
SNMX 17

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1705	17.000	5.70	5.56

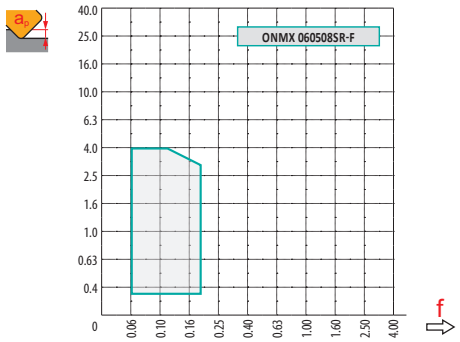


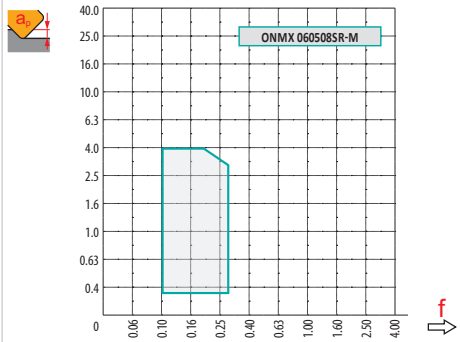
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

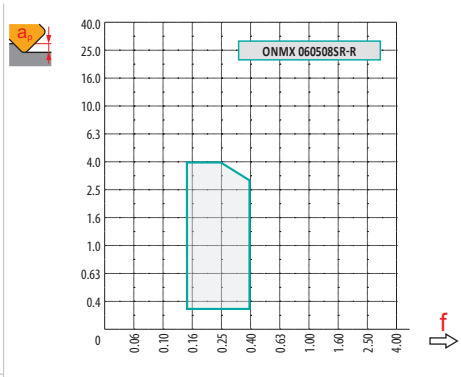
Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
M la geometria versatile rappresenta la prima scelta per una vasta gamma di condizioni di lavoro. Progettata con un angolo di taglio positivo, T-land medio e arrotondamento del tagliente per lavorazioni medie.																			
SNMX 170508SR-M:8215	0.8	265	0.20	4.0	155	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	50	0.14	1.0
SNMX 170508SR-M:M6330	0.8	225	0.20	4.0	160	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	–	–	–
SNMX 170508SR-M:M8330	0.8	265	0.20	4.0	155	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	50	0.14	1.0
SNMX 170508SR-M:M8340	0.8	240	0.20	4.0	140	0.18	4.0	–	–	–	–	–	–	60	0.14	3.2	–	–	–
SNMX 170508SR-M:M9325	0.8	325	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–	–	65	0.14	1.0
SNMX 170508SR-M:M9340	0.8	295	0.20	4.0	175	0.18	4.0	–	–	–	–	–	–	70	0.14	3.2	–	–	–
 																			
R la geometria robusta è utilizzata per la sgrossatura e condizioni di lavoro pesanti. Progettata con un angolo di taglio leggermente positivo, T-land ampio e arrotondamento del tagliente per lavorazioni di sgrossatura.																			
SNMX 170508SR-R:8215	0.8	240	0.30	4.0	–	–	–	225	0.30	4.0	–	–	–	–	–	–	45	0.21	1.0
SNMX 170508SR-R:M5315	0.8	300	0.30	4.0	–	–	–	285	0.30	4.0	–	–	–	–	–	–	60	0.21	1.0
SNMX 170508SR-R:M8330	0.8	240	0.30	4.0	–	–	–	225	0.30	4.0	–	–	–	–	–	–	45	0.21	1.0
SNMX 170508SR-R:M8340	0.8	220	0.30	4.0	–	–	–	205	0.30	4.0	–	–	–	–	–	–	–	–	–
SNMX 170508SR-R:M9325	0.8	290	0.30	4.0	–	–	–	275	0.30	4.0	–	–	–	–	–	–	55	0.21	1.0

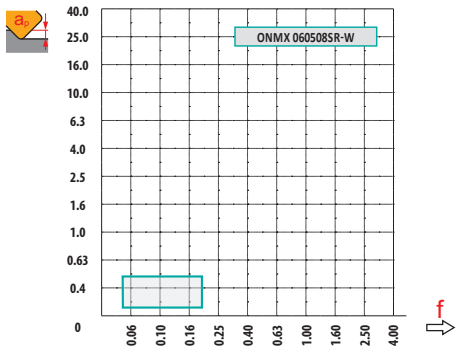
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

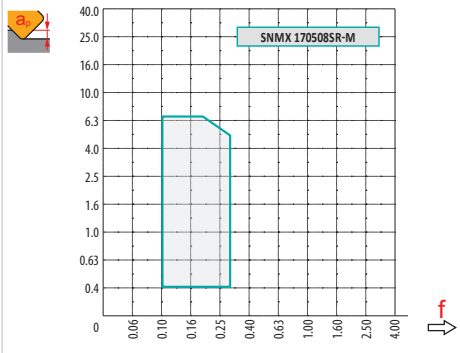
	ONMX 06-F	ONMX 06-M	ONMX 06-R	ONMX 06-W	SNMX 17-M	SNMX 17-R
RE	0.80	0.80	0.80	0.80	0.80	0.80
BS	0.75	0.75	0.75	4.30	0.70	0.70

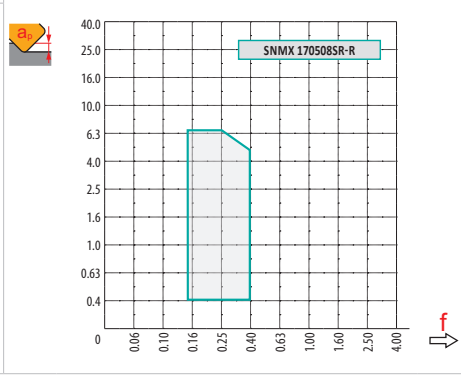










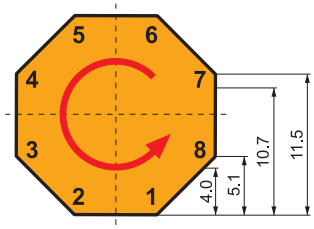


DC / a_p	0.50	1.00	1.50	2.00	2.50	3.00	3.50	4.00
50	51.06	52.11	53.19	54.27	55.35	56.43	57.51	58.59
63	64.06	65.11	66.19	67.27	68.35	69.43	70.51	71.59
80	81.06	82.11	83.19	84.27	85.35	86.43	87.51	88.59
100	101.06	102.11	103.19	104.27	105.35	106.43	107.51	108.59
125	126.06	127.11	128.19	129.27	130.35	131.43	132.51	133.59
160	161.06	162.11	163.19	164.27	165.35	166.43	167.51	168.59
200	201.06	202.11	203.19	204.27	205.35	206.43	207.51	208.59
250	251.06	252.11	253.19	254.27	255.35	256.43	257.51	258.59

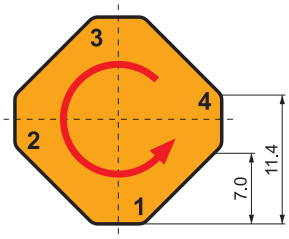
DC	a_p	0.00	1.00	2.00	3.00	4.00	5.00	6.00	7.00
		S							
50	DEF	47.24	49.40	51.56	53.73	55.90	58.06	60.23	62.40
63		60.24	62.40	64.56	66.73	68.90	71.06	73.23	75.40
80		77.24	79.40	81.56	83.73	85.90	88.06	90.23	92.40
100		97.24	99.40	101.56	103.73	105.90	108.06	110.23	112.40
125		122.24	124.40	126.56	128.73	130.90	133.06	135.23	137.40
160		157.24	159.40	161.56	163.73	165.90	168.06	170.23	172.40
200		197.24	199.40	201.56	203.73	205.90	208.06	210.23	212.40
250		247.24	249.40	251.56	253.73	255.90	258.06	260.23	262.40

DC	X.V	f_{max}
50	1.35	0.36
63	1.39	0.40
80	1.44	0.45
100	1.48	0.51
125	1.53	0.57
160	1.58	0.64
200	1.63	0.72
250	1.68	0.80

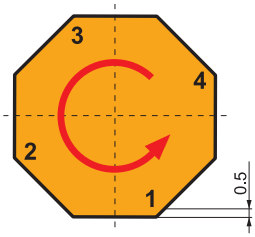
	O		S		
DC	RPMX	APMX/I	DC	RPMX	APMX/I
50	0.3	0.4/100	47.24	0.1	0.1/100
63	0.2	0.25/100	60.24	0.1	0.05/100
80	0.2	0.2/100	77.24	0.1	0.05/100
100	0.1	0.1/100			
125	0.1	0.05/100			



a_p	
-> 4.0	16
-> 5.1	14
-> 10.7	8
-> 11.5	6



a_p	
-> 7.0	8
-> 11.4	4



ONMX 06-W	
a_p	
-> 0.5	8

SHN06C

P M K H

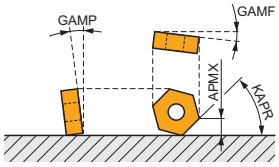
PRAMET

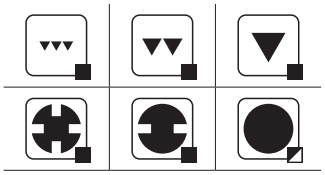
S

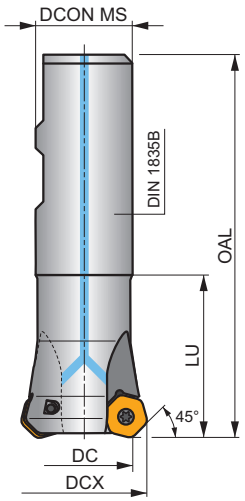
ECON HN06 fresa per spianatura a 45° con geometria doppio negativa e refrigerante interno

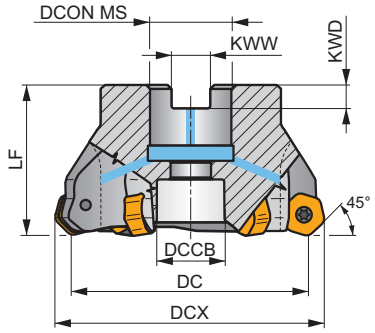
Fresa a spianare a 45° ad elevata produttività che utilizza inserti bilaterali tipo HN .. 06 con APMX di 3 mm. Sgrossatura, finitura e smussatura. Inserto economico con 12 taglienti. Passo differenziato dei taglienti. Attacco weldon ed a manicotto. Corpo trattato per una maggiore durata dell'utensile.

KAPR	45°
APMX	3.0 mm









h_m	0.06 - 0.15
h_m	0.06 - 0.15

	Codice prodotto	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	25N2R042B25-SHN06C-C	25	32.2	99	25	–	42	–	–	–	-7	-7	2	–	17400	✓	0.35	GI204	FA010	–
	32N3R042B32-SHN06C-C	32	39.3	103	32	–	42	–	–	–	-7	-7	3	–	15400	✓	0.59	GI204	FA010	–
	40A05R-S45HN06C-C	40	47.3	–	16	14	–	40	8.4	5.6	-7	-7	5	✓	13800	✓	0.37	GI204	FA012	–
	50A04R-S45HN06C-C	50	57.3	–	22	18	–	40	10.4	6.3	-7	-7	4	✓	12300	✓	0.54	GI204	FA013	–
	50A06R-S45HN06C-C	50	57.3	–	22	18	–	40	10.4	6.3	-7	-7	6	✓	12300	✓	0.41	GI204	FA013	–
	63A06R-S45HN06C-C	63	70.3	–	22	18	–	40	10.4	6.3	-7	-7	6	✓	11000	✓	0.68	GI204	FA013	–
ISO 6462 DIN 8030	63A08R-S45HN06C-C	63	70.3	–	22	18	–	40	10.4	6.3	-7	-7	8	✓	11000	✓	0.68	GI204	FA013	–
	80A07R-S45HN06C-C	80	86.8	–	27	38	–	50	12.4	7	-7	-7	7	✓	9700	✓	1.10	GI204	FA011	AC001
	80A10R-S45HN06C-C	80	86.8	–	27	38	–	50	12.4	7	-7	-7	10	✓	9700	✓	1.10	GI204	FA011	AC001
	100A08R-S45HN06C-C	100	107.1	–	32	45	–	50	14.4	8	-7	-7	8	✓	8700	✓	2.00	GI204	FA011	AC002
	100A12R-S45HN06C-C	100	107.1	–	32	45	–	50	14.4	8	-7	-7	12	✓	8700	✓	1.82	GI204	FA011	AC002
	125A10R-S45HN06C-C	125	132.2	–	40	56	–	63	16.4	9	-7	-7	10	✓	7800	✓	3.53	GI204	FA011	AC003

GI204	HNGX 0604AN..	XNGX 0604AN..

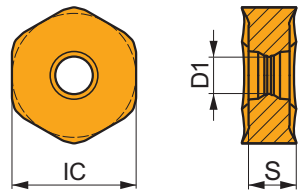
		Nm						
FA010	US 3007-T09P	2.0	M 3	7.3	–	–	Flag T09P	–
FA011	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	–
FA012	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 0830C
FA013	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 1030C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

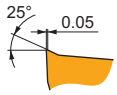
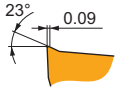
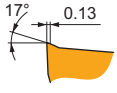
HNGX 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0604	10.500	3.70	4.76

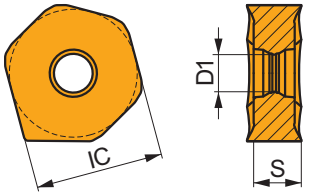


Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

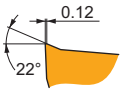
Codice prodotto		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F geometria con design altamente positivo per lavorazioni leggere.																				
HNGX 0604ANSN-F:8215		–	315	0.11	1.7	185	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M6330		–	265	0.11	1.7	185	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M8330		–	305	0.11	1.7	180	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M8340		–	285	0.11	1.7	170	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M9340		–	365	0.11	1.7	215	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
M geometria con design altamente positivo per lavorazioni medie.																				
HNGX 0604ANSN-M:8215		–	300	0.13	2.0	180	0.13	2.0	285	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M5315		–	425	0.13	2.0	–	–	–	400	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M6330		–	255	0.13	2.0	180	0.13	2.0	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M8310		–	325	0.13	2.0	165	0.13	2.0	305	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M8330		–	295	0.13	2.0	175	0.13	2.0	280	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M8340		–	265	0.13	2.0	155	0.13	2.0	250	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M9315		–	410	0.13	2.0	–	–	–	385	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M9325		–	375	0.13	2.0	–	–	–	355	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M9340		–	345	0.13	2.0	205	0.13	2.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
R geometria con design altamente positivo per lavorazioni da medie a pesanti.																				
HNGX 0604ANSN-R:8215		–	280	0.18	1.8	165	0.18	1.8	265	0.18	1.8	–	–	–	–	–	–	55	0.12	1.0
HNGX 0604ANSN-R:M5315		–	370	0.18	1.8	–	–	–	350	0.18	1.8	–	–	–	–	–	–	70	0.12	1.0
HNGX 0604ANSN-R:M8310		–	300	0.18	1.8	150	0.18	1.8	285	0.18	1.8	–	–	–	–	–	–	60	0.12	1.0
HNGX 0604ANSN-R:M8330		–	275	0.18	1.8	165	0.18	1.8	260	0.18	1.8	–	–	–	–	–	–	55	0.12	1.0
HNGX 0604ANSN-R:M8340		–	250	0.18	1.8	150	0.18	1.8	235	0.18	1.8	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-R:M9325		–	345	0.18	1.8	–	–	–	325	0.18	1.8	–	–	–	–	–	–	65	0.12	1.0

XNGX 06

	IC	D1	S
	(mm)	(mm)	(mm)
0604	10.500	3.70	4.76

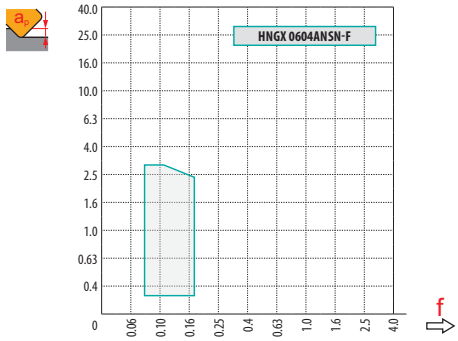


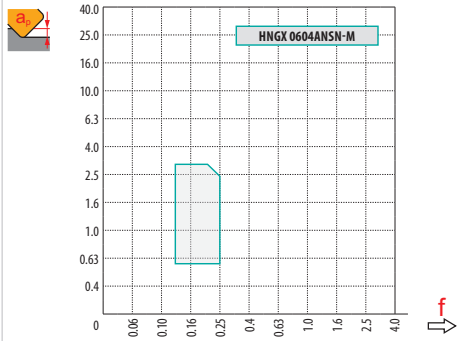
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

