

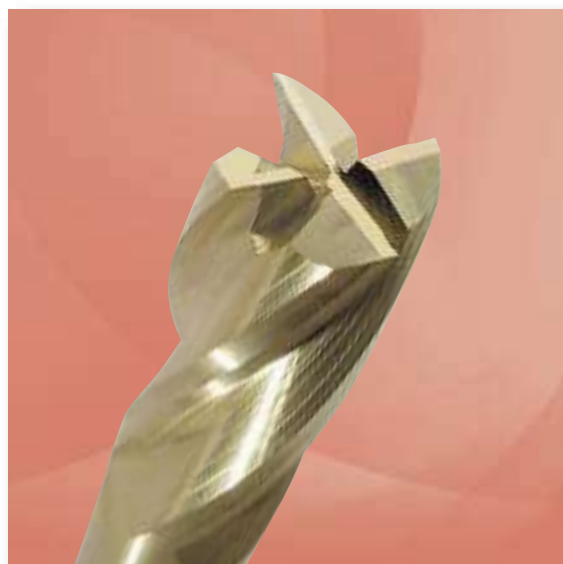


UTENSILI FRESATURA TPTOOLS

Micro frese per rame

Mini end mills for copper

Mikrofräser für kupfer
Micro fraises pour cuivre
Мини фреза концевая для меди
Mini frézy pro obrábění mědi

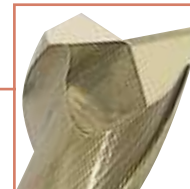


Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

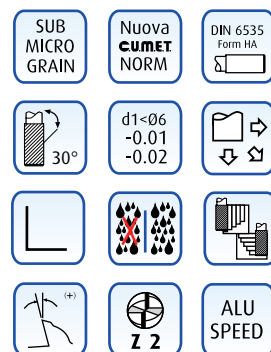
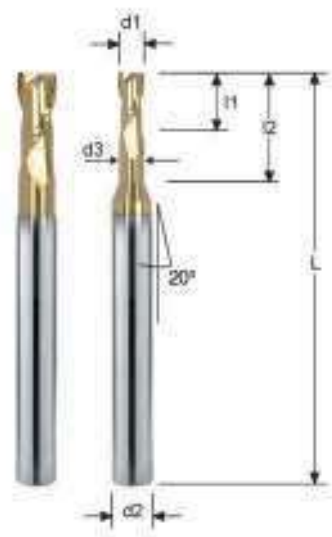
VHM-Schatfräser - Fraise carbure à bout plat

Фреза концевая твердосплавная для меди – Sk rohová fréza



CODE	*d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y800.004.02540S4	0.4	4	0.5	2.5	40	0.35	2
Y800.004.02550S4	0.4	4	0.5	2.5	50	0.35	2
Y800.005.0340S4	0.5	4	0.6	3	40	0.45	2
Y800.005.0640S4	0.5	4	0.6	6	40	0.45	2
Y800.005.0350S4	0.5	4	0.6	3	50	0.45	2
Y800.005.0650S4	0.5	4	0.6	6	50	0.45	2
Y800.006.0340S4	0.6	4	0.7	3	40	0.55	2
Y800.006.0640S4	0.6	4	0.7	6	40	0.55	2
Y800.006.0350S4	0.6	4	0.7	3	50	0.55	2
Y800.006.0650S4	0.6	4	0.7	6	50	0.55	2
Y800.008.0440S4	0.8	4	1	4	40	0.75	2
Y800.008.0740S4	0.8	4	1	7	40	0.75	2
Y800.008.0450S4	0.8	4	1	4	50	0.75	2
Y800.008.0750S4	0.8	4	1	7	50	0.75	2
Y800.010.0440S4	1	4	2	4	40	0.95	2
Y800.010.0840S4	1	4	2	8	40	0.95	2
Y800.010.1040S4	1	4	2	10	40	0.95	2
Y800.010.1240S4	1	4	2	12	40	0.95	2
Y800.010.0450S4	1	4	2	4	50	0.95	2
Y800.010.0850S4	1	4	2	8	50	0.95	2
Y800.010.1050S4	1	4	2	10	50	0.95	2
Y800.010.1250S4	1	4	2	12	50	0.95	2
Y800.015.0540S4	1.5	4	2.5	5	40	1.45	2
Y800.015.1040S4	1.5	4	2.5	10	40	1.45	2
Y800.015.0550S4	1.5	4	2.5	5	50	1.45	2
Y800.015.1050S4	1.5	4	2.5	10	50	1.45	2
Y800.015.1550S4	1.5	4	2.5	15	50	1.45	2
Y800.020.0650S4	2	4	3	6	50	1.95	2
Y800.020.1250S4	2	4	3	12	50	1.95	2
Y800.020.1650S4	2	4	3	16	50	1.95	2
Y800.030.1250S4	3	4	5	12	50	2.90	2
Y800.030.1860S4	3	4	5	18	60	2.90	2
Y800.040.1660S6	4	6	8	16	57	3.8	2
Y800.050.1760S6	5	6	10	17	57	4.5	2
Y800.06.21.60	6	6	12	21	57	5.5	2

→ Help 155

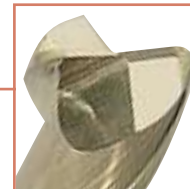


Fresa testa torica in metallo duro integrale

Solid carbide corner radius end mill

VHM-torusfräser - Fraise carbure avec rayon d'angle

Фреза концевая твердосплавная с угловым радиусом для меди - Sk fréza s rohovým rádiusem

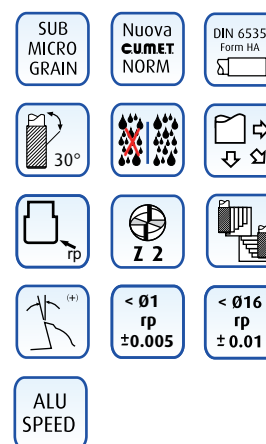
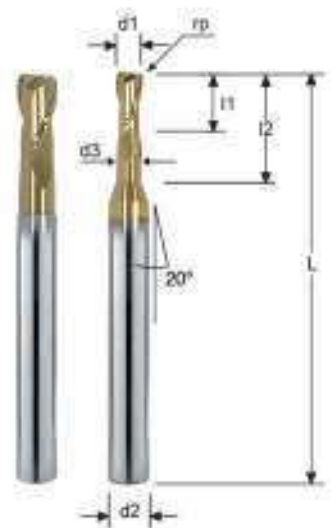


CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y800M010.0440R01	1	4	0.1	1.2	4	40	0.95	2
Y800M010.0840R01	1	4	0.1	1.2	8	40	0.95	2
Y800M010.1040R01	1	4	0.1	1.2	10	40	0.95	2
Y800M010.1240R01	1	4	0.1	1.2	12	40	0.95	2
Y800M010.0450R01	1	4	0.1	1.2	4	50	0.95	2
Y800M010.0850R01	1	4	0.1	1.2	8	50	0.95	2
Y800M010.1050R01	1	4	0.1	1.2	10	50	0.95	2
Y800M010.1250R01	1	4	0.1	1.2	12	50	0.95	2
Y800M015.0540R01	1.5	4	0.1	1.8	5	40	1.45	2
Y800M015.1040R01	1.5	4	0.1	1.8	10	40	1.45	2
Y800M015.0550R01	1.5	4	0.1	1.8	5	50	1.45	2
Y800M015.1050R01	1.5	4	0.1	1.8	10	50	1.45	2
Y800M015.1550R01	1.5	4	0.1	1.8	15	50	1.45	2
Y800M020.0650R01	2	4	0.1	2.2	6	50	1.95	2
Y800M020.1050R01	2	4	0.1	2.2	10	50	1.95	2
Y800M020.1250R01	2	4	0.1	2.2	12	50	1.95	2
Y800M020.1650R01	2	4	0.1	2.2	16	50	1.95	2
Y800M030.1250R02	3	4	0.2	7	12	50	2.90	2
Y800M030.1860R02	3	4	0.2	7	18	60	2.90	2
Y800M030.2560R02	3	4	0.2	7	25	60	2.90	2
Y800M040.1660R05	4	6	0.5	8	16	57	3.80	2
Y800M040.2060R05	4	6	0.5	8	20	57	3.80	2
Y800M050.1760R05	5	6	0.5	10	17	57	4.50	2
Y800M06.21.60R1	6	6	1	12	21	57	5.50	2
Y800M08.25.63R1	8	8	1	16	25	63	7.80	2
Y800M10.30.72R1	10	10	1	20	30	72	9.50	2
Y800M12.38.83R15	12	12	1.5	23	38	83	11.5	2
Y800M16.40100R15	16	16	1.5	26	40	100	15.5	2