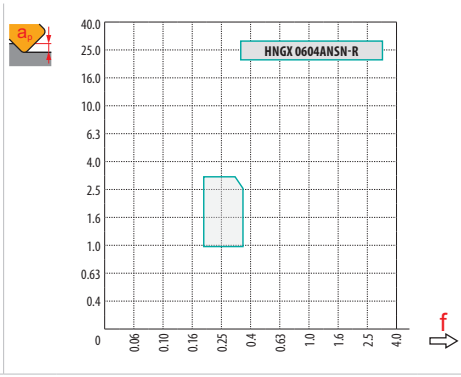
Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
   **W** design Wiper per una migliore finitura superficiale.																			
XNGX 0604ANSN:8215	–	290	0.13	1.8	170	0.12	1.8	275	0.13	1.8	–	–	–	–	–	–	–	–	–

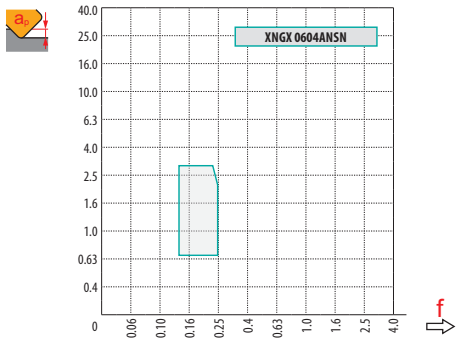
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	HNGX 06-F	HNGX 06-M	HNGX 06-R	XNGX 06
RE	–	–	–	–
BS	1.12	0.80	0.80	4.15









DC	X.V	f_{max}
25	1.31	0.24
32	1.36	0.28
40	1.40	0.31
50	1.45	0.35
63	1.49	0.39
80	1.54	0.44
100	1.59	0.49
125	1.64	0.55

DC	RPMX	APMX/I
25	2.7°	3.0/65
32	1.9°	3.0/89
40	1.5°	2.5/100
50	1.1°	1.9/100
63	0.9°	1.4/100
80	0.6°	1.0/100
100	0.5°	0.8/100
125	0.4°	0.6/100

a_p
0.9

SHN09C

P M K H

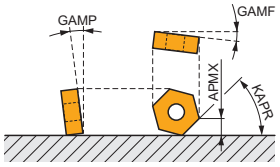
PRAMET

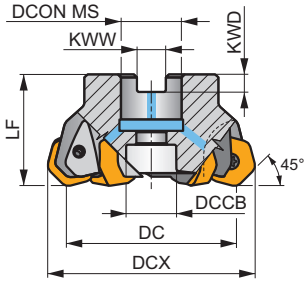
S

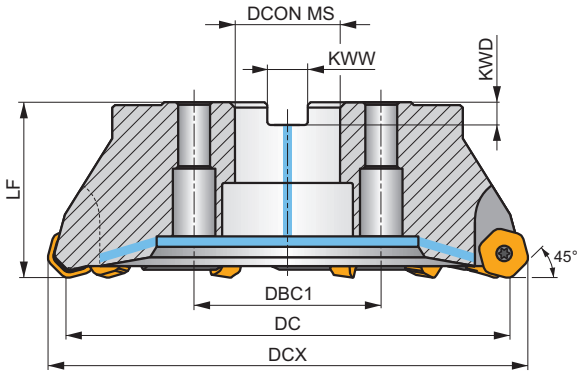
ECON HN09 fresa per spianatura a 45° con geometria doppio negativa e refrigerante interno

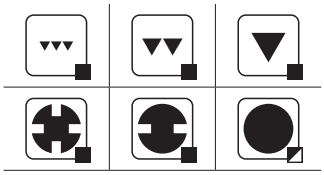
Fresa a spianare a 45° ad elevata produttività che utilizza inserti bilaterali tipo HN .. 09 con APMX di 5 mm. Sgrossatura, finitura e smussatura. Inserto economico con 12 taglienti. Passo differenziato dei taglienti. Attacco a manicotto. Corpo trattato per una maggiore durata dell'utensile.

KAPR	45°
APMX	5.0 mm









h_m 0.08 - 0.25

	Codice prodotto	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	50A04R-S45HN09C-CF	50	61.7	40	22	18	–	10.4	6.3	-7	-7	4	✓	7900	✓	0.38	GI252	FA023	–
	63A06R-S45HN09C-CF	63	74.7	40	22	18	–	10.4	6.3	-7	-7	6	✓	7000	✓	0.54	GI252	FA023	–
	80A06R-S45HN09C-CF	80	91.7	50	27	38	–	12.4	7	-7	-7	6	✓	6200	✓	1.06	GI252	FA021	AC001
	80A08R-S45HN09C-CF	80	91.7	50	27	38	–	12.4	7	-7	-7	8	✓	6200	✓	1.06	GI252	FA021	AC001
	100A06R-S45HN09C-CF	100	111.7	50	32	45	–	14.4	8	-7	-7	6	✓	5600	✓	1.95	GI252	FA021	AC002
	100A08R-S45HN09C-CF	100	111.7	50	32	45	–	14.4	8	-7	-7	8	✓	5600	✓	1.99	GI252	FA021	AC002
	100A10R-S45HN09C-CF	100	111.7	50	32	45	–	14.4	8	-8	-7	10	–	5600	✓	1.99	GI252	FA021	AC002
	125A06R-S45HN09C-CF	125	136.7	63	40	56	–	16.4	9	-7	-7	6	✓	5000	✓	3.36	GI252	FA021	AC003
	125A08R-S45HN09C-CF	125	136.7	63	40	56	–	16.4	9	-7	-7	8	✓	4900	✓	3.66	GI252	FA021	AC003
	125A10R-S45HN09C-CF	125	136.7	63	40	56	–	16.4	9	-7	-7	10	✓	5000	✓	3.52	GI252	FA021	AC003
	125A12R-S45HN09C-CF	125	136.7	63	40	56	–	16.4	9	-8	-7	12	–	5000	✓	3.36	GI252	FA021	AC003
	160C08R-S45HN09C-CF	160	171.7	63	40	–	66.7	16.4	9	-7	-7	8	✓	4400	✓	6.24	GI252	FA026	–
	160C12R-S45HN09C-CF	160	171.7	63	40	–	66.7	16.4	9	-7	-7	12	✓	4400	✓	6.45	GI252	FA026	–
	160C14R-S45HN09C-CF	160	171.7	63	40	–	66.7	16.4	9	-7	-7	14	✓	4400	✓	6.39	GI252	FA026	–
	200C10R-S45HN09C-CF	200	211.7	63	60	–	101.6	25.7	14	-7	-7	10	✓	3900	✓	11.37	GI252	FA027	–
	250C14R-S45HN09C-CF	250	261.7	63	60	–	101.6	25.7	14	-7	-7	14	✓	3500	✓	18.50	GI252	FA028	–
	315C16R-S45HN09C-CF	315	326.7	80	60	–	101.6	25.7	14	-7	-7	16	✓	3100	✓	37.00	GI252	FA029	–

GI252	HNGX 0906AN..	XNGX 0906AN..

		Nm											
FA021	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	–	–	–	–	–	–
FA023	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1030C	–	–	–	–	–

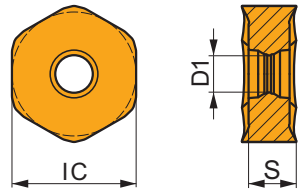
FA026	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1240C	CAC 160C	HSD 0825C	HXK 5	–	–
FA027	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 200C	HSD 1025C	HXK 7	–	–
FA028	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 250C	HSD 1025C	HXK 7	–	–
FA029	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 315C	HSD 1035C	HXK 7	CACP 3150C	RRH 34

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

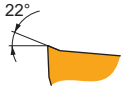
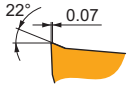
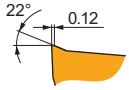
HNGX 09

PRAMET

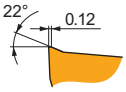
	IC (mm)	D1 (mm)	S (mm)
0906	16.500	4.90	6.35



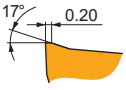
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			**FF** geometria con design altamente positivo per lavorazioni leggere.																	
HNGX 0906ANEN-FF:8215	●	–	345	0.10	1.0	205	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANEN-FF:M8330	●	–	335	0.10	1.0	200	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANEN-FF:M9340	●	–	405	0.10	1.0	240	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
			**F** geometria con design altamente positivo per lavorazioni da leggere a medie.																	
HNGX 0906ANSN-F:8215	✱	–	300	0.12	2.1	180	0.11	2.1	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-F:M6330	✱	–	255	0.12	2.1	180	0.11	2.1	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-F:M8310	✱	–	330	0.12	2.1	165	0.11	2.1	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-F:M8330	✱	–	300	0.12	2.1	180	0.11	2.1	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-F:M8340	✱	–	270	0.12	2.1	160	0.11	2.1	–	–	–	–	–	–	–	–	–	–	–	–
			**M** geometria con design altamente positivo per lavorazioni medie.																	
HNGX 0906ANSN-M:8215	✱	–	255	0.20	2.7	150	0.18	2.7	240	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M5315	✱	–	340	0.20	2.7	–	–	–	320	0.20	2.7	–	–	–	–	–	–	–	–	–

Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
HNGX 0906ANSN-M:M6330	–	220	0.20	2.7	155	0.18	2.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M8310	–	280	0.20	2.7	140	0.18	2.7	265	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M8330	–	255	0.20	2.7	150	0.18	2.7	240	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M8340	–	235	0.20	2.7	140	0.18	2.7	220	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M9315	–	340	0.20	2.7	–	–	–	320	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M9325	–	315	0.20	2.7	–	–	–	295	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M9340	–	290	0.20	2.7	170	0.18	2.7	–	–	–	–	–	–	–	–	–	–	–	–

M geometria con design altamente positivo per lavorazioni medie.

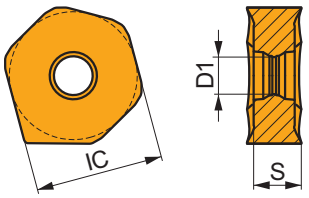
 																			
HNGX 0906ANSN-R:8215	–	240	0.25	3.0	140	0.25	3.0	225	0.25	3.0	–	–	–	–	–	–	45	0.13	1.0
HNGX 0906ANSN-R:M5315	–	305	0.25	3.0	–	–	–	285	0.25	3.0	–	–	–	–	–	–	60	0.13	1.0
HNGX 0906ANSN-R:M8310	–	260	0.25	3.0	130	0.25	3.0	245	0.25	3.0	–	–	–	–	–	–	50	0.13	1.0
HNGX 0906ANSN-R:M8330	–	240	0.25	3.0	140	0.25	3.0	225	0.25	3.0	–	–	–	–	–	–	45	0.13	1.0
HNGX 0906ANSN-R:M8340	–	220	0.25	3.0	130	0.25	3.0	205	0.25	3.0	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-R:M9315	–	310	0.25	3.0	–	–	–	290	0.25	3.0	–	–	–	–	–	–	60	0.13	1.0
HNGX 0906ANSN-R:M9325	–	295	0.25	3.0	–	–	–	280	0.25	3.0	–	–	–	–	–	–	55	0.13	1.0

R geometria con design positivo per lavorazioni da medie a pesanti.

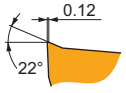
XNGX 09

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0906	16.500	4.90	6.35



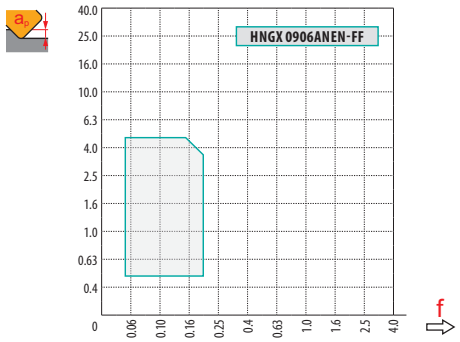
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

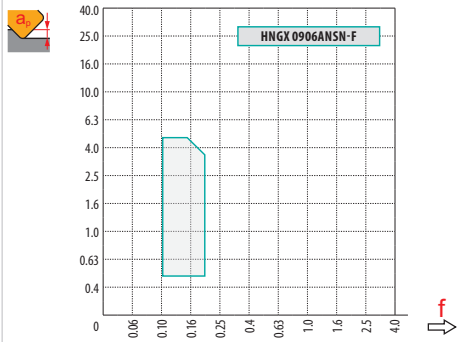
Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
XNGX 0906ANSN:8215	–	245	0.20	2.7	145	0.18	2.7	230	0.20	2.7	–	–	–	–	–	–	–	–	–
XNGX 0906ANSN:M8330	–	245	0.20	2.7	145	0.18	2.7	230	0.20	2.7	–	–	–	–	–	–	–	–	–

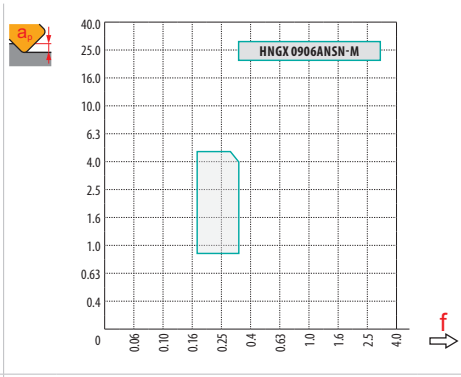
W design Wiper per una migliore finitura superficiale.

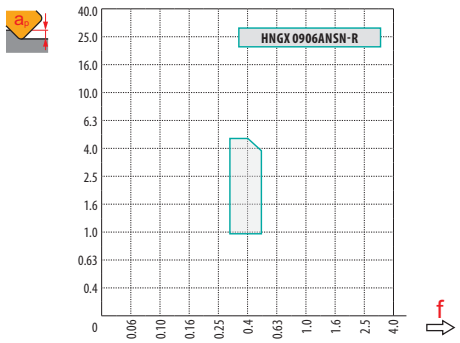
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

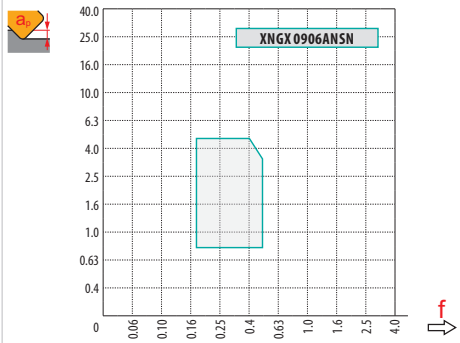
	HNGX 09-FF	HNGX 09-F	HNGX 09-M	HNGX 09-R	XNGX 09
RE	–	–	–	–	–
BS	1.50	1.17	1.17	1.17	7.53











DC	X.V	f_{max}
50	1.35	0.36
63	1.39	0.40
80	1.44	0.45
100	1.48	0.51
125	1.53	0.57
160	1.58	0.64
200	1.63	0.72
250	1.68	0.80
315	1.74	0.90

DC	RPMX	APMX/I
50	2.1°	3.5/100
63	1.5°	2.5/100
80	1.1°	1.8/100
100	0.9°	1.4/100
125	0.7°	1.1/100
160	0.5°	0.7/100

a_p
1.9

SPN13

P M K S H

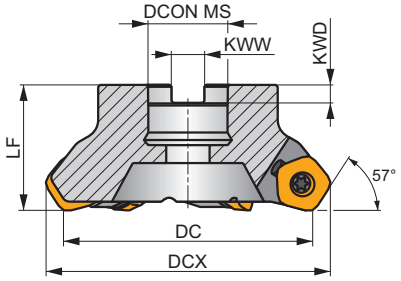
PRAMET

S

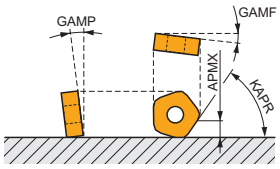
PENTA HD fresa per spianatura a 57° con geometria doppio negativa per fresatura pesante

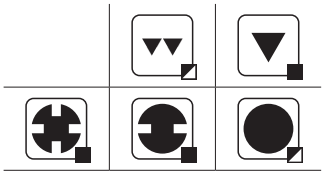
Fresa a spianare a 57° ad elevata produttività che utilizza inserti negativi bilaterali PN .. 13 e XN .. 13 con APMX di 10 mm. Adatta per spianatura pesante. Attacco a manicotto. Sede dell'inserto protetta da sottoplacchetta. Corpo trattato per una maggiore durata dell'utensile.