→ Help 155

*d1 < Ø 6 = -0.01 / -0.02

d1 ≤ Ø 16 = f7

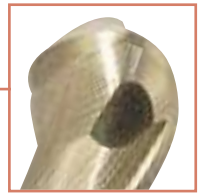


Fresa testa sferica 3D in metallo duro integrale

Solid carbide 3D ball nose end mill

VHM-3D Radiusfräser - Fraise carbure 3D à bout hémisphérique

Фреза концевая твердосплавная радиусная 3D для меди - Sk 3D kulová fréza

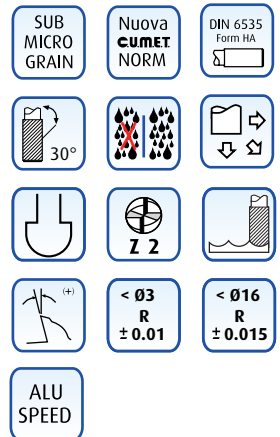
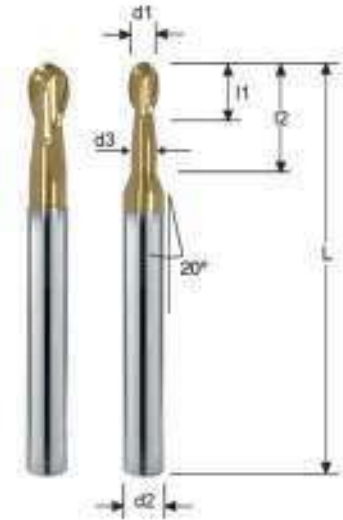


CODE	*d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y800R003.0240S4	0.3	4	0.4	2	40	0.25	2
Y800R003.0440S4	0.3	4	0.4	4	40	0.25	2
Y800R003.0250S4	0.3	4	0.4	2	50	0.25	2
Y800R003.0450S4	0.3	4	0.4	4	50	0.25	2
Y800R004.01540S4	0.4	4	0.4	1.5	40	0.35	2
Y800R004.01550S4	0.4	4	0.4	1.5	50	0.35	2
Y800R005.0240S4	0.5	4	0.6	2	40	0.45	2
Y800R005.0540S4	0.5	4	0.6	5	40	0.45	2
Y800R005.0250S4	0.5	4	0.6	2	50	0.45	2
Y800R005.0550S4	0.5	4	0.6	5	50	0.45	2
Y800R006.0240S4	0.6	4	0.7	2	40	0.55	2
Y800R006.0540S4	0.6	4	0.7	5	40	0.55	2
Y800R006.0250S4	0.6	4	0.7	2	50	0.55	2
Y800R006.0550S4	0.6	4	0.7	5	50	0.55	2
Y800R008.0440S4	0.8	4	0.8	4	40	0.75	2
Y800R008.0840S4	0.8	4	0.8	8	40	0.75	2
Y800R008.0450S4	0.8	4	0.8	4	50	0.75	2
Y800R008.0850S4	0.8	4	0.8	8	50	0.75	2
Y800R010.0440S4	1	4	1.2	4	40	0.95	2
Y800R010.0840S4	1	4	1.2	8	40	0.95	2
Y800R010.1040S4	1	4	1.2	10	40	0.95	2
Y800R010.1240S4	1	4	1.2	12	40	0.95	2
Y800R010.0450S4	1	4	1.2	4	50	0.95	2
Y800R010.0850S4	1	4	1.2	8	50	0.95	2
Y800R010.1050S4	1	4	1.2	10	50	0.95	2
Y800R010.1250S4	1	4	1.2	12	50	0.95	2
Y800R015.0540S4	1.5	4	1.8	5	40	1.45	2
Y800R015.1040S4	1.5	4	1.8	10	40	1.45	2
Y800R015.0550S4	1.5	4	1.8	5	50	1.45	2
Y800R015.1050S4	1.5	4	1.8	10	50	1.45	2
Y800R015.1550S4	1.5	4	1.8	15	50	1.45	2
Y800R020.0650S4	2	4	4	6	50	1.95	2
Y800R020.1050S4	2	4	4	10	50	1.95	2
Y800R020.1250S4	2	4	4	12	50	1.95	2
Y800R020.1650S4	2	4	4	16	50	1.95	2
Y800R030.1250S4	3	4	6	12	50	2.9	2
Y800R030.1860S4	3	4	6	18	60	2.9	2
Y800R040.1660S6	4	6	8	16	57	3.8	2
Y800R050.1760S6	5	6	10	17	57	4.5	2
Y800R06.21.60	6	6	12	21	57	5.5	2
Y800R08.25.63	8	8	16	25	63	7.5	2
Y800R10.30.72	10	10	20	30	72	9.5	2
Y800R12.38.83	12	12	24	38	83	11.5	2
Y800R16.40.100	16	16	26	40	100	15.5	2

→ Help 156

*d1 < ø 6 = -0.01 / -0.02

d1 ≤ ø16 = f7



In questa sezione viene utilizzato un speciale rivestimento a basso coefficiente d'attrito ed una geometria specifica per ottimizzare la lavorazione del rame in sgrossatura e finitura.

On this section is used a special coating with low friction coefficient, specific geometry to optimize the processing of copper in roughing and finishing.

In diesem Abschnitt wird eine besondere Beschichtung mit einem niedrigen Reibungskoeffizienten und eine spezifische Geometrie, die Verarbeitung von Kupfer in Schruppen und Schlichten optimiert.

Cette section utilise un revêtement spécial pour le coefficient de frottement faible et une géométrie spécifique pour optimiser le traitement du cuivre dans l'ébauche et la finition.

Специальное покрытие с низким коэффициентом трения, оригинальная геометрия для оптимизации черновой и чистовой операции обработки меди.

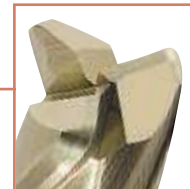
V této části je použit speciální povlak s nízkým koeficientem tření, specifická geometrie pro optimalizaci obrábění mědi v hrubování a dokončování.

Fresa testa torica in metallo duro integrale

Solid carbide corner radius end mill

VHM-torusfräser - Fraise carbure avec rayon d'angle

Фреза концевая твердосплавная с угловым радиусом для меди - Sk fréza s rohovým rádiusem



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y803M040.2060R05	4	6	0.5	8	20	57	3.80	3
Y803M050.1760R05	5	6	0.5	10	17	57	4.50	3
Y803M06.21.60R1	6	6	1	12	21	57	5.50	3
Y803M08.25.63R1	8	8	1	16	25	63	7.80	3
Y803M10.30.72R1	10	10	1	20	30	72	9.50	3
Y803M12.38.83R15	12	12	1.5	23	38	83	11.5	3
Y803M16.40100R15	16	16	1.5	26	40	100	15.5	3

*d1 < ø 6 = -0.01 / -0.02

d1 ≤ ø 16 = f7

→ Help 155



Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

VHM-Schatfräser - Fraise carbure à bout plat

Фреза концевая твердосплавная для меди - Sk rohová fréza



CODE	*d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y804.040.1660S6	4	6	8	16	57	3.8	4
Y804.050.1760S6	5	6	10	17	57	4.5	4
Y804.06.21.60	6	6	12	21	57	5.5	4
Y804.08.25.63	8	8	16	25	63	7.8	4
Y804.08.25.75	8	8	16	25	75	7.8	4
Y804.10.30.72	10	10	20	30	72	9.5	4
Y804.10.30.100	10	10	20	30	100	9.5	4
Y804.12.38.83	12	12	22	38	83	11.5	4
Y804.12.38.100	12	12	22	38	100	11.5	4
Y804.16.40.100	16	16	26	40	100	15.5	4

*d1 < ø 6 = -0.01 / -0.02

d1 ≤ ø 16 = f7

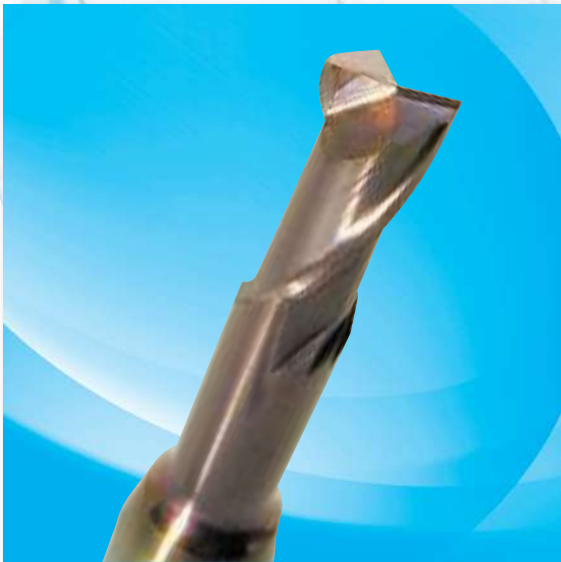
→ Help 155



Micro frese per acciaio

Mini end mills for steel

Mikrofräser für stahl
Micro fraises pour acier
Мини фреза концевая для стали
Mini fréza pro ocel



Microfresa testa torica in metallo duro integrale gambo Ø 3 mm

Solid carbide miniature corner radius end mill, shank Ø 3 mm

VHM - Mini Schafffräser mit Eckenradius, Schaft Ø 3 mm - Microfraise carbure avec rayon d'angle, queue Ø 3 mm

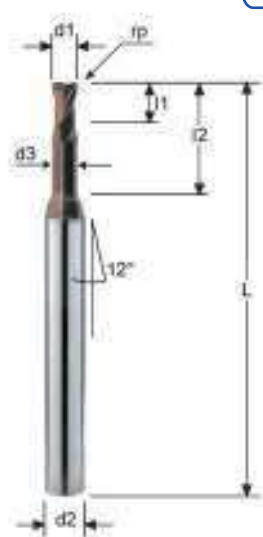
Мини-фреза концевая твердосплавная с угловым радиусом, хвостовик Ø 3 mm

Sk miniaturní fréza s rohovým rádiusem se stopkou Ø 3 mm



CODE	d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
200M.004	0.4	3	-	0.6	-	50	-	2
200ML.004	0.4	3	-	0.6	1,5	50	0.35	2
200M.005	0.5	3	0.05	0.7	-	50	-	2
200ML.005	0.5	3	0.05	0.7	2,5	50	0.45	2
200MXL.005	0.5	3	0.05	0.7	4	50	0.45	2
200MSL.005	0.5	3	0.05	0.7	7,5	50	0.45	2
200M.006	0.6	3	0.05	0.9	-	50	-	2
200ML.006	0.6	3	0.05	0.9	5	50	0.55	2
200M.008	0.8	3	0.05	1.2	-	50	-	2
200ML.008	0.8	3	0.05	1.2	4	50	0.75	2
200MXL.008	0.8	3	0.05	1.2	7	50	0.75	2
200MSL.008	0.8	3	0.05	1.2	12	50	0.75	2
200M.010	1.0	3	0.10	1.5	-	50	-	2
200ML.010	1.0	3	0.10	1.5	5	50	0.95	2
200MXL.010	1.0	3	0.10	1.5	8,5	50	0.95	2
200M.012	1.2	3	0.10	1.8	-	50	-	2
200ML.012	1.2	3	0.10	1.8	6	50	1.15	2
200MXL.012	1.2	3	0.10	1.8	10	50	1.15	2
200M.015	1.5	3	0.15	2.2	-	50	-	2
200ML.015	1.5	3	0.15	2.2	7,5	50	1.45	2
200MXL.015	1.5	3	0.15	2.2	12	50	1.45	2
200M.020	2.0	3	0.15	2.2	-	50	-	2
200ML.020	2.0	3	0.15	2.2	10	50	1.95	2
200MXL.020	2.0	3	0.15	2.2	16	50	1.95	2
200M.025	2.5	3	0.15	3.0	-	50	-	2
200ML.025	2.5	3	0.15	3.0	15	50	2.45	2

→ Help 158



HRC < 60

CAST IRON

NI-Alloy

INOX Stainless Steel

SUB MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

20°

d1 -0.01 -0.02

HSC HHC

rp

Z 2

GOLD

< Ø1 rp ±0.005

< Ø6 rp ±0.01

Microfresa testa sferica 3D in metallo duro integrale gambo Ø 3 mm

Solid carbide 3D miniature ball nose end mill, shank Ø 3 mm

VHM - 3D Mini Radiusfräser, Schaft Ø 3 mm - Microfraise carbure mini 3D, hémisphérique, queue Ø 3 mm

Мини-фреза концевая твердосплавная полусферическая 3D, хвостовик Ø 3 mm

Sk 3D miniaturní kulová fréza se stopkou Ø 3 mm



CODE	d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
200RM.004	0.4	3	0.4	-	50	-	2
200RML.004	0.4	3	0.4	1.5	50	0.35	2
200RM.005	0.5	3	0.5	-	50	-	2
200RML.005	0.5	3	0.5	2.5	50	0.45	2
200RMXL.005	0.5	3	0.5	4	50	0.45	2
200RMSL.005	0.5	3	0.5	7.5	50	0.45	2
200RM.006	0.6	3	0.6	-	50	-	2
200RML.006	0.6	3	0.6	5	50	0.55	2
200RM.008	0.8	3	0.8	-	50	-	2
200RML.008	0.8	3	0.8	4	50	0.75	2
200RMXL.008	0.8	3	0.8	7	50	0.75	2
200RMSL.008	0.8	3	0.8	12	50	0.75	2
200RM.010	1.0	3	1.0	-	50	-	2
200RML.010	1.0	3	1.0	5	50	0.95	2
200RMXL.010	1.0	3	1.0	8.5	50	0.95	2
200RMSL.010	1.0	3	1.0	15	50	0.95	2
200RM.012	1.2	3	1.2	-	50	-	2
200RML.012	1.2	3	1.2	6	50	1.15	2
200RMXL.012	1.2	3	1.2	10	50	1.15	2
200RM.015	1.5	3	1.5	-	50	-	2
200RML.015	1.5	3	1.5	7.5	50	1.45	2
200RMXL.015	1.5	3	1.5	12	50	1.45	2
200RMSL.015	1.5	3	1.5	20	50	1.45	2
200RM.020	2.0	3	2.0	-	50	-	2
200RML.020	2.0	3	2.0	10	50	1.95	2
200RMXL.020	2.0	3	2.0	16	50	1.95	2
200RM.025	2.5	3	2.5	-	50	-	2
200RML.025	2.5	3	2.5	15	50	2.45	2

→ Help 159



HRC < 60

CAST IRON

NI-Alloy

INOX Stainless Steel

SUB MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

20°

d1 -0.01 -0.02

HSC HHC

rp

Z 2

GOLD

< Ø1 rp ±0.005

< Ø3 rp ±0.01

Microfresa testa piana in metallo duro integrale gambo Ø 4-6 mm

Solid carbide mini flat nose end mill shank Ø 4-6 mm

VHM – Mini gesenkräser, shaft Ø 4-6 mm - Microfraise carbure à bout plat queue Ø 4-6 mm

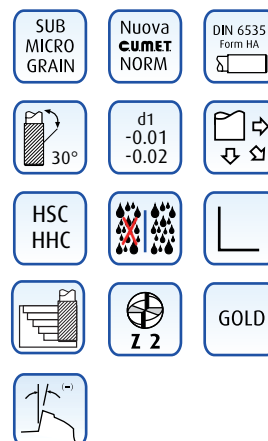
Микро фреза концевая твердосплавная с плоским торцом, хвостовик Ø 4-6 mm