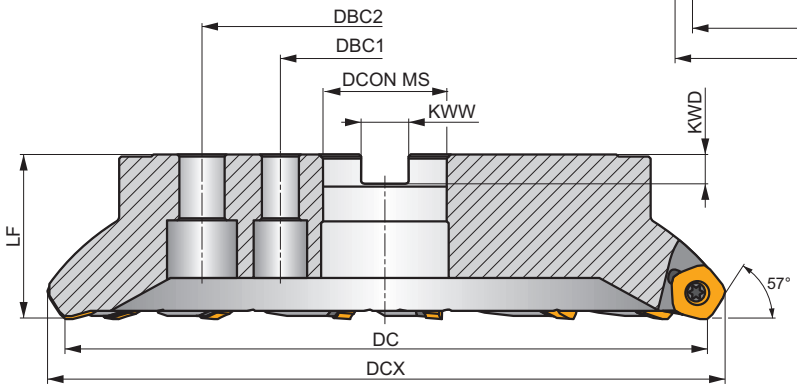
PENTA HD



KAPR	57°
APMX	10.0 mm







h_m 0.20 - 0.50

	Codice prodotto	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DBC1 (mm)	DBC2 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**100A05R-S57PN13**	100	115.8	50	32	–	–	14.4	8	-8.2	-4	5	–	3400	–	1.22	GI261	FA081	AC002
	125A06R-S57PN13	125	140.8	63	40	–	–	16.4	9	-7	-4	6	–	3100	–	2.79	GI261	FA081	AC003
	160C08R-S57PN13	160	175.8	63	40	66.7	–	16.4	9	-6	-4	8	–	2700	–	3.58	GI261	FA081	–
	200C10R-S57PN13	200	215.8	63	60	101.6	–	25.7	14	-5	-4	10	–	2400	–	9.17	GI261	FA081	–
	250C12R-S57PN13	250	265.8	63	60	101.6	–	25.7	14	-5	-4	12	–	2200	–	15.39	GI261	FA081	–
	315C14R-S57PN13	315	330.8	80	60	101.6	177.8	25.7	14	-5	-4	14	–	1900	–	29.17	GI261	FA081	–

GI261	PNMU 1308DN..	XNGX 1308DNSN	PNMQ 1308DN..

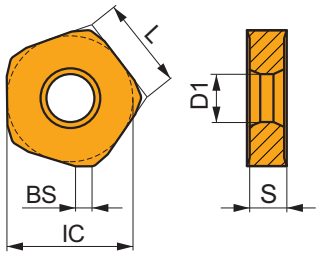
FA081	SPN 13T3DN	US 64010-T15P	SDR T15P	US 68026-T30P	15.0 Nm	M 8	26	SDR T30P-T

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

PNMU 13

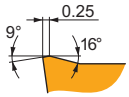
PRAMET

	BS	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1308	3.00	24.400	10.00	13.00	7.94



Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
PNMU 1308DNSR-M:8215		–	165	0.35	6.5	95	0.32	6.5	155	0.35	6.5	–	–	–	40	0.28	5.2	30	0.18	2.0
PNMU 1308DNSR-M:M8330		–	190	0.35	6.5	110	0.32	6.5	180	0.35	6.5	–	–	–	45	0.28	5.2	35	0.18	2.0
PNMU 1308DNSR-M:M8345		–	135	0.35	6.5	80	0.32	6.5	–	–	–	–	–	–	30	0.28	5.2	–	–	–
PNMU 1308DNSR-M:M9315		–	210	0.35	6.5	–	–	–	195	0.35	6.5	–	–	–	–	–	–	40	0.18	2.0
PNMU 1308DNSR-M:M9340		–	170	0.35	6.5	100	0.32	6.5	–	–	–	–	–	–	40	0.28	5.2	–	–	–

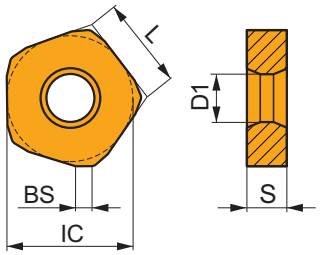


M geometria con design positivo per lavorazioni di sgrossatura.

PNMQ 13

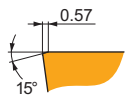
PRAMET

	BS	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1308	3.00	24.400	10.00	13.00	7.94



Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

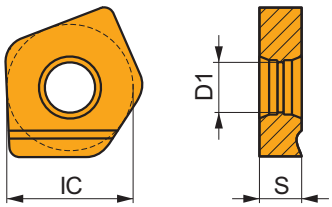
Codice prodotto		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
PNMQ 1308DNSN:M8330		–	165	0.60	6.5	–	–	–	155	0.60	6.5	–	–	–	–	–	–	30	0.30	2.0
PNMQ 1308DNSN:M8345		–	120	0.60	6.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



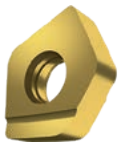
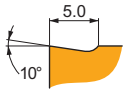
SN design con angolo di spoglia superiore del tagliente a zero gradi adatto per lavorazioni di sgrossatura.

XNGX 13

	IC	D1	S
	(mm)	(mm)	(mm)
1308	24.180	10.00	7.94

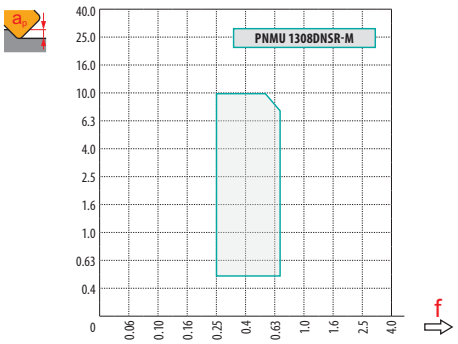


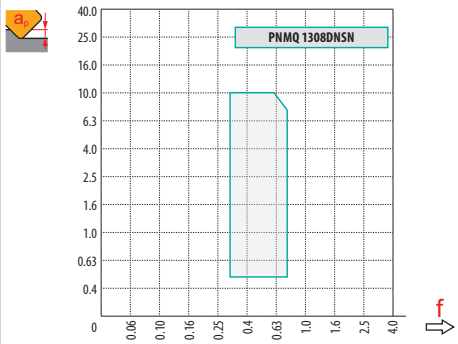
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

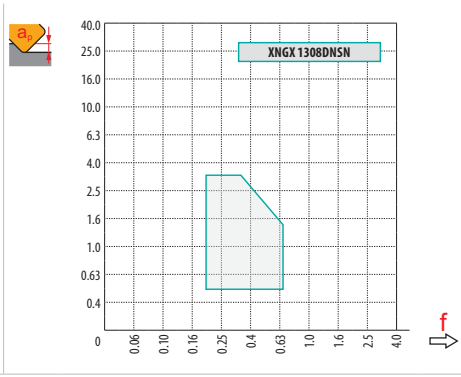
Codice prodotto		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**W** design Wiper per una migliore finitura superficiale.																	
XNGX 1308DNSN:M8330		–	245	0.45	2.5	–	–	–	230	0.45	2.5	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	PNMU 13-M	PNMQ 13	XNGX 13
RE	–	–	–
BS	3.00	3.00	12.71







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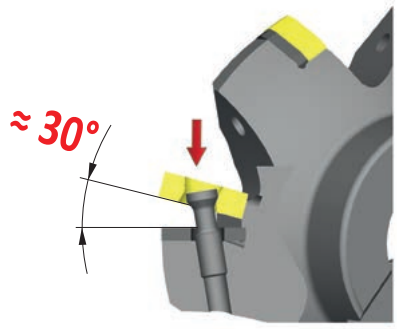

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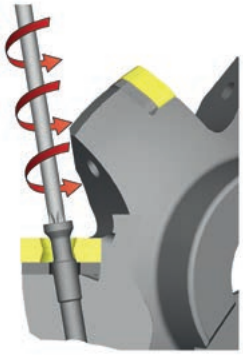
3



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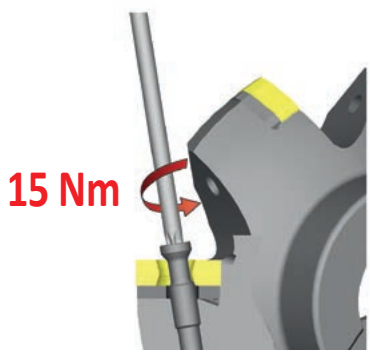


SPIANATURA

	SSD13F	SSE09	SSN12Z	FSB22X		
	45°	45°	45°	60°		
	APMX (mm) 6.4	APMX (mm) 4.5	APMX (mm) 6.5	APMX (mm) 15.0		
	DC (mm) 32 – 250	DC (mm) 20 – 160	DC (mm) 63 – 125	DC (mm) 125 – 250		
Codolo cilindrico						
Weldon	 DC = 32, 40 (mm)	 DC = 20 – 32 (mm)				
Modulare						
Fresa a manicotto	 DC = 40 – 250 (mm)	 DC = 32 – 160 (mm)				
Pagina	26	31	35	38		
ISO	P M K N S H	P M K S	P M K S	P M K		
Forma dell'inserto						
Inserti	SDET 13T3 SDMT 13T3 XDET 13T3	SE.T 09T3	SN.T 1205	SB.. 2207		
N. di taglienti	4 / 4 / 1	4	4	4 / 1		
Spianatura	■	■	■	■		
Smussatura	■	■	■			
Interpolazione elicoidale	◪					
Fresatura a tuffo progressiva	◪					
Rampa	◪					

■ Uso primario ◪ Uso possibile

SSD13F

P M K N S H

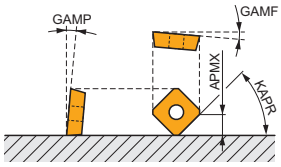
PRAMET

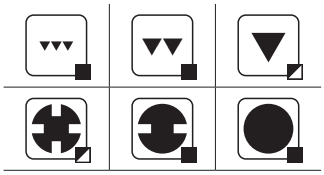
S

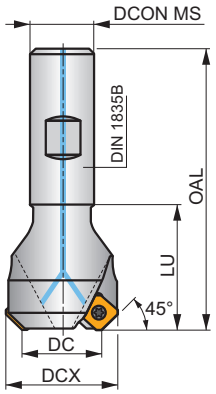
VER SD13 Fresa per operazioni di spianatura a 45°con geometria positiva e passaggio refrigerante interno

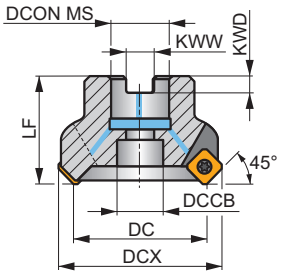
Fresa per operazioni di spianatura a 45° altamente versatile, che prevede l'utilizzo inserti di tipo SD.. 13 inserti con APMX di 6.4 mm. Adatta per una vasta gamma di applicazioni in pezzi da lavorare di qualunque materiale. Disponibilità di corpi fresa con attacchi weldon e a manicotto, con passo differenziato dei denti. Corpo trattato per una maggiore vita utensile, supporti in metallo duro sulla sede inserto per una sicurezza del processo ottimale.

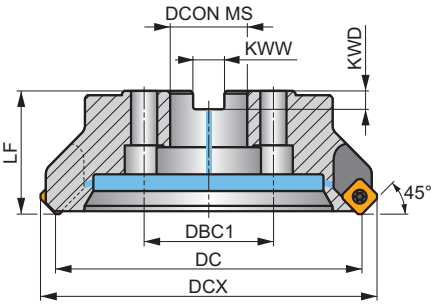
KAPR	45°
APMX	6.4 mm











h_m	0.04 - 0.28
h_m	0.04 - 0.32

	Codice prodotto	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	32N3R045B25-SSD13F-C	32	44.9	120	25	–	–	45	–	–	–	-15	15	3	–	16100	✓	0.43	GI341	C0610	–
DIN 1835B	40N3R045B32-SSD13F-C	40	53.5	120	32	–	–	45	–	–	–	-7	15	3	–	14400	✓	0.72	GI341	C0610	–
	40A03R-S45SD13F-C	40	53.5	–	16	14	–	–	40	8.4	5.6	-7	15	3	–	14400	✓	0.27	GI341	C0611	–
	50A04R-S45SD13F-C	50	63.5	–	22	18	–	–	40	10.4	6.3	-7	15	4	✓	12900	✓	0.51	GI341	C0612	–
	63A05R-S45SD13F-C	63	76.4	–	22	18	–	–	40	10.4	6.3	-7	15	5	✓	11500	✓	0.53	GI341	C0612	–
	80A07R-S45SD13F-C	80	93.4	–	27	22	–	–	50	12.4	7	-7	15	7	✓	10200	✓	1.21	GI341	C0613	AC001
	100A08R-S45SD13F-C	100	112.9	–	32	45	–	–	50	14.4	8	-12	15	8	✓	9100	✓	1.83	GI341	C0613	AC002
	100A10R-S45SD13F-C	100	112.9	–	32	45	–	–	50	14.4	8	-12	15	10	–	9100	✓	1.94	GI341	C0613	AC002
ISO 6462 DIN 8030	125A08R-S45SD13F-C	125	137.8	–	40	56	–	–	63	16.4	9	-12	15	8	✓	8100	✓	3.41	GI341	C0613	AC003
ISO 6462 DIN 8030	125A12R-S45SD13F-C	125	137.8	–	40	56	–	–	63	16.4	9	-12	15	12	–	8100	✓	3.31	GI341	C0613	AC003
	160C10R-S45SD13F-C	160	172.8	–	40	–	66.7	–	63	16.4	9	-12	15	10	✓	7200	✓	6.68	GI341	C0614	–
	160C14R-S45SD13F-C	160	172.8	–	40	–	66.7	–	63	16.4	9	-12	15	14	✓	7200	✓	6.62	GI341	C0614	–
	200C12R-S45SD13F-C	200	212.8	–	60	–	101.6	–	63	25.7	14	-12	15	12	✓	6400	✓	9.06	GI341	C0615	–
	200C16R-S45SD13F-C	200	212.8	–	60	–	101.6	–	63	25.7	14	-12	15	16	✓	6400	✓	11.85	GI341	C0615	–
	250C14R-S45SD13F-C	250	262.8	–	60	–	101.6	–	63	25.7	14	-12	15	14	✓	5700	✓	19.50	GI341	C0616	–
	250C20R-S45SD13F-C	250	262.8	–	60	–	101.6	–	63	25.7	14	-12	15	20	✓	5700	✓	19.20	GI341	C0616	–

GI341	SDET 13T3..	SDMT 13T3..	XDET 13T3..