Sk minirí rohová fréza se stopkou Ø 4-6 mm



CODE	d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
205PM001.002S4	0.1	4	0.2	-	50	-	2
205PM001.015S4	0.1	4	0.15	1	50	0.08	2
205PM001.025S4	0.1	4	0.15	2	50	0.08	2
205PM0015.002S4	0.15	4	0.2	-	50	-	2
205PM002.004S4	0.2	4	0.4	-	50	-	2
205PM002.015S4	0.2	4	0.3	1	50	0.15	2
205PM002.025S4	0.2	4	0.3	2	50	0.15	2
205PM003.015S4	0.3	4	0.4	1	50	0.25	2
205PM003.025S4	0.3	4	0.4	2	50	0.25	2
205PM003.035S4	0.3	4	0.4	3	50	0.25	2
205PM004.015S4	0.4	4	0.6	1	50	0.35	2
205PM004.025S4	0.4	4	0.6	2	50	0.35	2
205PM004.035S4	0.4	4	0.6	3	50	0.35	2
205PM004.045S4	0.4	4	0.6	4	50	0.35	2
205PM004.055S4	0.4	4	0.6	5	50	0.35	2
205PM005.025S4	0.5	4	0.8	2	50	0.45	2
205PM005.035S4	0.5	4	0.8	3	50	0.45	2
205PM005.045S4	0.5	4	0.8	4	50	0.45	2
205PM005.055S4	0.5	4	0.8	5	50	0.45	2
205PM005.065S4	0.5	4	0.8	6	50	0.45	2
205PM005.085S4	0.5	4	0.8	8	50	0.45	2
205PM005.105S4	0.5	4	0.8	10	50	0.45	2
205PM006.012S4	0.6	4	1.2	-	50	-	2
205PM006.025S4	0.6	4	0.9	2	50	0.55	2
205PM006.035S4	0.6	4	0.9	3	50	0.55	2
205PM006.045S4	0.6	4	0.9	4	50	0.55	2
205PM006.055S4	0.6	4	0.9	5	50	0.55	2
205PM006.065S4	0.6	4	0.9	6	50	0.55	2
205PM006.085S4	0.6	4	0.9	8	50	0.55	2
205PM006.105S4	0.6	4	0.9	10	50	0.55	2
205PM008.025S4	0.8	4	1.2	2	50	0.75	2
205PM008.045S4	0.8	4	1.2	4	50	0.75	2
205PM008.065S4	0.8	4	1.2	6	50	0.75	2
205PM008.085S4	0.8	4	1.2	8	50	0.75	2
205PM008.105S4	0.8	4	1.2	10	50	0.75	2
205PM010.025S4	1.0	4	1.5	2	50	0.95	2
205PM010.025S6	1.0	6	1.5	2.5	50	0.95	2
205PM010.035S4	1.0	4	1.5	3	50	0.95	2
205PM010.045S4	1.0	4	1.5	4	50	0.95	2
205PM010.065S4	1.0	4	1.5	6	50	0.95	2
205PM010.105S4	1.0	4	1.5	10	50	0.95	2
205PM010.145S4	1.0	4	1.5	14	50	0.95	2
205PM010.165S4	1.0	4	1.5	16	60	0.95	2
205PM010.185S4	1.0	4	1.5	18	60	0.95	2
205PM010.205S4	1.0	4	1.5	20	60	0.95	2
205PM012.004S4	1.2	4	4	-	50	-	2
205PM012.035S4	1.2	4	1.8	3	50	1.15	2
205PM012.045S4	1.2	4	1.8	4	50	1.15	2
205PM012.065S4	1.2	4	1.8	6	50	1.15	2
205PM012.085S4	1.2	4	1.8	8	50	1.15	2
205PM012.105S4	1.2	4	1.8	10	50	1.15	2
205PM012.125S4	1.2	4	1.8	12	50	1.15	2
205PM012.165S4	1.2	4	1.8	16	60	1.15	2

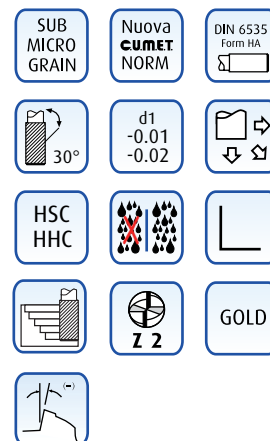
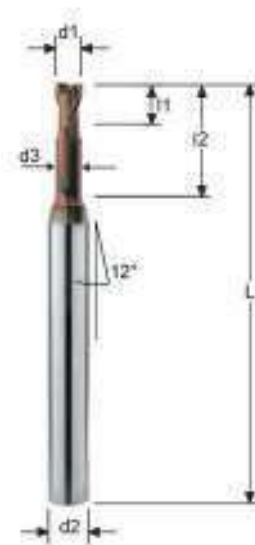
by exaustion



→ Help 157

CODE	d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
205PM013.04S4	1.3	4	4	-	50	-	2
205PM015.004S4	1.5	4	4	-	50	-	2
205PM015.04S6	1.5	6	4	-	50	1.45	2
205PM015.05S4	1.5	4	2.2	5	50	1.45	2
205PM015.08S4	1.5	4	2.2	8	50	1.45	2
205PM015.10S4	1.5	4	2.2	10	50	1.45	2
205PM015.12S4	1.5	4	2.2	12	50	1.45	2
205PM015.16S4	1.5	4	2.2	16	60	1.45	2
205PM015.18S4	1.5	4	2.2	18	60	1.45	2
205PM018.05S4	1.8	4	5.0	-	50	-	2
205PM020.006S4	2.0	4	6.0	-	50	-	2
205PM020.04S4	2.0	4	3.0	4	50	1.95	2
205PM020.06S4	2.0	4	3.0	6	50	1.95	2
205PM020.08S4	2.0	4	3.0	8	50	1.95	2
205PM020.10S4	2.0	4	3.0	10	50	1.95	2
205PM020.14S4	2.0	4	3.0	14	50	1.95	2
205PM020.16S4	2.0	4	3.0	16	60	1.95	2
205PM020.18S4	2.0	4	3.0	18	60	1.95	2
205PM020.20S4	2.0	4	3.0	20	60	1.95	2
205PM020.30S4	2.0	4	3.0	30	70	1.95	2
205PM025.08S4	2.5	4	8.0	-	50	-	2
205PM025.10S6	2.5	6	3.5	10	50	2.45	2
205PM025.14S6	2.5	6	3.5	14	57	2.45	2
205PM025.20S6	2.5	6	3.5	20	57	2.45	2
205PM025.25S6	2.5	6	3.5	25	70	2.45	2
205PM030.08S4	3.0	4	8.0	-	50	-	2
205PM030.06S6	3.0	6	4.0	6	50	2.95	2
205PM030.12S6	3.0	6	4.0	12	50	2.95	2
205PM030.14S6	3.0	6	4.0	14	57	2.95	2
205PM030.18S6	3.0	6	4.0	18	57	2.95	2
205PM030.20S6	3.0	6	4.0	20	57	2.95	2
205PM030.25S6	3.0	6	4.0	25	70	2.95	2
205PM030.30S6	3.0	6	4.0	30	70	2.95	2
205PM030.35S6	3.0	6	4.0	35	80	2.95	2
205PM030.40S6	3.0	6	4.0	40	80	2.95	2
205PM040.10S4	4.0	4	10.0	-	50	-	2
205PM040.08S6	4.0	6	6.0	8	50	3.85	2
205PM040.10S6	4.0	6	6.0	10	50	3.85	2
205PM040.12S6	4.0	6	6.0	12	50	3.85	2
205PM040.14S6	4.0	6	6.0	14	57	3.85	2
205PM040.16S6	4.0	6	6.0	16	57	3.85	2
205PM040.18S6	4.0	6	6.0	18	57	3.85	2
205PM040.20S6	4.0	6	6.0	20	57	3.85	2
205PM040.25S6	4.0	6	6.0	25	70	3.85	2
205PM040.30S6	4.0	6	6.0	30	70	3.85	2
205PM040.40S6	4.0	6	6.0	40	80	3.85	2
205PM040.45S6	4.0	6	6.0	45	90	3.85	2

→ Help 157



Microfresa testa torica in metallo duro integrale gambo Ø 4-6 mm

Solid carbide mini corner radius end mill shank Ø 4-6 mm

VHM – Mini torusfräser, shaft Ø 4-6 mm - Microfraise carbure avec rayon d'angle, queue Ø 4-6 mm

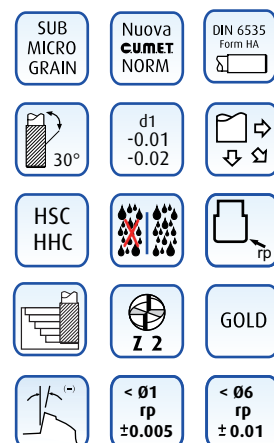
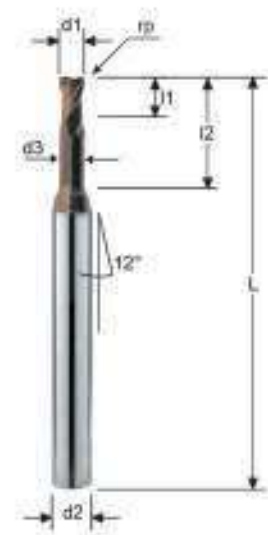
Микро фреза концевая твердосплавная с угловым радиусом, хвостовик Ø 4-6 mm

Sk minifréza s rohovým rádiusem se stopkou Ø 4-6 mm



CODE	d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
205M006.01R005S4	0.6	4	0.05	1.0	-	50	-	2
205M009.015R005S4	0.9	4	0.05	1.5	-	50	-	2
205M010.025R01S4	1.0	4	0.1	2.5	-	50	-	2
205M010.025R02S4	1.0	4	0.2	2.5	-	50	-	2
205M010.025R03S4	1.0	4	0.3	2.5	-	50	-	2
205M010.04R01S4	1.0	4	0.1	1.5	4	50	0.95	2
205M010.04R02S4	1.0	4	0.2	1.5	4	50	0.95	2
205M010.06R03S4	1.0	4	0.3	1.5	6	50	0.95	2
205M010.08R01S4	1.0	4	0.1	1.5	8	50	0.95	2
205M010.08R02S4	1.0	4	0.2	1.5	8	50	0.95	2
205M010.10R01S4	1.0	4	0.1	1.5	10	50	0.95	2
205M010.10R02S4	1.0	4	0.2	1.5	10	50	0.95	2
205M010.12R01S4	1.0	4	0.1	1.5	12	50	0.95	2
205M010.12R02S4	1.0	4	0.2	1.5	12	50	0.95	2
205M010.12R03S4	1.0	4	0.3	1.5	12	50	0.95	2
205M015.03R01S4	1.5	4	0.1	3.0	-	50	-	2
205M015.03R02S4	1.5	4	0.2	3.0	-	50	-	2
205M015.03R03S4	1.5	4	0.3	3.0	-	50	-	2
205M015.03R05S4	1.5	4	0.5	3.0	-	50	-	2
205M015.06R01S4	1.5	4	0.1	2.2	6	50	1.45	2
205M015.06R02S4	1.5	4	0.2	2.2	6	50	1.45	2
205M015.06R03S4	1.5	4	0.3	2.2	6	50	1.45	2
205M015.08R02S4	1.5	4	0.2	2.2	8	50	1.45	2
205M015.08R03S4	1.5	4	0.3	2.2	8	50	1.45	2
205M015.10R02S4	1.5	4	0.2	2.2	10	50	1.45	2
205M015.10R03S4	1.5	4	0.3	2.2	10	50	1.45	2
205M015.12R02S4	1.5	4	0.2	2.2	12	50	1.45	2
205M015.16R02S4	1.5	4	0.2	2.2	16	50	1.45	2
205M020.05R01S4	2.0	4	0.1	5.0	-	50	-	2
205M020.05R02S4	2.0	4	0.2	5.0	-	50	-	2
205M020.05R05S4	2.0	4	0.5	5.0	-	50	-	2
205M020.06R01S4	2.0	4	0.1	3.0	6	50	1.95	2
205M020.06R02S4	2.0	4	0.2	3.0	6	50	1.95	2
205M020.06R03S4	2.0	4	0.3	3.0	6	50	1.95	2
205M020.06R05S4	2.0	4	0.5	3.0	6	50	1.95	2
205M020.08R01S4	2.0	4	0.1	3.0	8	50	1.95	2
205M020.08R02S4	2.0	4	0.2	3.0	8	50	1.95	2
205M020.08R03S4	2.0	4	0.3	3.0	8	50	1.95	2
205M020.08R05S4	2.0	4	0.5	3.0	8	50	1.95	2
205M020.10R01S4	2.0	4	0.1	3.0	10	50	1.95	2
205M020.10R02S4	2.0	4	0.2	3.0	10	50	1.95	2
205M020.10R03S4	2.0	4	0.3	3.0	10	50	1.95	2
205M020.10R05S4	2.0	4	0.5	3.0	10	50	1.95	2
205M020.12R01S4	2.0	4	0.1	3.0	12	50	1.95	2
205M020.12R02S4	2.0	4	0.2	3.0	12	50	1.95	2
205M020.12R03S4	2.0	4	0.3	3.0	12	50	1.95	2
205M020.12R05S4	2.0	4	0.5	3.0	12	50	1.95	2
205M020.16R05S4	2.0	4	0.5	3.0	16	60	1.95	2
205M025.06R02S6	2.5	6	0.2	6.0	-	50	-	2
205M025.06R03S6	2.5	6	0.3	6.0	-	50	-	2
205M025.06R05S6	2.5	6	0.5	6.0	-	50	-	2
205M030.08R02S6	3.0	6	0.2	8.0	-	50	-	2

→ Help 158



Microfresa testa torica in metallo duro integrale gambo Ø 4-6 mm

Solid carbide mini corner radius end mill shank Ø 4-6 mm

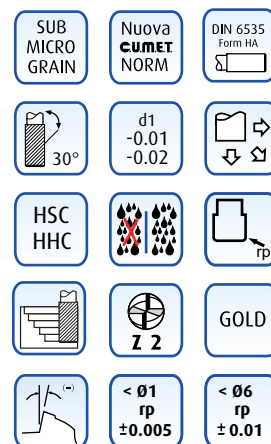
VHM – Mini torusfräser, shaft Ø 4-6 mm - Microfraise carbure avec rayon d'angle, queue Ø 4-6 mm

Микро фреза концевая твердосплавная с угловым радиусом, хвостовик Ø 4-6 mm

Sk mini fréza s rohovým rádiusem se stopkou Ø 4-6 mm



CODE	d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
205M030.08R03S6	3.0	6	0.3	8.0	-	50	-	2
205M030.08R05S6	3.0	6	0.5	8.0	-	50	-	2
205M030.08R1S6	3.0	6	1.0	8.0	-	50	-	2
205M030.10R01S6	3.0	6	0.1	4.0	10	57	2.85	2
205M030.10R02S6	3.0	6	0.2	4.0	10	57	2.85	2
205M030.10R03S6	3.0	6	0.3	4.0	10	57	2.85	2
205M030.10R05S6	3.0	6	0.5	4.0	10	57	2.85	2
205M030.12R01S6	3.0	6	0.1	4.0	12	57	2.85	2
205M030.12R02S6	3.0	6	0.2	4.0	12	57	2.85	2
205M030.12R05S6	3.0	6	0.5	4.0	12	57	2.85	2
205M030.16R01S6	3.0	6	0.1	4.0	16	57	2.85	2
205M030.16R02S6	3.0	6	0.2	4.0	16	57	2.85	2
205M030.16R03S6	3.0	6	0.3	4.0	16	57	2.85	2
205M030.16R05S6	3.0	6	0.5	4.0	16	57	2.85	2
205M030.20R02S6	3.0	6	0.2	4.0	20	57	2.85	2
205M030.20R03S6	3.0	6	0.3	4.0	20	57	2.85	2
205M030.20R05S6	3.0	6	0.5	4.0	20	57	2.85	2
205M040.08R01S6	4.0	6	0.1	8.0	-	50	-	2
205M040.08R02S6	4.0	6	0.2	8.0	-	50	-	2
205M040.08R03S6	4.0	6	0.3	8.0	-	50	-	2
205M040.08R05S6	4.0	6	0.5	8.0	-	50	-	2
205M040.08R1S6	4.0	6	1.0	8.0	-	50	-	2
205M040.12R01S6	4.0	6	0.1	6.0	12	50	3.85	2
205M040.12R02S6	4.0	6	0.2	6.0	12	50	3.85	2
205M040.12R05S6	4.0	6	0.5	6.0	12	50	3.85	2
205M040.16R01S6	4.0	6	0.1	6.0	16	57	3.85	2
205M040.16R02S6	4.0	6	0.2	6.0	16	57	3.85	2
205M040.16R03S6	4.0	6	0.3	6.0	16	57	3.85	2
205M040.16R05S6	4.0	6	0.5	6.0	16	57	3.85	2
205M040.20R02S6	4.0	6	0.2	6.0	20	57	3.85	2
205M040.20R03S6	4.0	6	0.3	6.0	20	57	3.85	2
205M040.20R05S6	4.0	6	0.5	6.0	20	57	3.85	2
205M040.25R02S6	4.0	6	0.2	6.0	25	70	3.85	2
205M040.25R03S6	4.0	6	0.3	6.0	25	70	3.85	2
205M040.25R05S6	4.0	6	0.5	6.0	25	70	3.85	2
205M050.10R05S6	5.0	6	0.5	10.0	-	57	-	2
205M060.12R01S6	6.0	6	0.1	12.0	-	57	-	2
205M060.12R02S6	6.0	6	0.2	12.0	-	57	-	2
205M060.12R03S6	6.0	6	0.3	12.0	-	57	-	2
205M060.12R05S6	6.0	6	0.5	12.0	-	57	-	2
205M060.12R1S6	6.0	6	1.0	12.0	-	57	-	2
205M060.12R15S6	6.0	6	1.5	12.0	-	57	-	2
205M060.12R2S6	6.0	6	2.0	12.0	-	57	-	2
205M060.16R01S6	6.0	6	0.1	8.0	16	57	5.85	2
205M060.16R02S6	6.0	6	0.2	8.0	16	57	5.85	2
205M060.16R03S6	6.0	6	0.3	8.0	16	57	5.85	2
205M060.16R05S6	6.0	6	0.5	8.0	16	57	5.85	2
205M060.16R1S6	6.0	6	1.0	8.0	16	57	5.85	2
205M060.16R15S6	6.0	6	1.5	8.0	16	57	5.85	2
205M060.20R01S6	6.0	6	0.1	8.0	20	57	5.85	2
205M060.20R02S6	6.0	6	0.2	8.0	20	57	5.85	2
205M060.20R03S6	6.0	6	0.3	8.0	20	57	5.85	2
205M060.20R05S6	6.0	6	0.5	8.0	20	57	5.85	2
205M060.20R1S6	6.0	6	1.0	8.0	20	57	5.85	2
205M060.20R15S6	6.0	6	1.5	8.0	20	57	5.85	2
205M060.25R1S6	6.0	6	1.0	8.0	25	70	5.85	2
205M060.25R15S6	6.0	6	1.5	8.0	25	70	5.85	2
205M060.30R1S6	6.0	6	1.0	8.0	30	70	5.85	2
205M060.30R15S6	6.0	6	1.5	8.0	30	70	5.85	2