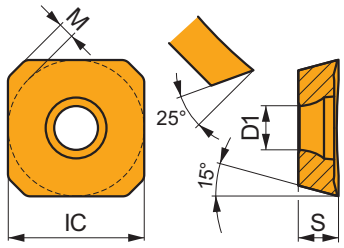
		Nm												
C0610	US 63513-T15P	3.0	M 3.5	13	Flag T15P	–	–	–	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0611	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 0830C	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0612	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HSD 1025C	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0613	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	–	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0614	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1240C	SDW 1103AF	MS 3507	HXK 3.5	CAC 160C	HSD 0825C	HXK 5
C0615	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1655C	SDW 1103AF	MS 3507	HXK 3.5	CAC 200C	HSD 1025C	HXK 7
C0616	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1655C	SDW 1103AF	MS 3507	HXK 3.5	CAC 250C	HSD 1025C	HXK 7

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

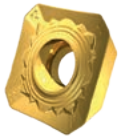
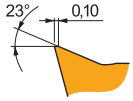
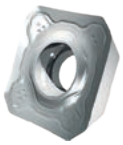
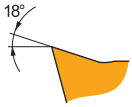
SDET 13

PRAMET

	IC (mm)	D1 (mm)	M (mm)	S (mm)
13T3	13.385	4.40	1.5	3.97

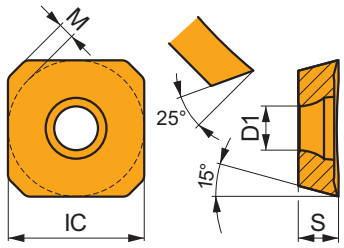


Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

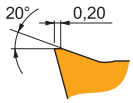
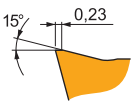
Codice prodotto		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F la geometria positiva è utilizzata per la finitura, adatta per sbalzi elevati o per applicazioni caratterizzate da pareti e pezzi da lavorare sottili. Progettata con un angolo di taglio altamente positivo, T-land stretto e arrotondamento del tagliente per lavorazioni leggere.																				
SDET 13T3AFSN-F:M6330		–	250	0.15	3.0	175	0.14	3.0	–	–	–	–	–	–	70	0.11	2.4	–	–	–
SDET 13T3AFSN-F:M8310		–	315	0.15	3.0	160	0.14	3.0	295	0.15	3.0	–	–	–	–	–	–	–	–	–
SDET 13T3AFSN-F:M8330		–	285	0.15	3.0	170	0.14	3.0	270	0.15	3.0	855	0.18	3.0	70	0.11	2.4	–	–	–
SDET 13T3AFSN-F:M8340		–	265	0.15	3.0	155	0.14	3.0	250	0.15	3.0	–	–	–	65	0.11	2.4	–	–	–
SDET 13T3AFSN-F:M9340		–	330	0.15	3.0	195	0.14	3.0	–	–	–	–	–	–	80	0.11	2.4	–	–	–
																				
FA la geometria è affilata e utilizzata per la lavorazione di leghe non ferrose, adatta per sbalzi elevati o per applicazioni caratterizzate da pareti e pezzi da lavorare sottili. Design lappatura superficiale con angolo di taglio altamente positivo.																				
SDET 13T3AFFN-FA:HF7		–	–	–	–	–	–	–	–	–	–	360	0.12	3.0	–	–	–	–	–	–
SDET 13T3AFFN-FA:M0315		–	–	–	–	–	–	–	–	–	–	840	0.12	3.0	–	–	–	–	–	–

SDMT 13

	IC (mm)	D1 (mm)	M (mm)	S (mm)
13T3	13.385	4.40	1.5	3.97

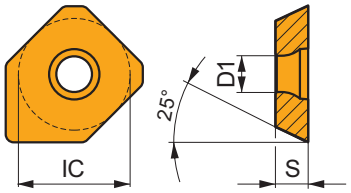


Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
	 																			
M la geometria versatile rappresenta la prima scelta per una vasta gamma di condizioni di lavoro. Progettata con un angolo di taglio positivo, T-land medio e arrotondamento del tagliente per lavorazioni medie.																				
SDMT 13T3AFSN-M:8215		–	■ 245	0.30	3.0	◪ 145	0.27	3.0	■ 230	0.30	3.0	–	–	–	◪ 60	0.24	2.4	■ 45	0.21	1.0
SDMT 13T3AFSN-M:M6330		–	■ 215	0.30	3.0	■ 150	0.27	3.0	–	–	–	–	–	–	■ 60	0.24	2.4	–	–	–
SDMT 13T3AFSN-M:M8330		–	■ 245	0.30	3.0	■ 145	0.27	3.0	■ 230	0.30	3.0	–	–	–	◪ 60	0.24	2.4	◪ 45	0.21	1.0
SDMT 13T3AFSN-M:M8340		–	■ 225	0.30	3.0	■ 135	0.27	3.0	◪ 210	0.30	3.0	–	–	–	■ 55	0.24	2.4	–	–	–
SDMT 13T3AFSN-M:M9325		–	■ 295	0.30	3.0	–	–	–	■ 280	0.30	3.0	–	–	–	–	–	–	◪ 55	0.21	1.0
SDMT 13T3AFSN-M:M9340		–	■ 265	0.30	3.0	■ 155	0.27	3.0	–	–	–	–	–	–	■ 65	0.24	2.4	–	–	–
	 																			
R la geometria robusta è utilizzata per la sgrossatura e condizioni di lavoro pesanti. Progettata con un angolo di taglio leggermente positivo, T-land ampio e arrotondamento del tagliente per lavorazioni di sgrossatura.																				
SDMT 13T3AFSN-R:M5315		–	◪ 285	0.35	3.0	–	–	–	■ 270	0.35	3.0	–	–	–	–	–	–	■ 55	0.25	1.0
SDMT 13T3AFSN-R:M8310		–	■ 255	0.35	3.0	◪ 130	0.32	3.0	■ 240	0.35	3.0	–	–	–	–	–	–	■ 50	0.25	1.0
SDMT 13T3AFSN-R:M8330		–	■ 240	0.35	3.0	◪ 140	0.32	3.0	■ 225	0.35	3.0	–	–	–	–	–	–	◪ 45	0.25	1.0
SDMT 13T3AFSN-R:M8340		–	■ 220	0.35	3.0	◪ 130	0.32	3.0	◪ 205	0.35	3.0	–	–	–	–	–	–	–	–	–
SDMT 13T3AFSN-R:M9325		–	■ 280	0.35	3.0	–	–	–	■ 265	0.35	3.0	–	–	–	–	–	–	◪ 55	0.25	1.0

XDET 13

	IC	D1	S
	(mm)	(mm)	(mm)
13T3	13.385	4.40	3.97



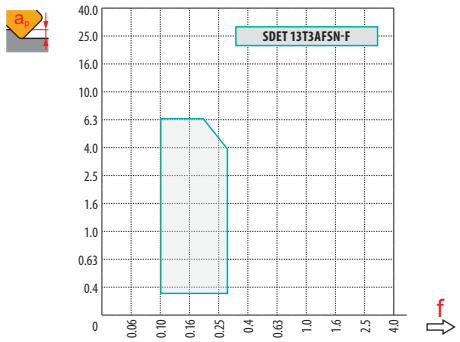
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

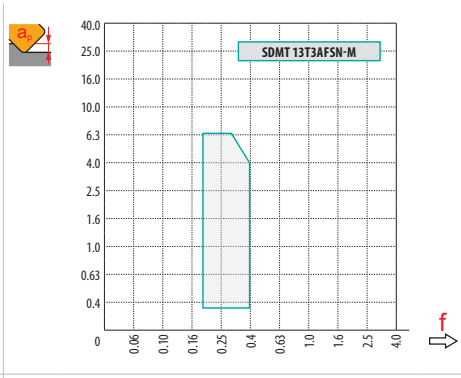
Codice prodotto		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
XDET 13T3AFER:8215		–	420	0.10	0.2	250	0.09	0.2	395	0.10	0.2	–	–	–	–	–	–	–	–	–
XDET 13T3AFER:M8330		–	395	0.10	0.2	235	0.09	0.2	375	0.10	0.2	–	–	–	–	–	–	–	–	–

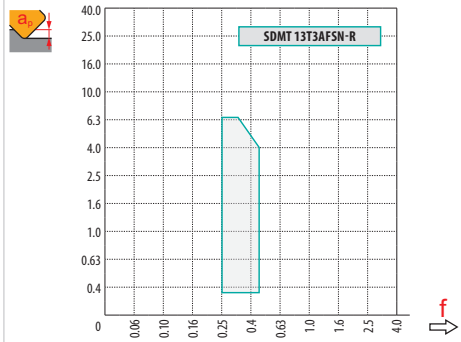
W design del raschiante volto a garantire una migliore finitura superficiale durante la lavorazione con frese di grandi dimensioni e in presenza di un avanzamento elevato.

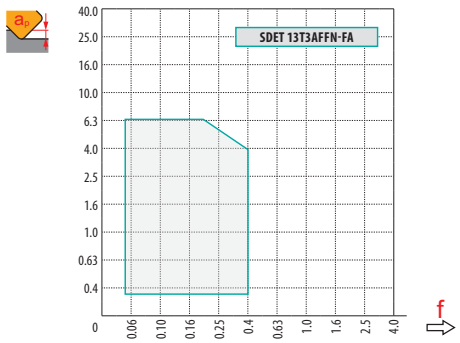
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

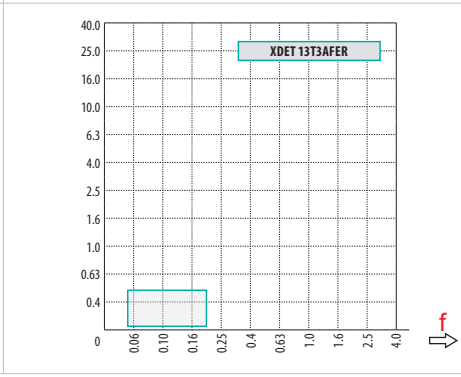
	SDET 13-F	SDMT 13-M	SDMT 13-R	SDET 13-FA	XDET 13
RE	–	–	–	–	–
BS	1.75	1.75	1.75	1.75	8.19











DC	X.V	f_{max}
32	1.22	0.15
40	1.26	0.16
50	1.30	0.18
63	1.34	0.20
80	1.39	0.22
100	1.43	0.24
125	1.48	0.26
160	1.53	0.29
200	1.58	0.33
250	1.63	0.36

DC	RPMX	APMX/I
32	14.1°	6.4/27
40	11.8°	6.4/32
50	9.8°	6.4/39
63	7.7°	6.4/49
80	5.2°	6.4/72
100	4.1°	6.4/91
125	3.2°	5.45/100
160	1.0°	1.6/100
200	0.4°	0.55/100
250	0.3°	0.4/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
32	60.0	89.8	1.7	1.7
40	75.0	107.0	1.7	1.7
50	94.0	127.0	1.7	1.7
63	120.0	152.8	1.7	1.7
80	155.0	186.8	1.7	1.7
100	193.0	225.8	1.7	1.7
125	245.0	275.6	1.7	1.7
160	322.0	345.6	1.7	1.7
200	405.0	425.6	1.7	1.7
250	505.0	525.6	1.7	1.7

a_p
1.5

SSE09

P M K S

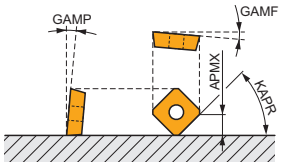
PRAMET

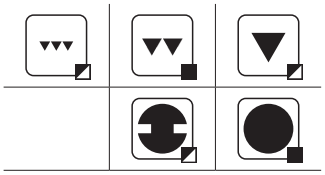
S

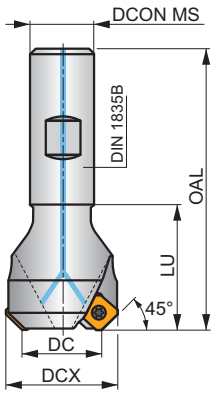
Fresa positiva per spianatura a 45° con refrigerante interno

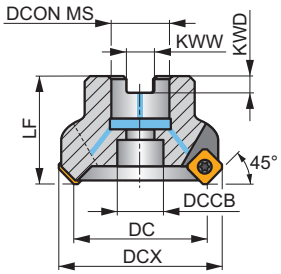
Fresa a spianare a 45° ad elevata produttività che utilizza inserti positivi SE .. 09 con APMX di 4,5 mm. Adatta per spianatura e smussatura. Disponibile con attacco weldon ed a manicotto, con passo differenziato dei taglienti. Corpo trattato per una maggiore durata dell'utensile.

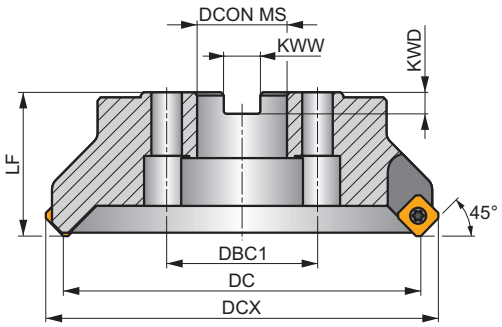
KAPR	45°
APMX	4.5 mm











h_m	0.06 - 0.18
h_m	0.06 - 0.2

	Codice prodotto	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	**20N2R032B20-SSE09-C**	20	29.8	82	20	–	–	32	–	–	–	-5	20	2	–	24600	✓	0.26	GI147	FA010	–
DIN 1835B	**25N3R042B25-SSE09-C**	25	34.8	98	25	–	–	42	–	–	–	-5	20	3	–	22000	✓	0.44	GI147	FA010	–
DIN 1835B	**32N4R042B32-SSE09-C**	32	42	102	32	–	–	42	–	–	–	-5	20	4	–	19400	✓	0.68	GI147	FA010	–
	32A04R-S45SE09F-C	32	42	–	16	14	–	–	40	8.4	6.4	-5	20	4	✓	19400	✓	0.24	GI147	FA012	–
	40A04R-S45SE09F-C	40	53.2	–	16	14	–	–	40	8.4	6.4	-5	20	4	✓	17400	✓	0.30	GI147	FA012	–
	50A05R-S45SE09F-C	50	59.6	–	22	18	–	–	40	10.4	6.4	-5	20	5	✓	15600	✓	0.55	GI147	FA013	–
	63A05R-S45SE09F-C	63	75.8	–	22	18	–	–	40	10.4	6.4	-5	20	5	✓	13900	✓	0.66	GI147	FA013	–
	63A06R-S45SE09F-C	63	75.8	–	22	18	–	–	40	10.4	6.4	-5	20	6	✓	13900	✓	0.58	GI147	FA013	–
ISO 6462 DIN 8030	**80A06R-S45SE09F-C**	80	89.6	–	27	38	–	–	50	12.4	7	-5	20	6	✓	12300	✓	1.14	GI147	FA011	AC001
ISO 6462 DIN 8030	**80A08R-S45SE09F-C**	80	89.6	–	27	38	–	–	50	12.4	7	-5	20	8	✓	12300	✓	1.13	GI147	FA011	AC001
	100A08R-S45SE09F-C	100	110	–	32	45	–	–	50	14.4	8	-5	20	8	✓	11000	✓	1.83	GI147	FA011	AC002
	100A10R-S45SE09F-C	100	110	–	32	45	–	–	50	14.4	8	-5	20	10	✓	10900	✓	1.82	GI147	FA011	AC002
	125A09R-S45SE09F-C	125	134.5	–	40	60	–	–	63	16.4	9	-5	20	9	✓	9800	✓	3.87	GI147	FA011	AC003
	125A12R-S45SE09F-C	125	134.5	–	40	60	–	–	63	16.4	9	-5	20	12	✓	9800	✓	3.87	GI147	FA011	AC003
	160C10R-S45SE09F	160	169.6	–	40	–	66.7	–	63	16.4	9	-5	20	10	✓	8700	–	6.21	GI147	FA014	–

GI147	SEET 09T3AF..	SEMT 09T3AF..

		Nm						
FA010	US 3007-T09P	2.0	M 3	7.3	–	–	Flag T09P	–
FA011	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	–
FA012	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 0830C
FA013	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 1030C

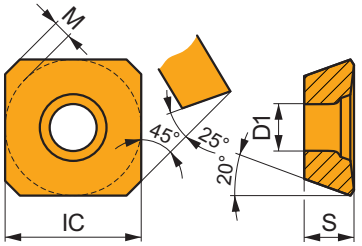
FA014	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 1240C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

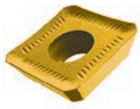
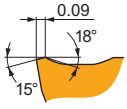
SEMT 09

PRAMET

	IC (mm)	D1 (mm)	M (mm)	S (mm)
09T3	9.525	3.50	1.2	3.97



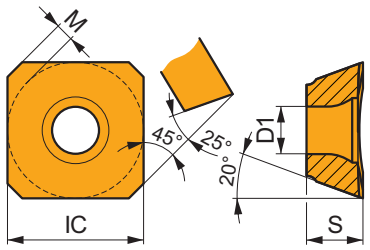
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
SEMT 09T3AFSN:8215	–	295	0.18	1.8	175	0.16	1.8	280	0.18	1.8	–	–	–	–	–	–	–	–	–
SEMT 09T3AFSN:M8330	–	290	0.18	1.8	170	0.16	1.8	275	0.18	1.8	–	–	–	–	–	–	–	–	–
SEMT 09T3AFSN:M8340	–	265	0.18	1.8	155	0.16	1.8	250	0.18	1.8	–	–	–	–	–	–	–	–	–
SEMT 09T3AFSN:M9325	–	365	0.18	1.8	–	–	–	345	0.18	1.8	–	–	–	–	–	–	–	–	–

AFSN design positivo per lavorazioni da leggere a medie.