→ Help 158

Microfresa testa sferica 3D in metallo duro integrale gambo Ø 4-6 mm

Solid carbide mini 3D ball nose end mill shank Ø 4-6 mm

VHM – 3D Mini Radiusfräser, shaft Ø 4-6 mm - Microfraise carbure mini 3D hémisphérique, queue Ø 4-6 mm

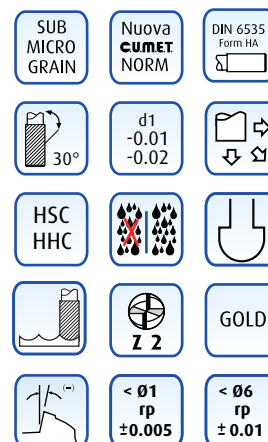
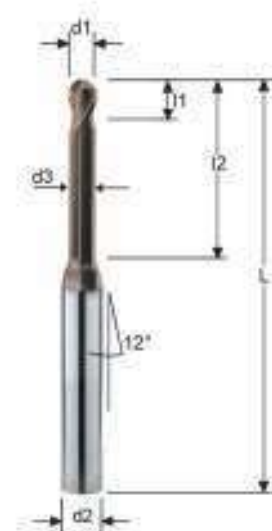
Микро фреза концевая твердосплавная радиусная 3D, хвостовик Ø 4-6 mm

Sk mini 3D kulová se stopkou Ø 4-6 mm



CODE	d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
205RM001.0012S4	0.1	4	0.12	-	50	-	2
205RM001.01S4	0.1	4	0.12	1	50	0.08	2
205RM001.02S4	0.1	4	0.12	2	50	0.08	2
205RM0015.0018S4	0.15	4	0.18	-	50	-	2
205RM003.004S4	0.3	4	0.4	-	50	0.25	2
205RM003.01S4	0.3	4	0.4	1	50	0.25	2
205RM003.02S4	0.3	4	0.4	2	50	0.25	2
205RM004.005S4	0.4	4	0.5	-	50	-	2
205RM004.02S4	0.4	4	0.5	2	50	0.35	2
205RM004.04S4	0.4	4	0.5	4	50	0.35	2
205RM004.05S4	0.4	4	0.5	5	50	0.35	2
205RM005.01S4	0.5	4	0.6	1	50	0.45	2
205RM005.02S4	0.5	4	0.6	2	50	0.45	2
205RM005.03S4	0.5	4	0.6	3	50	0.45	2
205RM005.04S4	0.5	4	0.6	4	50	0.45	2
205RM005.05S4	0.5	4	0.6	5	50	0.45	2
205RM005.06S4	0.5	4	0.6	6	50	0.45	2
205RM005.08S4	0.5	4	0.6	8	50	0.45	2
205RM006.01S4	0.6	4	0.7	1	50	-	2
205RM006.02S4	0.6	4	0.7	2	50	0.55	2
205RM006.03S4	0.6	4	0.7	3	50	0.55	2
205RM006.04S4	0.6	4	0.7	4	50	0.55	2
205RM006.05S4	0.6	4	0.7	5	50	0.55	2
205RM006.06S4	0.6	4	0.7	6	50	0.55	2
205RM006.08S4	0.6	4	0.7	8	50	0.55	2
205RM006.10S4	0.6	4	0.7	10	50	0.55	2
205RM007.03S4	0.7	4	0.8	3	50	0.65	2
205RM008.01S4	0.8	4	0.9	1	50	-	2
205RM008.02S4	0.8	4	0.9	2	50	0.75	2
205RM008.03S4	0.8	4	0.9	3	50	0.75	2
205RM008.04S4	0.8	4	0.9	4	50	0.75	2
205RM008.06S4	0.8	4	0.9	6	50	0.75	2
205RM008.08S4	0.8	4	0.9	8	50	0.75	2
205RM008.10S4	0.8	4	0.9	10	50	0.75	2
205RM010.002S4	1.0	4	2.0	-	50	-	2
205RM010.02S6	1.0	6	2.0	-	50	-	2
205RM010.02S4	1.0	4	1.2	2	50	0.95	2
205RM010.03S4	1.0	4	1.2	3	50	0.95	2
205RM010.04S4	1.0	4	1.2	4	50	0.95	2
205RM010.05S4	1.0	4	1.2	5	50	0.95	2
205RM010.06S4	1.0	4	1.2	6	50	0.95	2
205RM010.08S4	1.0	4	1.2	8	50	0.95	2

by exhaustion



→ Help 159

Microfresa testa sferica 3D in metallo duro integrale gambo Ø 4-6 mm

Solid carbide mini 3D ball nose end mill shank Ø 4-6 mm

VHM – 3D Mini Radiusfräser, shaft Ø 4-6 mm - Microfraise carbure mini 3D hémisphérique, queue Ø 4-6 mm

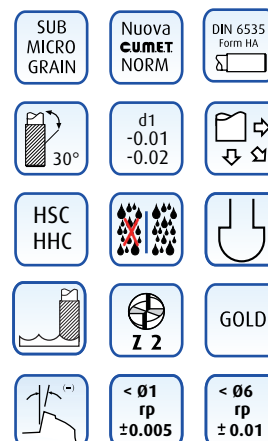
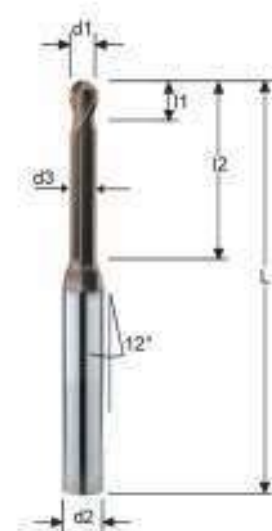
Микро фреза концевая твердосплавная радиусная 3D, хвостовик Ø 4-6 mm

Sk mini 3D kulová se stopkou Ø 4-6 mm



CODE	d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
205RM010.10S4	1.0	4	1.2	10	50	0.95	2
205RM010.12S4	1.0	4	1.2	12	50	0.95	2
205RM010.16S4	1.0	4	1.2	16	60	0.95	2
205RM010.20S4	1.0	4	1.2	20	60	0.95	2
205RM012.003S4	1.2	4	3.0	-	50	-	2
205RM012.03S4	1.2	4	1.4	3	50	1.15	2
205RM014.03S4	1.4	4	3.0	-	50	-	2
205RM014.08S4	1.4	4	1.7	8	50	1.35	2
205RM015.03S4	1.5	4	1.8	3	50	1.45	2
205RM015.03S6	1.5	6	3.0	-	50	1.45	2
205RM015.06S4	1.5	4	1.8	6	50	1.45	2
205RM015.08S4	1.5	4	1.8	8	50	1.45	2
205RM015.10S4	1.5	4	1.8	10	50	1.45	2
205RM015.16S4	1.5	4	1.8	16	60	1.45	2
205RM015.20S4	1.5	4	1.8	20	60	1.45	2
205RM016.03S4	1.6	4	3.0	-	50	-	2
205RM016.10S4	1.6	4	1.9	10	50	1.55	2
205RM018.04S4	1.8	4	4.0	-	50	-	2
205RM019.04S4	1.9	4	4.0	-	50	-	2
205RM020.05S4	2.0	4	5.0	-	50	-	2
205RM020.05S6	2.0	6	5.0	-	50	-	2
205RM020.04S4	2.0	4	2.2	4	50	1.95	2
205RM020.06S4	2.0	4	2.2	6	50	1.95	2
205RM020.08S4	2.0	4	2.2	8	50	1.95	2
205RM020.10S4	2.0	4	2.2	10	50	1.95	2
205RM020.12S4	2.0	4	2.2	12	50	1.95	2
205RM020.14S4	2.0	4	2.2	14	50	1.95	2
205RM020.16S4	2.0	4	2.2	16	60	1.95	2
205RM020.18S4	2.0	4	2.2	18	60	1.95	2
205RM020.20S4	2.0	4	2.2	20	60	1.95	2
205RM020.30S4	2.0	4	2.2	30	70	1.95	2