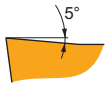
SEET 09

	IC	D1	M	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.525	3.50	1.2	3.97



Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

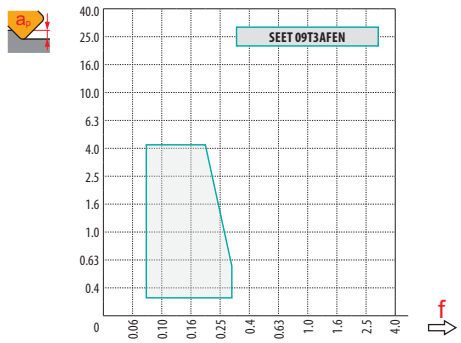
Codice prodotto	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
SEET 09T3AFEN:M6330	–	255	0.14	2.5	180	0.13	2.5	–	–	–	–	–	–	75	0.10	2.0	–	–	–
SEET 09T3AFEN:M8330	–	295	0.14	2.5	175	0.13	2.5	–	–	–	–	–	–	70	0.10	2.0	–	–	–
SEET 09T3AFEN:M8340	–	270	0.14	2.5	160	0.13	2.5	–	–	–	–	–	–	65	0.10	2.0	–	–	–
SEET 09T3AFEN:M9340	–	345	0.14	2.5	205	0.13	2.5	–	–	–	–	–	–	85	0.10	2.0	–	–	–

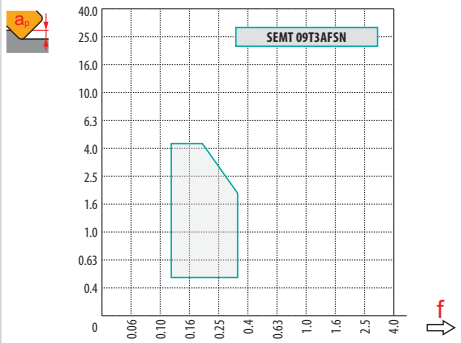


AFEN design positivo per lavorazioni da leggere a medie.

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SEET 09	SEMT 09
RE	–	–
BS	1.28	1.25





DC	X.V	f_{max}
20	1.20	0.18
25	1.24	0.20
32	1.29	0.23
40	1.33	0.25
50	1.37	0.28
63	1.41	0.32
80	1.46	0.36
100	1.50	0.40
125	1.55	0.45
160	1.60	0.51

SSN12Z

P M K S

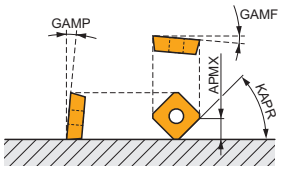
PRAMET

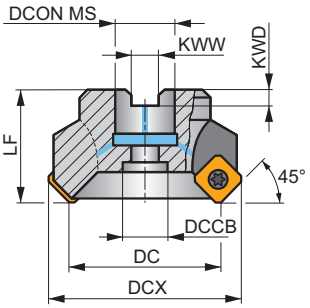
S

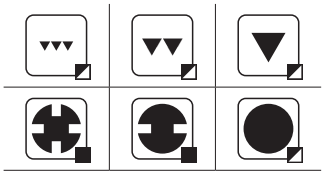
Fresa per spianatura a 45° con geometria positiva e refrigerante interno

Fresa a spianare a 45° ad elevata produttività che utilizza inserti monolaterali tipo SN .. 12 con APMX di 6,5 mm. Adatta per spianatura e smussatura. Attacco a manicotto. Corpo trattato per una maggiore durata dell'utensile.

KAPR	45°
APMX	6.5 mm







h_m 0.12 - 0.35

	Codice prodotto	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**63A05R-S45SN12Z-C**	63	78	40	22	18	–	10.4	6.3	-5.5	7.5	5	–	8600	✓	0.62	GI156	FA071	–
	80A06R-S45SN12Z-C	80	95	50	27	38	–	12.4	7	-5.5	7.5	6	–	7700	✓	1.36	GI156	FA071	AC001
	100A07R-S45SN12Z-C	100	115	50	32	45	–	14.4	8	-5.5	7.5	7	–	6900	✓	1.70	GI156	FA071	AC002
	125A08R-S45SN12Z-C	125	140	63	40	56	–	16.4	9	-5.5	7.5	8	–	6100	✓	3.42	GI156	FA071	AC003

GI156	SNKT 1205AZ..	SNMT 1205AZ..

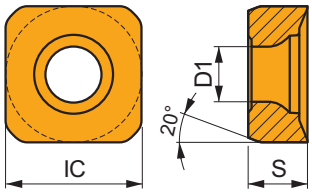
FA071	US 4511-T20	5.0 Nm	M 4.5	11	SDR T20-T

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

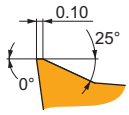
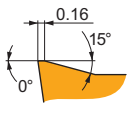
SNMT 12

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.20	5.56



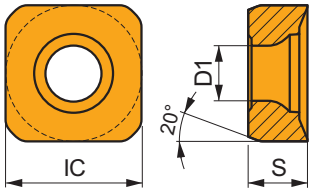
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 		**M** geometria con design altamente positivo per lavorazioni medie.																	
SNMT 1205AZSR-M:8215	–	300	0.25	3.2	180	0.23	3.2	285	0.25	3.2	–	–	–	75	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M8330	–	300	0.25	3.2	180	0.23	3.2	285	0.25	3.2	–	–	–	75	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M8340	–	275	0.25	3.2	165	0.23	3.2	260	0.25	3.2	–	–	–	65	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M9325	–	365	0.25	3.2	–	–	–	345	0.25	3.2	–	–	–	–	–	–	–	–	–
 		**R** geometria con design positivo per lavorazioni da medie a pesanti.																	
SNMT 1205AZSR-R:8215	–	290	0.27	3.5	170	0.24	3.5	275	0.27	3.5	–	–	–	70	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M5315	–	365	0.27	3.5	–	–	–	345	0.27	3.5	–	–	–	–	–	–	–	–	–
SNMT 1205AZSR-R:M8330	–	290	0.27	3.5	170	0.24	3.5	275	0.27	3.5	–	–	–	70	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M8340	–	270	0.27	3.5	160	0.24	3.5	255	0.27	3.5	–	–	–	65	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M9325	–	355	0.27	3.5	–	–	–	335	0.27	3.5	–	–	–	–	–	–	–	–	–

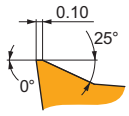
SNKT 12

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.20	5.56

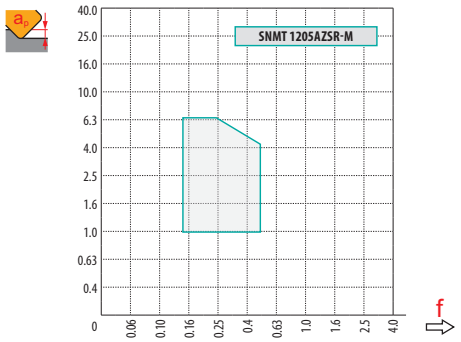


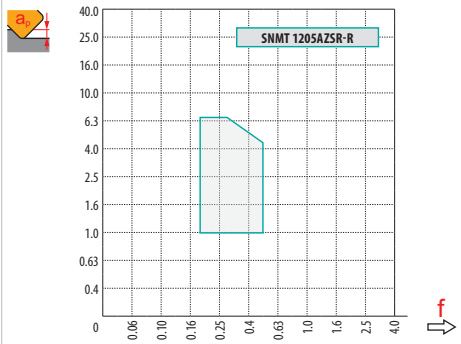
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

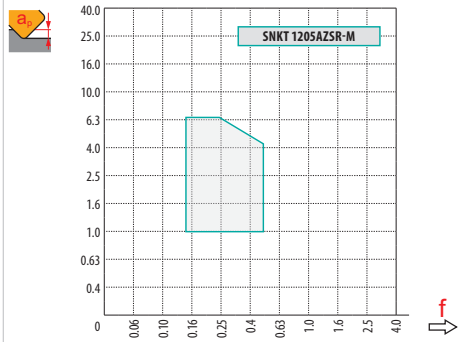
Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 		**M** geometria con design altamente positivo per lavorazioni medie.																	
SNKT 1205AZSR-M:M8330	–	305	0.24	3.2	180	0.22	3.2	285	0.24	3.2	–	–	–	75	0.17	2.6	–	–	–
SNKT 1205AZSR-M:M8340	–	275	0.24	3.2	165	0.22	3.2	260	0.24	3.2	–	–	–	65	0.17	2.6	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SNMT 12-M	SNMT 12-R	SNKT 12-M
RE	–	–	–
BS	0.95	1.03	1.59







DC	X.V	f_{max}
63	1.34	0.53
80	1.39	0.60
100	1.43	0.67
125	1.47	0.74

FSB22X

P M K

PRAMET

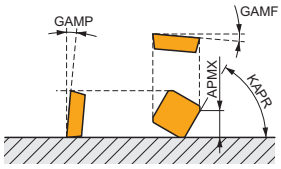
F

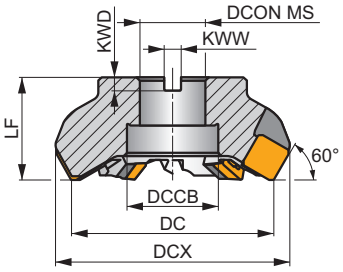
ROUGH SB fresa a spianare a 60° con geometria positiva per fresatura pesante

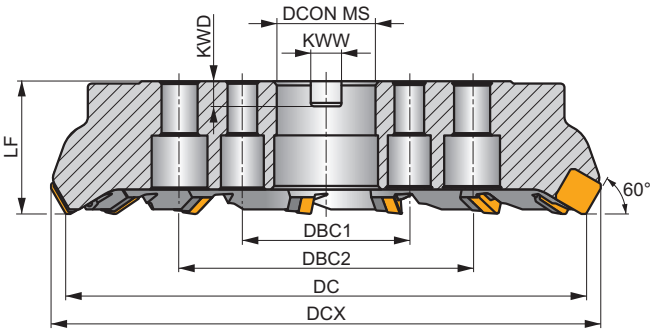
Fresa a spianare a 60 ° ad alta produttività che utilizza inserti SB .. 22 positivi con APMX di 15 mm. Specifica per spianatura pesante con azione di taglio leggera. Passo differenziato dei taglienti . Attacco a manicotto. Corpo trattato per una maggiore durata dell'utensile.

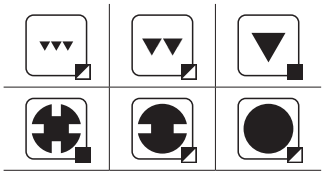
ROUGH SB

KAPR	60°
APMX	15.0 mm









h_m	0.15 - 0.5

	Codice prodotto	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	DBC2 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**125B07R-F60SB22X**	125	144.4	63	40	56	–	–	16.4	9	-9	9	7	✓	–	–	3.73	GI144	FA111	AC003
	160C08R-F60SB22X	160	178.7	63	40	–	66.7	–	16.4	9	-9	9	8	✓	–	–	6.46	GI144	FA114	–
	200C08R-F60SB22X	200	217.9	63	60	–	101.6	–	25.7	14	-9	9	8	✓	–	–	10.59	GI144	FA115	–
	250C09R-F60SB22X	250	267.4	63	60	–	101.6	–	25.7	14	-9	9	9	✓	–	–	17.54	GI144	FA115	–

GI144	SBKX 2207DZ..	SBMR 2207DZ..

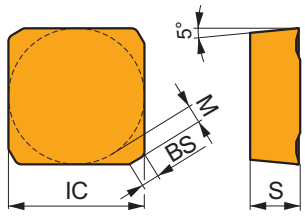
FA111	LNX 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	–
FA114	LNX 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	HS 1240
FA115	LNX 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	HS 1655

AC003	KS 2040	K.FMH40

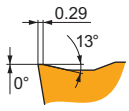
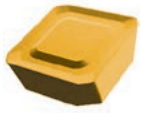
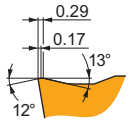
SBMR 22

PRAMET

	IC (mm)	M (mm)	S (mm)	BS (mm)
2207	22.000	2.8	8.00	1.99



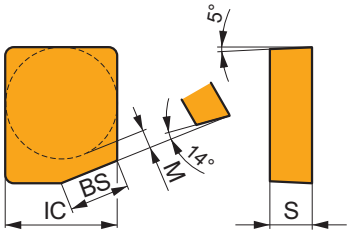
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
DZSR design bilanciato per lavorazioni pesanti.																			
SBMR 2207DZSR:M8326	–	140	0.38	8.5	–	–	–	130	0.38	8.5	–	–	–	–	–	–	–	–	–
SBMR 2207DZSR:M8346	–	120	0.38	8.5	70	0.38	8.5	–	–	–	–	–	–	–	–	–	–	–	–
 																			
R geometria con design bilanciato per lavorazioni pesanti.																			
SBMR 2207DZSR-R:M5326	–	160	0.44	9.8	–	–	–	150	0.44	9.8	–	–	–	–	–	–	–	–	–
SBMR 2207DZSR-R:M8326	–	135	0.44	9.8	–	–	–	125	0.44	9.8	–	–	–	–	–	–	–	–	–
SBMR 2207DZSR-R:M8346	–	115	0.44	9.8	65	0.40	9.8	–	–	–	–	–	–	–	–	–	–	–	–

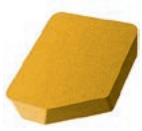
SBKX 22

PRAMET

	IC (mm)	M (mm)	S (mm)	BS (mm)
2207	22.000	3.2	8.00	11.84

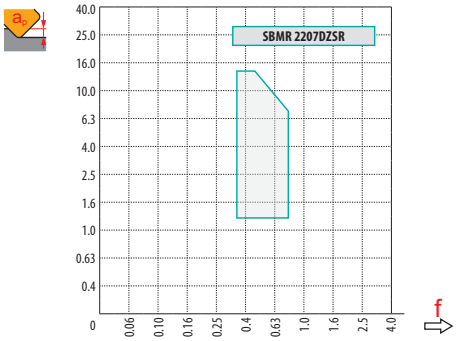


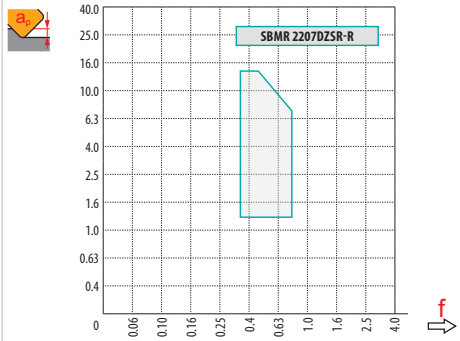
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

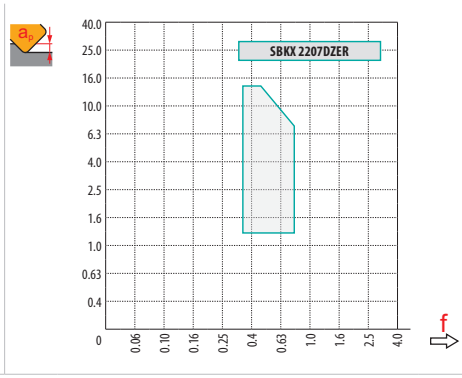
Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
DZER design Wiper con angolo di spoglia superiore del tagliente a zero gradi per una migliore finitura superficiale.																			
SBKX 2207DZER:M8326	–	100	0.60	8.5	–	–	–	95	0.60	8.5	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SBMR 22	SBMR 22-R	SBKX 22
RE	–	–	–
BS	1.99	1.99	11.84







SPIANATURA

	SOD05	SOD06D	SOE06Z			
	45°	45°	43°			
	APMX (mm) 2.7 (10.0)	APMX (mm) 3.1 (8.6)	APMX (mm) 3.3 (9.9)			
	DCX (mm) 32 – 125	DC (mm) 63 – 160	DC (mm) 50 – 200			
Codolo cilindrico	 DC = 32, 40 (mm)					
Weldon						
Modulare						
Fresa a manicotto	 DC = 40 – 125 (mm)					
Pagina	42	51	55			
ISO	P M K N	P M K S H	P M N S			
Forma dell'inserto						
Inserti	OD.. 0505 RD.. 1205 SD.. 1205	OD.. 0605 RPE. 1505	OEHT 0604 REHT 1604 XEHT 0604			
N. di taglienti	8 / 8 / 4	8 / 8	8 / 8 / 1			
Spianatura	■	■	■			
Smussatura	■	■	■			
Interpolazione elicoidale	■		◪			
Fresatura a tuffo progressiva	■		◪			
Rampa	■		◪			
Fresatura di superfici sagomate (fresatura a copiare)	■		◪			
Fresatura di spallamento superficiale	■					
Cave poco profonde	■					
Fresatura a tuffo	■					

■ Uso primario ◪ Uso possibile

SOD05

P M K N

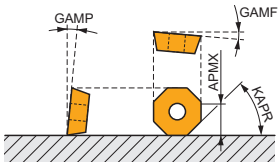
PRAMET

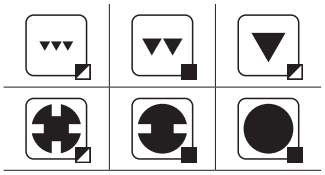
S

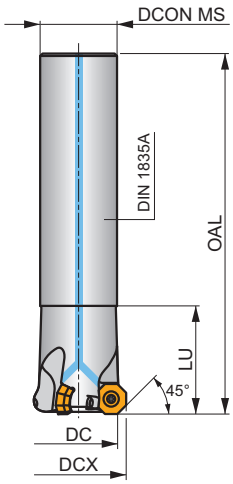
Fresa universale per spianatura con design positivo e passaggio interno del refrigerante

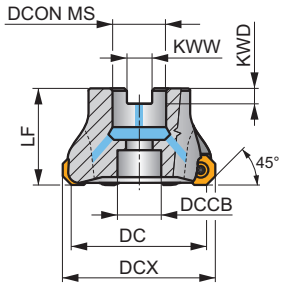
Highly productive universal face mill utilising single-sided positive inserts with APMX up to 2.7 (10) mm. Unique insert seat fits OD.. 05, RD.. 12 and SD.. 12 style inserts, suited for wide range of applications. Differential tooth pitch. Arbor and cylindrical style. Body treated for longer tool life.