→ Help 159



Microfresa testa sferica 3D in metallo duro integrale gambo Ø 4-6 mm

Solid carbide mini 3D ball nose end mill shank Ø 4-6 mm

VHM – 3D Mini Radiusfräser, shaft Ø 4-6 mm - Microfraise carbure mini 3D hémisphérique, queue Ø 4-6 mm

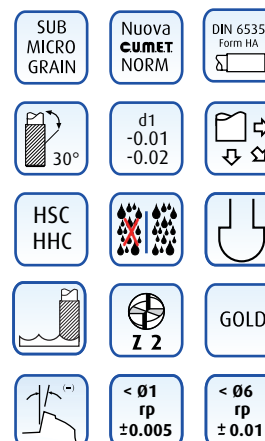
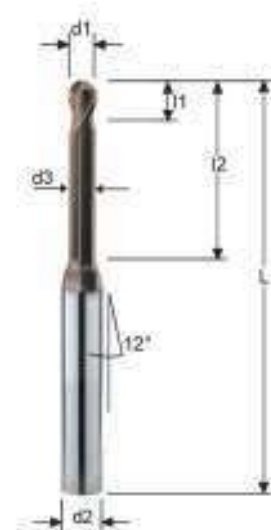
Микро фреза концевая твердосплавная радиусная 3D, хвостовик Ø 4-6 mm

Sk mini 3D kulová se stopkou Ø 4-6 mm



CODE	d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
205RM025.06S4	2.5	4	6.0	-	50	-	2
205RM025.06S6	2.5	6	6.0	-	50	-	2
205RM025.10S6	2.5	6	3.0	10	50	2.45	2
205RM025.14S6	2.5	6	3.0	14	57	2.45	2
205RM025.16S6	2.5	6	3.0	16	57	2.45	2
205RM025.20S6	2.5	6	3.0	20	57	2.45	2
205RM025.25S6	2.5	6	3.0	25	70	2.45	2
205RM030.08S4	3.0	4	8.0	-	60	-	2
205RM030.08S6	3.0	6	8.0	-	57	-	2
205RM030.06S6	3.0	6	3.6	6	50	2.95	2
205RM030.08S6	3.0	6	3.6	8	50	2.95	2
205RM030.10S6	3.0	6	3.6	10	50	2.95	2
205RM030.12S6	3.0	6	3.6	12	50	2.95	2
205RM030.16S6	3.0	6	3.6	16	57	2.95	2
205RM030.18S6	3.0	6	3.6	18	57	2.95	2
205RM030.20S6	3.0	6	3.6	20	57	2.95	2
205RM030.25S6	3.0	6	3.6	25	70	2.95	2
205RM030.30S6	3.0	6	3.6	30	70	2.95	2
205RM030.40S6	3.0	6	3.6	40	80	2.95	2
205RM040.08S4	4.0	4	8.0	-	50	-	2
205RM040.08S6	4.0	6	8.0	-	50	-	2
205RM040.08S6	4.0	6	5.0	8	50	3.85	2
205RM040.10S6	4.0	6	5.0	10	50	3.85	2
205RM040.12S6	4.0	6	5.0	12	50	3.85	2
205RM040.16S6	4.0	6	5.0	16	57	3.85	2
205RM040.20S6	4.0	6	5.0	20	57	3.85	2
205RM040.25S6	4.0	6	5.0	25	70	3.85	2
205RM040.30S6	4.0	6	5.0	30	70	3.85	2
205RM040.35S6	4.0	6	5.0	35	80	3.85	2
205RM040.45S6	4.0	6	5.0	45	90	3.85	2
205RM040.50S6	4.0	6	5.0	50	90	3.85	2

→ Help 159-160



Frese per alta velocità e acciai duri

End mills for high speed-hard cut

Fräser für HSC und Geartetem Stahl

Fraises pour HSC et pour aciers temperé

Фреза концевая для высокоскоростной тяжелой обработки

Vysoko rychlostní frézy pro těžký řez



Fresa testa torica in metallo duro integrale

Solid carbide corner radius end mill

VHM – Torusfräser - Fraise carbure avec rayon d'angle

Фреза концевая твердосплавная с угловым радиусом - Sk fréza s rohovým rádiusem



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.	α°
Y200R.010.02	1	6	0.2	1.5	-	75	-	2	13°30'
Y200R.015.02	1.5	6	0.2	2.5	-	75	-	2	15°
Y200R.020.03	2	6	0.3	3.0	-	75	-	2	13°30'
Y200R.030.03	3	6	0.3	5.0	-	75	-	2	10°30'
Y200R.040.05	4	6	0.5	6.0	-	75	-	2	6°
Y200R.040.1	4	6	1.0	6.0	-	75	-	2	6°
Y200R.060.05	6	6	0.5	10.0	20	100	5.8	2	-
Y200R.060.1	6	6	1.0	10.0	20	100	5.8	2	-
Y200R.080.05	8	8	0.5	12.0	24	100	7.8	2	-
Y200R.080.1	8	8	1.0	12.0	24	100	7.8	2	-
Y200R.100.05	10	10	0.5	15.0	30	100	9.8	2	-
Y200R.100.1	10	10	1.0	15.0	30	100	9.8	2	-
Y200R.100.15	10	10	1.5	15.0	30	100	9.8	2	-
Y200R.120.1	12	12	1.0	18.0	36	100	11.8	2	-
Y200R.120.15	12	12	1.5	18.0	36	100	11.8	2	-
Y200R.120.2	12	12	2.0	18.0	36	100	11.8	2	-
Y200R.160.15	16	16	1.5	25.0	40	100	15.8	2	-
Y200R.160.2	16	16	2.0	25.0	40	100	15.8	2	-

→ Help 162-163-164-165

*d1 < ø 6 = -0.01 / -0.02

d1 ≤ ø16 = f7



HRC < 65

CAST IRON

INOX
Stainless Steel

SUB MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

30°

30°

HSC HHC

rp

rp

GOLD

rp ± 0.01

Fresa a palla 3D 260° in metallo duro integrale

Solid carbide 3D 260° ball end mill

VHM - 3D 260° Radiusfräser - Fraise carbure 3D 260° a balle

Фреза концевая твердосплавная сферическая 3D 260° - Sk 3D 260° kulová fréza



CODE	*d1 mm	d2h6 mm	l1 mm	d3 mm	l2 mm	L mm	Z no.	α°
200RB020075	2	4	1.7	1.0	17	75	2	6°
200RB030100	3	6	2.6	1.7	17	100	2	8°
200RB030150	3	6	2.6	1.7	30	150	2	4°25'
200RB040100	4	6	3.5	2.4	17	100	2	7°
200RB040150	4	6	3.5	2.4	30	150	2	3°50'
200RB050100	5	6	4	4.3	30	100	2	1°40'
200RB060100	6	6	5.2	4.0	30	100	2	2°10'
200RB060150	6	6	5.2	4.0	45	150	2	1°20'
200RB080100	8	8	7.0	5.0	35	100	2	3°10'
200RB080150	8	8	7.0	5.0	50	150	2	1°55'
200RB100100	10	10	8.7	6.1	40	100	2	3°40'
200RB100150	10	10	8.7	6.1	60	150	2	2°10'
200RB120100	12	12	10.5	7.5	50	100	2	3°10'
200RB120150	12	12	10.5	7.5	75	150	2	1°50'

→ Help 160

*d1 < ø 6 = -0.01 / -0.02

d1 ≤ ø12 = f7



HRC < 50

CAST IRON

Aluminium

NI-Alloy

SUB MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

30°

30°

HSC HHC

r = 260°

r = 260°

HYPER

R ± 0.01

Fresa a palla 3D 260° in metallo duro integrale

Solid carbide 3D 260° ball end mill

VHM - 3D 260° Radiusfräser - Fraise carbure 3D 260° a balle

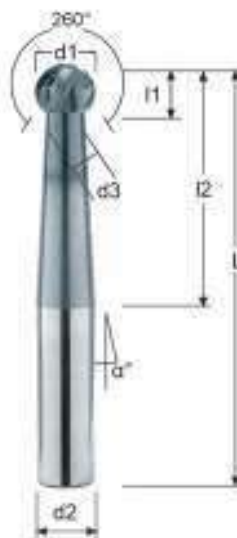
Фреза концевая твердосплавная сферическая 3D 260° - Sk 3D 260° kulová fréza