KAPR	45°
APMX	2.7 (10.0) mm









h_m	0.03 - 0.15
h_m	0.03 - 0.12

	Codice prodotto	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	KAPR (°)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	32N3R045A25-SOD05-C	32	24.7	130	25	–	45	–	45	–	–	-10	8	3	–	17700	✓	0.41	GI326	FA049	–
DIN 1835A	40N3R045A32-SOD05-C	40	32.6	150	32	–	45	–	45	–	–	-7	8	3	–	15800	✓	0.86	GI326	FA040	–
	40A03R-S450D05-C	40	32.7	–	16	14	–	40	45	8.4	5.6	-10	8	3	–	15800	✓	0.18	GI326	FA042	–
	50A04R-S450D05-C	50	42.6	–	22	18	–	40	45	10.4	6.3	-7	8	4	–	14100	✓	0.28	GI326	FA043	–
	50A05R-S450D05-C	50	42.6	–	22	18	–	40	45	10.4	6.3	-7	8	5	–	14100	✓	0.28	GI326	FA043	–
ISO 6462 DIN 8030	63A05R-S450D05-C	63	55.6	–	22	18	–	40	45	10.4	6.3	-7	8	5	✓	12600	✓	0.39	GI326	FA043	–
ISO 6462 DIN 8030	63A06R-S450D05-C	63	55.6	–	22	18	–	40	45	10.4	6.3	-7	8	6	✓	12600	✓	0.50	GI326	FA043	–
	80A06R-S450D05-C	80	72.6	–	27	38	–	50	45	12.4	7	-7	8	6	✓	11100	✓	0.73	GI326	FA041	AC001
	80A08R-S450D05-C	80	72.6	–	27	38	–	50	45	12.4	7	-7	8	8	✓	11100	✓	0.66	GI326	FA041	AC001
	100A07R-S450D05-C	100	92.6	–	32	45	–	50	45	14.4	8	-7	8	7	✓	10000	✓	1.09	GI326	FA041	AC002
	125A08R-S450D05-C	125	117.6	–	40	56	–	63	45	16.4	9	-7	8	8	✓	8900	✓	2.20	GI326	FA041	AC003

GI326	OD.. 0505..	RD.. 1205..	SDKT 1205..	SDMT 1205..SN

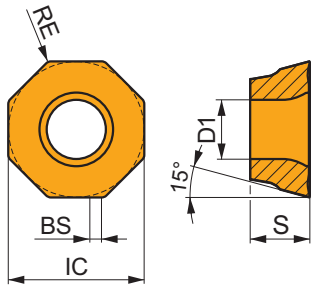
		Nm					
FA040	US 45014-T20P	5.0	M 5	13	Flag T20P	–	–
FA041	US 45014-T20P	5.0	M 5	13	–	SDR T20P-T	–
FA042	US 45014-T20P	5.0	M 5	13	–	SDR T20P-T	HS 90835
FA043	US 45014-T20P	5.0	M 5	13	–	SDR T20P-T	HS 1030C
FA049	US 45011-T20P	5.0	M 5	11	Flag T20P	–	–

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

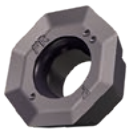
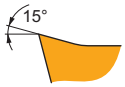
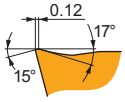
ODKT 05IM

PRAMET

	IC (mm)	D1 (mm)	S (mm)	BS (mm)
0505	12.700	5.50	5.56	1.00



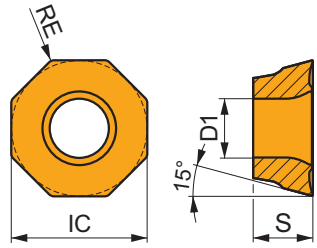
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F geometria per inserto di spianatura a 45°, con design positivo per lavorazioni leggere.																				
ODKT 0505ADFR-F:M8310	●	0.8	■ 275	0.15	2.5	◪ 140	0.14	2.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
FM geometria per inserto di spianatura a 45°, con design positivo per lavorazioni da leggere a medie.																				
ODKT 0505ADSR-FM:M6330	⬌	0.8	■ 190	0.25	2.5	■ 135	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M8310	⬌	0.8	■ 240	0.25	2.5	◪ 120	0.23	2.5	◪ 225	0.25	2.5	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M8330	⬌	0.8	■ 225	0.25	2.5	■ 135	0.23	2.5	◪ 210	0.25	2.5	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M8345	⬌	0.8	■ 160	0.25	2.5	■ 95	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M9340	⬌	0.8	■ 245	0.25	2.5	■ 145	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–

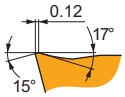
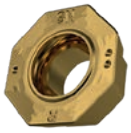
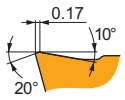
ODMT 05IM

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0505	12.700	5.50	5.56



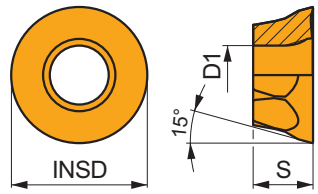
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
FM geometria per inserto di spianatura a 45°, con design positivo per lavorazioni da leggere a medie.																			
ODMT 0505ADSR-FM:M8340	0.8	200	0.25	2.5	120	0.23	2.5	190	0.25	2.5	–	–	–	–	–	–	–	–	–
ODMT 0505ADSR-FM:M9340	0.8	245	0.25	2.5	145	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–
 																			
R geometria per inserto di spianatura a 45°, con design positivo per condizioni di taglio instabili.																			
ODMT 050508SN-R:M8330	0.8	190	0.25	2.5	–	–	–	180	0.25	2.5	–	–	–	–	–	–	–	–	–
ODMT 050508SN-R:M9340	0.8	210	0.25	2.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

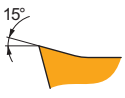
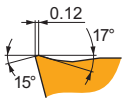
RDGT 12IM

PRAMET

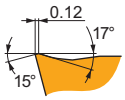
	INSD (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
F geometria con design altamente positivo per lavorazioni leggere.																			
RDGT 120500FN-F:M8310	–	210	0.20	1.5	105	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
 																			
FM geometria con design positivo per lavorazioni da leggere a medie.																			
RDGT 120500SN-FM:M8330	–	190	0.20	1.5	110	0.18	1.5	180	0.20	1.5	–	–	–	–	–	–	–	–	–

Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

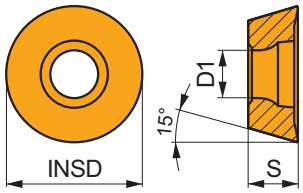
Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
RDGT 120500SN-FM:M8345	●	–	■	140	0.20	1.5	◪	80	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–

FM geometria con design positivo per lavorazioni da leggere a medie.

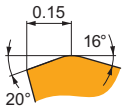
RDMT 12IM

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

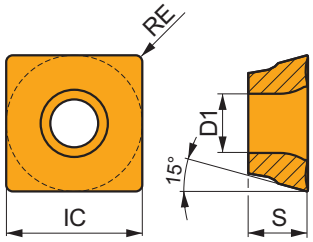
Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
RDMT 120500SN-R:M8330	⬌	–	■	175	0.30	1.5	–	–	–	–	■	165	0.30	1.5	–	–	–	–	–	–	–	–
RDMT 120500SN-R:M8340	⬌	–	■	160	0.30	1.5	–	–	–	–	◪	150	0.30	1.5	–	–	–	–	–	–	–	–

R geometria con design positivo, adatta per operazioni di copiatura e contornatura, per condizioni di taglio instabili.

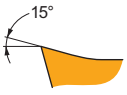
SDKT 12IM

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56

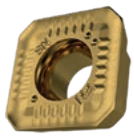
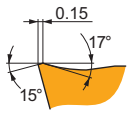


Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
SDKT 1205PDFR-F:8215	●	0.8	■	285	0.10	4.0	◪	170	0.09	4.0	–	–	–	◪	855	0.12	4.0	–	–	–	–	–

F geometria per inserto a spallamento retto a 90°, con design positivo per lavorazioni leggere.

Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

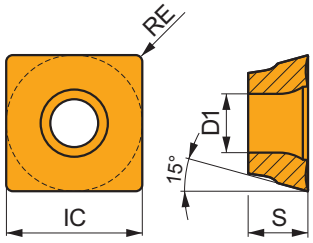
Codice prodotto		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
																				
SDKT 1205AESN-FM:M8330		–	280	0.15	4.0	165	0.15	4.0	265	0.15	4.0	–	–	–	–	–	–	–	–	–
SDKT 1205AESN-FM:M8345		–	205	0.15	4.0	120	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–
SDKT 1205PDSR-FM:M8330		0.8	255	0.15	4.0	150	0.15	4.0	240	0.15	4.0	–	–	–	–	–	–	–	–	–
SDKT 1205PDSR-FM:M8345		0.8	185	0.15	4.0	110	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–

FM geometria per inserto a spallamento retto a 90°, con design positivo per lavorazioni da leggere a medie.

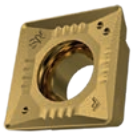
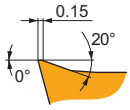
SDMT 12IM

PRAMET

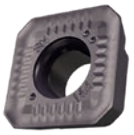
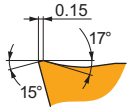
	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



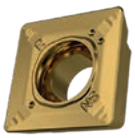
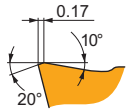
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
																				
SDMT 120508SN-F:M8310		0.8	265	0.15	4.0	135	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–
SDMT 120508SN-F:M8330		0.8	245	0.15	4.0	145	0.15	4.0	–	–	–	735	0.18	4.0	–	–	–	–	–	–

F geometria per inserto a spallamento retto a 90°, con design positivo per lavorazioni da leggere a medie.

																				
SDMT 120508SN-FM:M8345		0.8	175	0.15	4.0	105	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–

FM geometria per inserto a spallamento retto a 90°, con design positivo per lavorazioni medie.

																				
SDMT 120508SN-R:M8330		0.8	225	0.20	4.0	–	–	–	210	0.20	4.0	–	–	–	–	–	–	–	–	–
SDMT 120508SN-R:M8345		0.8	165	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SDMT 1205AESN-R:M8330		–	265	0.20	4.0	–	–	–	250	0.20	4.0	–	–	–	–	–	–	–	–	–
SDMT 1205AESN-R:M8340		–	240	0.20	4.0	–	–	–	225	0.20	4.0	–	–	–	–	–	–	–	–	–

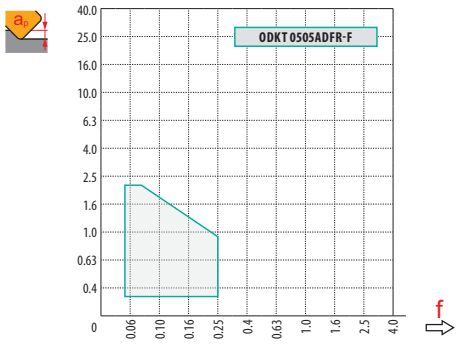
R geometria per inserto a spallamento retto a 90°, con design positivo per condizioni di taglio instabili.

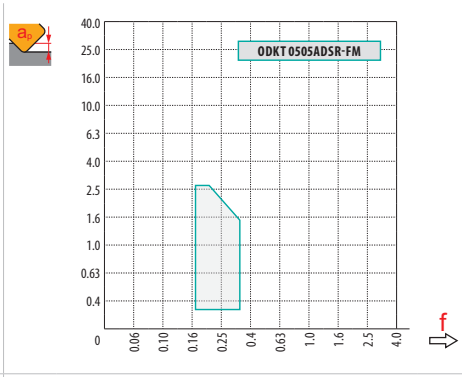
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

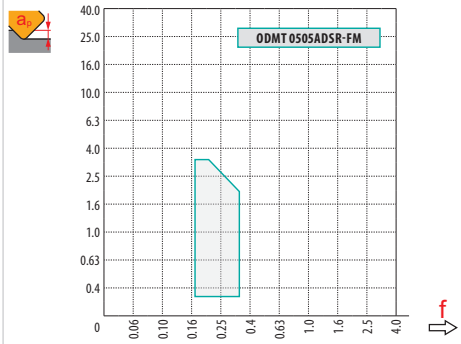
	ODKT 05-F	ODKT 05-FM	ODMT 05-FM	ODMT 05-R
RE	0.4	0.8	0.8	0.8
BS	1.00	1.00	–	–

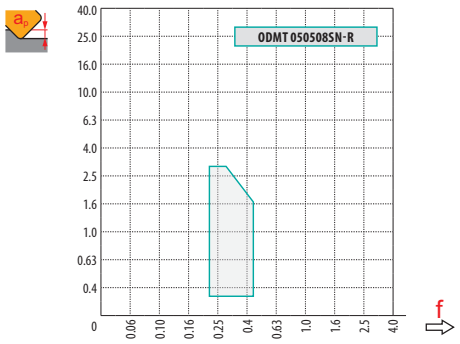
	RDGT 12-F	RDGT 12-FM	RDGT 12-R
RE	6.35	6.35	6.35
BS	–	–	–

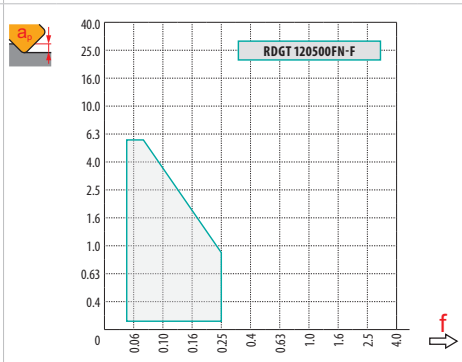
	SDKT 12-F	SDKT 12-FM	SDMT 12-F	SDMT 12-R
RE	0.8	0.8	0.8	0.8
BS	2.30	2.30	–	–

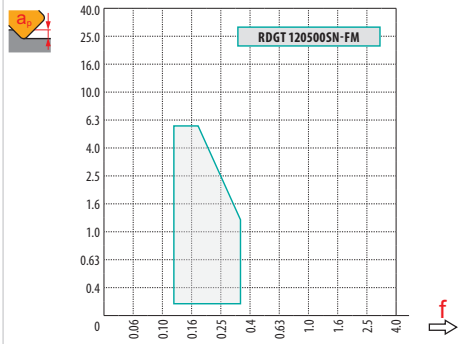


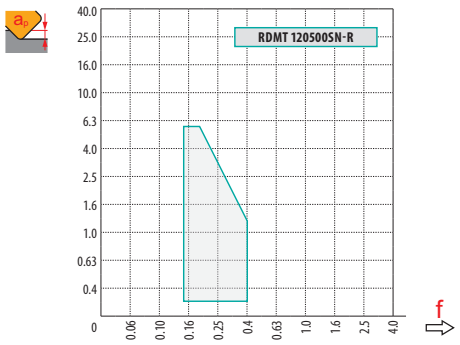


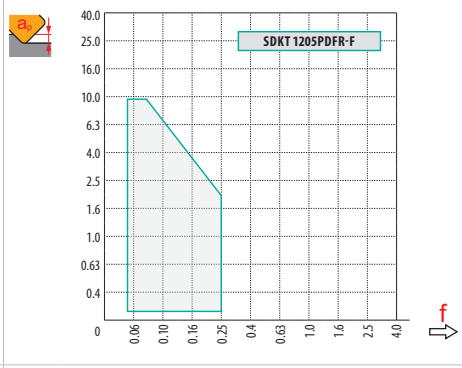


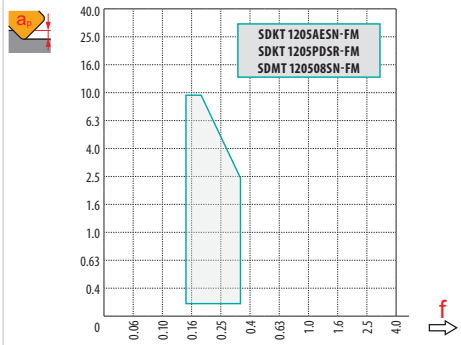


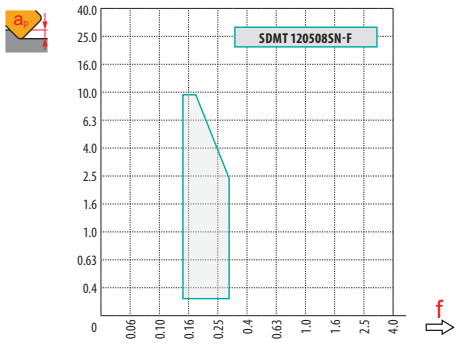


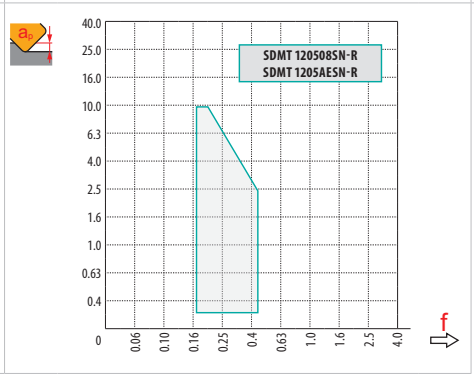












DCX	a_p	0.25	0.50	0.60	0.70	0.80	1.00	1.25	1.50	2.00	3.00	4.00	5.00	6.00
		R												
32		23.43	24.80	25.23	25.62	25.99	26.63	27.33	27.94	28.94	30.39	31.31	31.83	32.00
40		31.43	32.80	33.23	33.62	33.99	34.63	35.33	35.94	36.94	38.39	39.31	39.83	40.00
50	DEF	41.43	42.80	43.23	43.62	43.99	44.63	45.33	45.94	46.94	48.39	49.31	49.83	50.00
63		54.43	55.80	56.23	56.62	56.99	57.63	58.33	58.94	59.94	61.39	62.31	62.83	63.00
80		71.43	72.80	73.23	73.62	73.99	74.63	75.33	75.94	76.94	78.39	79.31	79.83	80.00
100		91.43	92.80	93.23	93.62	93.99	94.63	95.33	95.94	96.94	98.39	99.31	99.83	100.00
125		116.43	117.80	118.23	118.62	118.99	119.63	120.33	120.94	121.94	123.39	124.31	124.83	125.00

DCX	X.V	f_{max}
32	1.36	0.28
40	1.40	0.31
50	1.43	0.33
63	1.47	0.37
80	1.52	0.42
100	1.57	0.47
125	1.62	0.52

S

a_{emax}
10.0

S

a_p	1.0	5.0	10.0
f	0.35	0.21	0.15

O

DCX	RPMX	APMX/I
50	4.1°	7.05/100
63	2.7°	4.6/100
80	1.8°	3/100
100	1.7°	2.85/100
125	0.7°	1.1/100

R

DCX	RPMX	APMX/I
50	3.8°	6.2/95
63	2.5°	4.25/100
80	1.7°	2.85/100
100	1.6°	2.65/100
125	0.3°	0.4/100

O

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
50	78.0	100.0	4.5	4.5
63	105.0	126.0	4.5	4.5
80	138.0	160.0	4.5	4.5
100	178.0	200.0	4.5	4.5
125	229.0	250.0	4.0	4.5

R

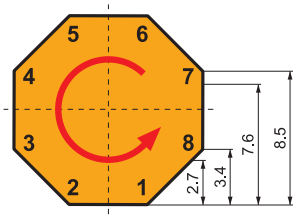
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
50	78.0	100.0	4.5	4.5
63	105.0	126.0	4.5	4.5
80	138.0	160.0	4.5	4.5
100	178.0	200.0	4.5	4.5
125	230.0	250.0	4.0	4.5

	O	R
a_p	2.4	2.3

DCX	µm	R 3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071

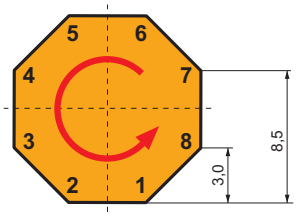
RE	µm	3	5	10	15	20	30	40	50	60	80	100
6.0	FE	0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191

ODKT 05



a_p	
–> 2.7	8
–> 3.4	7
–> 7.6	4
–> 8.5	2

ODMT 05



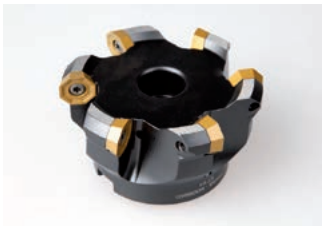
a_p	
–> 3.0	8
–> 8.5	4

SOD06D

P M K S H

PRAMET

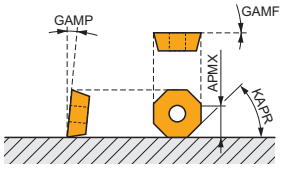
S

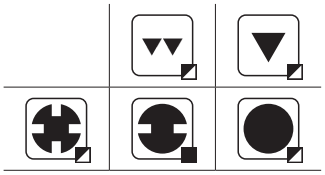


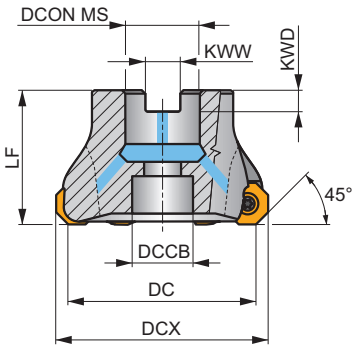
Fresa universale per spianatura con design positivo e passaggio interno del refrigerante

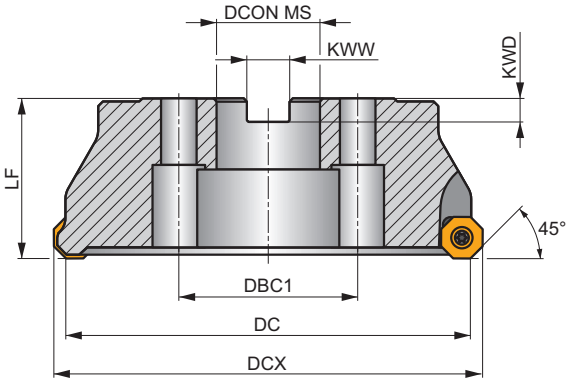
Highly productive universal face mill utilising single sided positive inserts with APMX of up to 3.1 (8.6) mm. Unique insert seat fits OD.. 06 and RP.. 15 style inserts, suited for face milling and chamfering. Arbor style only with differential tooth pitch. Body treated for longer tool life.

KAPR	45°
APMX	3.1 (8.6) mm









h_m 0.12 - 0.22

	Codice prodotto	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
ISO 6462 DIN 8030	**63A05R-S450D06D**	63	72.5	40	22	18	–	10.4	6.3	0	5	5	✓	8800	✓	0.55	GI059	FA071
	80A06R-S450D06D	80	89.5	50	27	20	–	12.4	7	0	5	6	✓	7800	✓	1.19	GI059	FA071
	100A07R-S450D06D	100	109.5	50	32	27	–	14.4	8	0	5	7	✓	7000	✓	2.07	GI059	FA071
	125A08R-S450D06D	125	134.5	63	40	33	–	16.4	9	0	5	8	✓	6300	✓	4.05	GI059	FA071
	160C09R-S450D06D	160	169.5	63	40	56	66.7	16.4	9	0	5	9	✓	5500	–	6.49	GI059	FA071

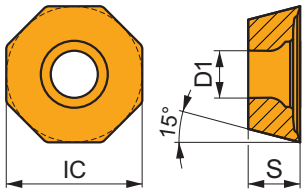
GI059	OD.. 0605ZZ..	RP.. 1505M0..

FA071	US 4511-T20	5.0 Nm	M 4.5	11	SDR T20-T

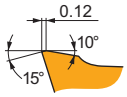
ODMT 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0605	15.875	5.50	5.56



Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

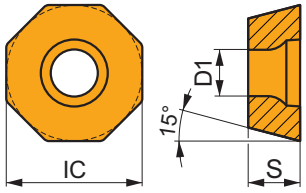
Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
ODMT 0605ZZN:M5315	–	255	0.24	3.0	–	–	–	240	0.24	3.0	–	–	–	–	–	–	–	–	–
ODMT 0605ZZN:M8330	–	200	0.24	3.0	–	–	–	190	0.24	3.0	–	–	–	–	–	–	–	–	–
ODMT 0605ZZN:M8340	–	185	0.24	3.0	–	–	–	175	0.24	3.0	–	–	–	–	–	–	–	–	–
ODMT 0605ZZN:M9325	–	245	0.24	3.0	–	–	–	230	0.24	3.0	–	–	–	–	–	–	–	–	–

ZZN design leggermente positivo per inserto di spianatura a 45°, per lavorazioni medie.

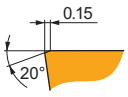
ODEW 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0605	15.875	5.50	5.56



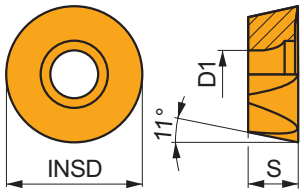
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
ODEW 0605ZZN:M8330	–	210	0.26	2.5	–	–	–	195	0.26	2.5	–	–	–	–	–	–	40	0.13	1.0

ZZN design con angolo di spoglia superiore del tagliente a zero gradi per inserti adatti alla spianatura a 45°, per lavorazioni medie.

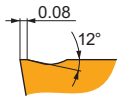
RPET 15

	INSD	D1	S
	(mm)	(mm)	(mm)
1505	15.785	5.50	5.56



Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto		RE	**P**			**M**			**K**			**N**			**S**			**H**		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)

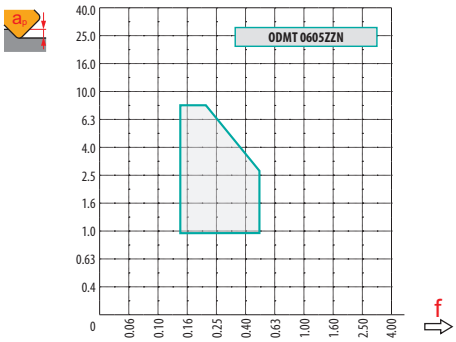


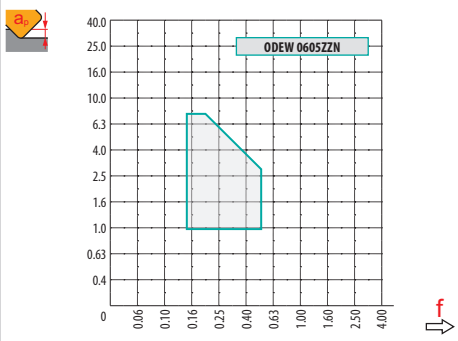
M geometria con design positivo adatta per operazioni di copiatura e contornatura, per lavorazioni da leggere a sgrossature pesanti.

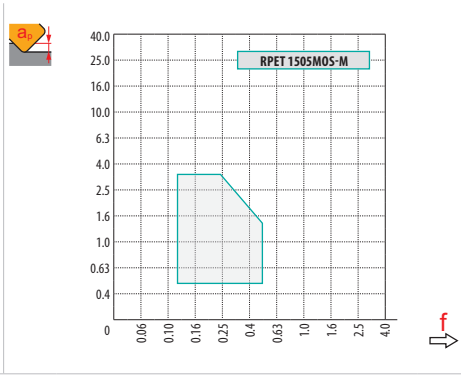
RPET 1505MOS-M:M8330		–	230	0.40	1.0	135	0.36	1.0	215	0.40	1.0	–	–	–	55	0.28	0.8	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ODMT 06	ODEW 06	RPET 15-M
RE	–	–	7.89
BS	1.73	5.92	–

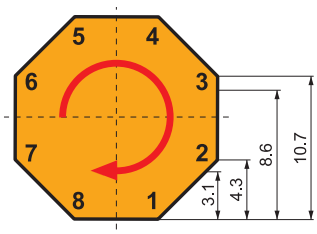






DC	a_p	0.00	0.50	0.75	1.25	1.50	2.00	2.50	3.00	4.00
63	DEF	56.63	62.17	63.36	65.18	65.91	67.16	68.19	69.05	70.41
80		73.63	79.17	80.36	82.18	82.91	84.16	85.19	86.05	87.41
100		93.63	99.17	100.36	102.18	102.91	104.16	105.19	106.05	107.41
125		118.63	124.17	125.36	127.18	127.91	129.16	130.19	131.05	132.41
160		153.63	159.17	160.36	162.18	162.91	164.16	165.19	166.05	167.41

DC	X.V	f_{max}
63	1.49	0.78
80	1.54	0.88
100	1.59	0.98
125	1.64	1.10
160	1.70	1.24



a_p	
–> 3.1	8
–> 4.3	7
–> 8.6	4
–> 10.7	2

SOE06Z

P M N S

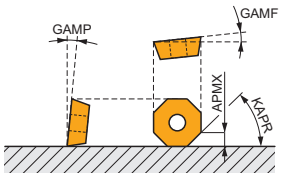
PRAMET

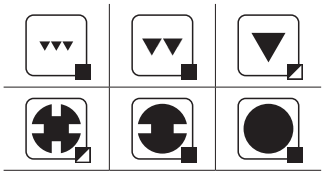
S

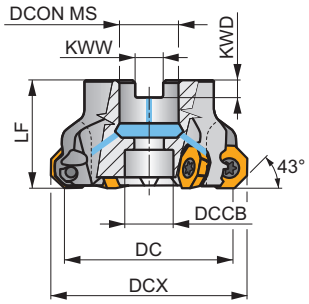
Fresa per spianatura universale con geometria positiva e refrigerante interno

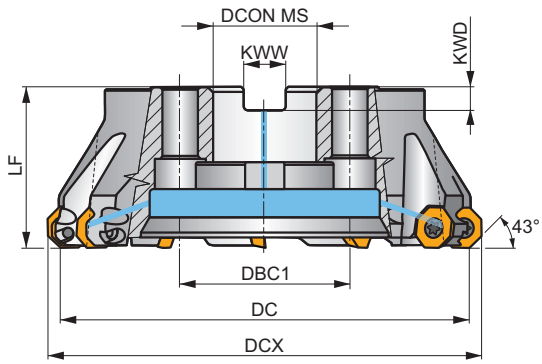
Fresa per spianatura universale ad elevata produttività che utilizza inserti positivi OE..06 - RE.. 16 con APMX di 4 mm . Sede unica per inserti OE .. 06, RE .. 16, XE .. 06, adatta per un'ampia gamma di applicazioni. Attacco a manicotto, con passo differenziato dei taglienti. Corpo trattato per una maggiore durata dell'utensile.

KAPR	43°
APMX	3.3 (9.9) mm









h_m 0.06 - 0.20

	Codice prodotto	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
	50A04R-S45OE06Z-C	50	60.2	40	22	18	–	10.4	6.3	6	10	4	✓	10700	✓	0.47	GI283	FA053	–
	50A05R-S45OE06Z-C	50	60	40	22	18	–	10.4	6.3	1	10	5	✓	10700	✓	0.47	GI283	FA053	–
	56A05R-S45OE06Z-C	56	66	40	22	18	–	10.4	6.3	6	10	5	✓	10100	✓	0.52	GI283	FA053	–
	63A04R-S45OE06Z-C	63	73.2	40	22	18	–	10.4	6.3	6	10	4	✓	9600	✓	0.58	GI283	FA053	–
	63A06R-S45OE06Z-C	63	73	40	22	18	–	10.4	6.3	1	10	6	✓	9600	✓	0.60	GI283	FA053	–
	70A06R-S45OE06Z-C	70	80	40	22	18	–	10.4	6.3	6	10	6	✓	9100	✓	0.69	GI283	FA053	–
	80A05R-S45OE06Z-C	80	90.2	50	27	38	–	12.4	7	6	10	5	✓	8500	✓	1.02	GI283	FA051	AC001
	80A06R-S45OE06Z-C	80	90.2	50	27	38	–	12.4	7	6	10	6	✓	8500	✓	1.03	GI283	FA051	AC001
ISO 6462 DIN 8030	**90A07R-S45OE06Z-C**	90	100	50	32	45	–	14.4	8	6	10	7	✓	8000	✓	1.59	GI283	FA051	AC002
	100A06R-S45OE06Z-C	100	110.2	50	32	45	–	14.4	8	6	10	6	✓	7600	✓	1.85	GI283	FA051	AC002
	100A08R-S45OE06Z-C	100	109.9	50	32	45	–	14.4	8	1	10	8	✓	7600	✓	1.87	GI283	FA051	AC002
	125A07R-S45OE06Z-C	125	135.2	63	40	56	–	16.4	9	6	10	7	✓	6800	✓	3.31	GI283	FA051	AC003
	125A09R-S45OE06Z-C	125	134.9	63	40	56	–	16.4	9	1	10	9	✓	6800	✓	3.35	GI283	FA051	AC003
	160C09R-S45OE06Z-C	160	170.2	63	40	–	66.7	16.4	9	6	10	9	✓	6000	✓	6.08	GI283	FA056	–
	160C12R-S45OE06Z-C	160	169.9	63	40	–	66.7	16.4	9	1	10	12	✓	6000	✓	7.06	GI283	FA056	–
	200C11R-S45OE06Z-C	200	210.2	63	60	–	101.6	25.7	14	6	10	11	✓	5300	✓	10.80	GI283	FA057	–
	200C14R-S45OE06Z-C	200	209.9	63	60	–	101.6	25.7	14	1	10	14	✓	5300	✓	11.15	GI283	FA057	–

GI283	OEHT 0604AE..	REHT 1604M0..	XEHT 0604AE..

		Nm							
FA051	US 5011-T20P	5.0	M 5	11	SDR T20P-T	–	–	–	–
FA053	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1030C	–	–	–

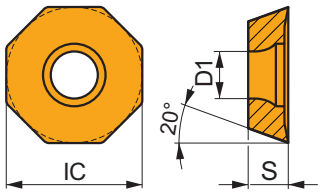
FA056	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5
FA057	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1655C	CAC 200C	HSD 1025C	HXK 7

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

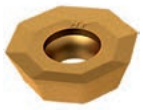
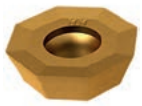
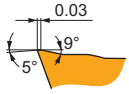
OEHT 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0604	16.050	5.50	4.76



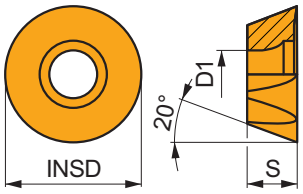
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
MF geometria per inserto di spianatura a 45°, con design positivo affilato per lavorazioni da leggere a medie, potenzialmente anche per la finitura.																			
OEHT 0604AEER-MF:M6330	–	255	0.12	2.2	180	0.11	2.2	–	–	–	–	–	–	75	0.10	1.8	–	–	–
OEHT 0604AEER-MF:M8330	–	295	0.12	2.2	175	0.11	2.2	–	–	–	885	0.14	2.2	70	0.10	1.8	–	–	–
OEHT 0604AEER-MF:M8340	–	275	0.12	2.2	165	0.11	2.2	–	–	–	–	–	–	65	0.10	1.8	–	–	–
																			
MM geometria per inserto di spianatura a 45°, con design positivo affilato per lavorazioni da leggere a medie.																			
OEHT 0604AEER-MM:M6330	–	245	0.16	2.2	170	0.14	2.2	–	–	–	–	–	–	70	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M8330	–	280	0.16	2.2	165	0.14	2.2	–	–	–	840	0.19	2.2	70	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M8340	–	255	0.16	2.2	150	0.14	2.2	–	–	–	–	–	–	60	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M8345	–	205	0.16	2.2	120	0.14	2.2	–	–	–	–	–	–	50	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M9340	–	320	0.16	2.2	190	0.14	2.2	–	–	–	–	–	–	80	0.11	1.8	–	–	–
																			
M geometria per inserto di spianatura a 45°, con design lievemente positivo per lavorazioni da leggere a medie.																			
OEHT 0604AESR-M:M6330	–	210	0.24	3.2	150	0.22	3.2	–	–	–	–	–	–	60	0.17	2.6	–	–	–
OEHT 0604AESR-M:M8310	–	265	0.24	3.2	135	0.22	3.2	–	–	–	–	–	–	–	–	–	–	–	–
OEHT 0604AESR-M:M8330	–	245	0.24	3.2	145	0.22	3.2	–	–	–	–	–	–	60	0.17	2.6	–	–	–
OEHT 0604AESR-M:M8340	–	220	0.24	3.2	130	0.22	3.2	–	–	–	–	–	–	55	0.17	2.6	–	–	–
OEHT 0604AESR-M:M9325	–	295	0.24	3.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

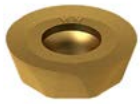
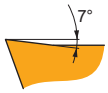
REHT 16

PRAMET

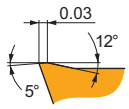
	INSD	D1	S
	(mm)	(mm)	(mm)
1604	16.000	5.50	4.76



Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
REHT 1604M0EN-MM:M6330	✱	–	255	0.20	2.0	180	0.18	2.0	–	–	–	–	–	–	75	0.14	1.6	–	–	–
REHT 1604M0EN-MM:M8340	✱	–	270	0.20	2.0	160	0.18	2.0	–	–	–	–	–	–	65	0.14	1.6	–	–	–
REHT 1604M0EN-MM:M9340	✱	–	330	0.20	2.0	195	0.18	2.0	–	–	–	–	–	–	80	0.14	1.6	–	–	–

MM geometria con design lievemente positivo, adatta per operazioni di copiatura e contornatura, per lavorazioni da leggere a medie.



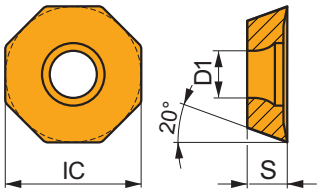
REHT 1604M0SN-M:M8310	✱	–	285	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	–	–	–	–	–	–
REHT 1604M0SN-M:M8330	✱	–	270	0.30	2.0	160	0.27	2.0	–	–	–	–	–	–	65	0.21	1.6	–	–	–
REHT 1604M0SN-M:M8340	✱	–	245	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	60	0.21	1.6	–	–	–

M geometria con design positivo adatta per operazioni di copiatura e contornatura, per lavorazioni medie.

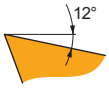
OEHT 06-FA

PRAMET

	IC	D1	S
	(mm)	(mm)	(mm)
0604	16.050	5.50	4.76



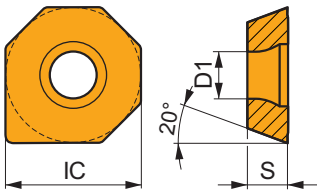
Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
OEHT 0604AEFR-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	330	0.18	2.0	–	–	–	–	–	–
OEHT 0604AEFR-FA:M0315	●	–	–	–	–	–	–	–	–	–	–	765	0.18	2.0	–	–	–	–	–	–

FA geometria per inserto di spianatura a 45°, con design altamente positivo per lavorazioni da leggere a medie.

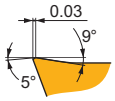
XEHT 06

	IC	D1	S
	(mm)	(mm)	(mm)
0604	16.050	5.50	4.76



Idoneità e valori iniziali per velocità di taglio (Vc), avanzamento (f) e profondità di taglio (ap). Fare riferimento alla nostra App Machining Calculator per ulteriori calcoli.

Codice prodotto		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)

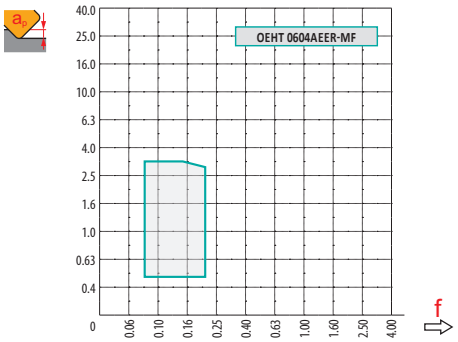


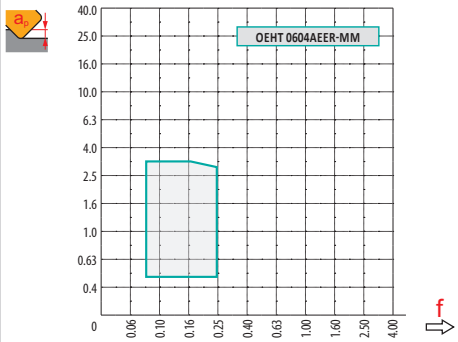
W design Wiper leggermente positivo per una migliore finitura superficiale.

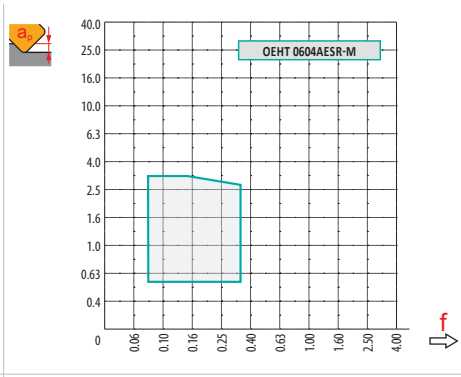
XEHT 0604AESR:M8310	●	–	■	265	0.24	3.2	◪	135	0.22	3.2	–	–	–	–	–	–	–	–	–	–	–	–
XEHT 0604AESR:M8330	✱	–	■	245	0.24	3.2	◪	145	0.22	3.2	–	–	–	–	–	–	–	–	–	–	–	–

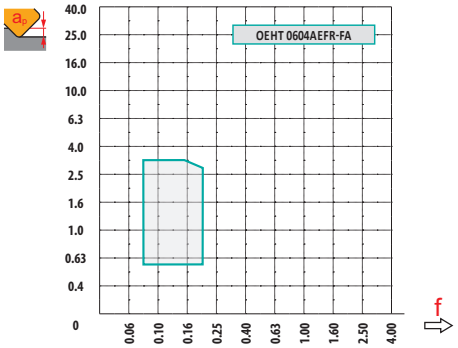
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

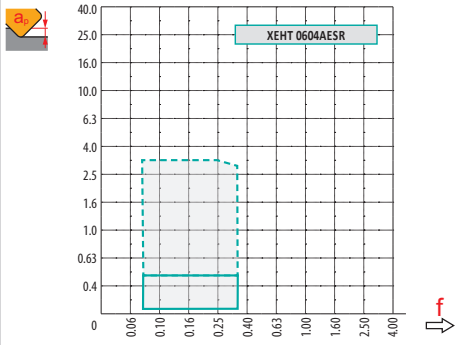
	OEHT 06-MF	OEHT 06-MM	OEHT 06-M	OEHT 06-FA	XEHT 06	REHT 16-MM	REHT 16-M
RE	–	–	–	–	–	8.00	8.00
BS	1.36	1.36	1.36	1.36	9.91	–	–

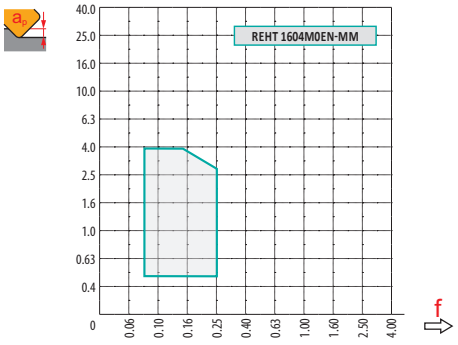


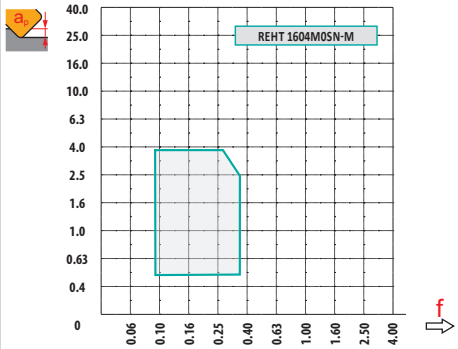












DC	R								
	a_p	0.00	0.50	0.75	1.25	1.50	2.00	2.50	3.00	4.00
50		43.90	49.47	50.66	52.49	53.23	54.48	55.52	56.39	57.76
56		49.80	55.37	56.56	58.39	59.13	60.38	61.42	62.29	63.66
63		56.90	62.47	63.66	65.49	66.23	67.48	68.52	69.39	70.76
70		63.80	69.37	70.56	72.39	73.13	74.38	75.42	76.29	77.66
80	DEF	73.90	79.47	80.66	82.49	83.23	84.48	85.52	86.39	87.76
90		83.80	89.37	90.56	92.39	93.13	94.38	95.42	96.29	97.66
100		93.90	99.47	100.66	102.49	103.23	104.48	105.52	106.39	107.76
125		118.90	124.47	125.66	127.49	128.23	129.48	130.52	131.39	132.76
160		153.90	159.47	160.66	162.49	163.23	164.48	165.52	166.39	167.76
200		193.90	199.47	200.66	202.49	203.23	204.48	205.52	206.39	207.76

DC	X.V	f_{max}
50	1.43	0.33
56	1.45	0.35
63	1.47	0.37
70	1.49	0.39
80	1.52	0.42
90	1.55	0.44
100	1.57	0.47
125	1.62	0.52
160	1.68	0.59
200	1.73	0.66

O		
DC	RPMX	APMX/I
50	4.9°	8.4/100
56	4.2°	7.2/100
63	3.6°	6.1/100
70	3.1°	5.3/100
80	2.6°	4.4/100
90	2.3°	3.9/100
100	2.0°	3.3/100
125	1.5°	2.5/100

R		
DCX	RPMX	APMX/I
59.9	4.6°	7.9/100
65.8	4.0°	6.8/100
72.9	3.0°	5.1/100
79.8	2.7°	4.6/100
89.9	2.2°	3.7/100
99.8	2.0°	3.3/100
109.9	1.8°	3.0/100
134.9	1.3°	2.1/100

O				
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
50	91.5	120.0	5.9	5.9
56	103.2	131.5	5.9	5.9
63	117.4	146.0	5.9	5.9
70	131.2	159.5	5.9	5.9
80	151.4	180.0	5.9	5.9
90	171.2	199.5	5.9	5.9
100	191.4	220.0	5.9	5.9
125	241.3	270.0	5.9	5.9

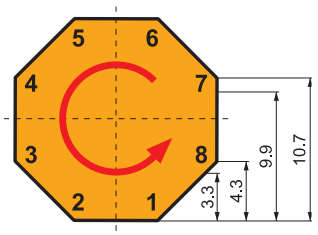
R				
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
59.9	91.5	119.5	5.9	5.9
65.8	103.5	131.0	5.9	5.9
72.9	118.0	145.5	5.9	5.9
79.8	131.5	159.0	5.9	5.9
89.9	151.5	179.5	5.9	5.9
99.8	171.5	199.0	5.9	5.9
109.9	191.5	219.5	5.9	5.9
134.9	241.5	269.5	5.9	5.9

	O	R
a_p	3.1	3.0

R

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
59.9	FE	0.848	1.095	1.548	1.896	2.189	2.681	3.096	3.461	3.792	4.378	4.895
65.8		0.889	1.147	1.622	1.987	2.294	2.810	3.245	3.628	3.974	4.589	5.130
72.9		0.935	1.207	1.708	2.091	2.415	2.958	3.415	3.818	4.183	4.830	5.400
79.8		0.979	1.263	1.787	2.188	2.527	3.095	3.573	3.995	4.376	5.053	5.650
89.9		1.039	1.341	1.896	2.322	2.682	3.285	3.793	4.240	4.645	5.364	5.997
99.8		1.094	1.413	1.998	2.447	2.826	3.461	3.996	4.468	4.894	5.651	6.318

RE	µm	3	5	10	15	20	30	40	50	60	80	100
8.0	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530



a_p	
–> 3.3	8
–> 4.3	7
–> 9.9	4
–> 10.7	2