CODE	*d1 mm	d2h6 mm	l1 mm	d3 mm	l2 mm	L mm	Z no.	α°
400RB030100	3	6	2.6	1.7	17	100	4	8°
400RB040100	4	6	3.5	2.4	17	100	4	7°
400RB050100	5	6	4.0	4.3	30	100	4	1°40'
400RB060100	6	6	5.2	4.0	30	100	4	2°10'
400RB060150	6	6	5.2	4.0	45	150	4	1°20'
400RB080100	8	8	7.0	5.0	35	100	4	3°10'
400RB080150	8	8	7.0	5.0	50	150	4	1°55'
400RB100100	10	10	8.7	6.1	40	100	4	3°40'
400RB100150	10	10	8.7	6.1	60	150	4	2°10'
400RB120100	12	12	10.5	7.5	50	100	4	3°10'
400RB120150	12	12	10.5	7.5	75	150	4	1°50'

→ Help 160

*d1 ≤ Ø12 = f7



HRC < 50

CAST IRON

NI-Alloy

SUB MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

30°

30°

HSC HHC

r = 260°

260°

(+)

Z 4

HYPER

R ± 0.01

Fresa testa sferica 3D Hard Cut in metallo duro integrale

Solid carbide 3D ball nose end mill, Hard Cut

VHM - 3D Radiusfräser, Hard Cut - Fraise carbure 3D hémisphérique, Hard Cut

Фреза концевая твердосплавная полусферическая 3D для твердых материалов

Sk kulová fréza pro těžký řez



CODE	*d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.	α°
200DRJ.01050	1	6	1	3	50	0.95	2	20°
200DRJ.02050	2	6	3	6	50	1.95	2	10°
200DRJ.02057	2	6	3	6	57	1.95	2	10°
200DRJ.02075	2	6	2	6	75	1.95	2	10°
200DRJ.03050	3	6	4	9	50	2.9	2	8°
200DRJ.03057	3	6	4	9	57	2.9	2	8°
200DRJ.03075	3	6	3	9	75	2.9	2	8°
200DRJ.04050	4	6	5	12	50	3.9	2	6°
200DRJ.04057	4	6	5	12	57	3.9	2	6°
200DRJ.04075	4	6	4	12	75	3.9	2	6°
200DRJ.05057	5	6	6	16	57	4.9	2	3°
200DRJ.05075	5	6	6	16	75	4.9	2	3°
200DRJ.06057	6	6	6	20	57	5.9	2	-
200DRJ.06075	6	6	6	20	75	5.9	2	-
200DRJ.06100	6	6	6	20	100	5.9	2	-
200DRJ.06100.1	6	8	6	12	100	5.9	2	7°
200DRJ.08060	8	8	9	16	60	7.8	2	-
200DRJ.08075	8	8	9	29	75	7.8	2	-
200DRJ.08100	8	8	9	29	100	7.8	2	-
200DRJ.08100.1	8	10	9	29	100	7.8	2	8°
200DRJ.10070	10	10	10	20	70	9.8	2	-
200DRJ.10080	10	10	10	35	80	9.8	2	-
200DRJ.10100	10	10	10	35	100	9.8	2	-
200DRJ.10100.1	10	12	10	35	100	9.8	2	8°
200DRJ.12075	12	12	12	24	75	11.8	2	-
200DRJ.12100	12	12	12	37	100	11.8	2	-

→ Help 166

*d1 < Ø6 = -0.01 / -0.02

d1 ≤ Ø12 = f7



HRC < 70

CAST IRON

SUB MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

17°

17°

HSC HHC

< Ø6 d1 -0.01 -0.02

Z 2

GOLD

R ± 0.01

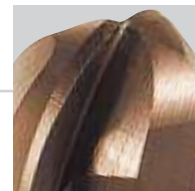
Fresa testa sferica 3D rastremata extralunga in metallo duro integrale

Solid carbide 3D ball nose end mill, extra long tapered neck

VHM-3D- Radiusfräser mit Kugelstirn, überlang - Fraise carbure 3D hémisphérique, ultra-longue

Фреза концевая твердосплавная полусферическая 3D длинная

Sk 3D kulová fréza, extra dlouhá kuželová stopka

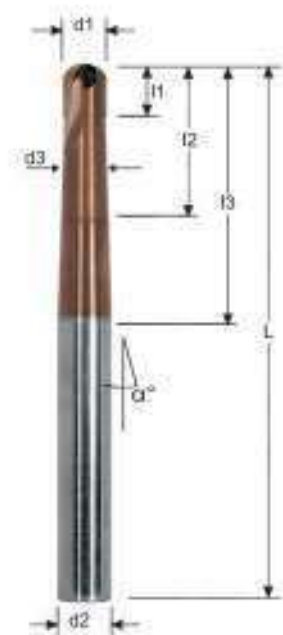


CODE	*d1 mm	d2h6 mm	L1 mm	L2 mm	L3 mm	L mm	d3 mm	Z no.	α°
200DJ.010	1	6	2	5	35	100	0,95	2	4°44'
200DJ.015	1,5	6	3	6	35	100	1,45	2	4°56'
200DJ.020	2	6	3	7	35	100	1,95	2	5°
200DJ.030	3	6	4	10	35	100	2,9	2	5°43'
200DJ.040	4	6	5	13	35	100	3,8	2	6°29'
200DJ.050	5	6	6	16	35	100	4,8	2	7°30'
200DJ.060	6	8	6	18	35	100	5,8	2	3°22'
200DJ.080	8	10	8	24	58	109	7,8	2	1°40'
200DJ.100	10	12	10	30	58	109	9,8	2	2°
200DJ.120	12	14	12	36	58	109	11,8	2	1°

→ Help 166

*d1 < ø 6 = -0.01 / - 0.02

d1 ≤ ø12 = f7



HRC
< 70

CAST
IRON

SUB
MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

0°

HSC
HHC

U

Z 2

GOLD

R
± 0.01

Z 2

GOLD

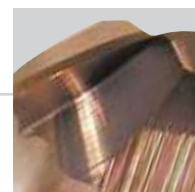
Fresa testa sferica 3D in metallo duro integrale

Solid carbide 3D ball nose end mill

VHM - 3D Radiusfräser - Fraise carbure 3D hémisphérique

Фреза концевая твердосплавная полусферическая 3D, для твердых материалов

Sk 3D kulová fréza



CODE	*d1 mm	d2h6 mm	L1 mm	L2 mm	L mm	Z no.	α°
200SRJ.01050S4	1	4	1.5	15	50	2	6°
200SRJ.01050S6	1	6	1.5	15	50	2	10°52'
200SRJ.01550S4	1.5	4	2.5	15	50	2	4°45'
200SRJ.01550S6	1.5	6	2.5	15	50	2	9°49'
200SRJ.02075S4	2	4	3	15	75	2	5°
200SRJ.02050S6	2	6	3	15	50	2	10°
200SRJ.02550	2.5	6	3	15	50	2	9°
200SRJ.03075	3	6	4.5	20	75	2	5°30'
200SRJ.04075	4	6	6	20	75	2	4°
200SRJ.05075	5	6	7.5	20	75	2	2°
200SRJ.06050	6	6	9	-	50	2	-
200SRJ.06100	6	6	9	-	100	2	-
200SRJ.08100	8	8	12	-	100	2	-
200SRJ.10100	10	10	15	-	100	2	-
200SRJ.10150	10	10	15	-	150	2	-
200SRJ.12100	12	12	18	-	100	2	-
200SRJ.12150	12	12	18	-	150	2	-
200SRJ.16100	16	16	24	-	100	2	-

→ Help 167

*d1 < ø 6 = -0.01 / - 0.02

d1 ≤ ø20 = f7



HRC
< 55

CAST
IRON

MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

30°

HSC
HHC

U

Z 2

GOLD

R
± 0.01

Z 2

GOLD

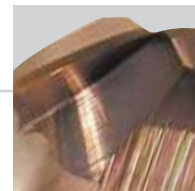
Fresa testa sferica rastremata extralunga in metallo duro integrale

Solid carbide 3D ball nose end mill, extra long tapered neck

VHM-3D- Radiusfräser mit Kugelstirn, überlang - Fraise carbure 3D hémisphérique, ultra-longue

Фреза концевая твердосплавная полусферическая 3D длинная

Sk 3D kulová fréza extra dlouhá kuželová stopka



CODE	*d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	Z no.	α°
200SRJL.02150	2	6	3	60	150	2	2°
200SRJL.03150	3	6	4.5	60	150	2	1°30'
200SRJL.04150	4	6	6	60	150	2	1°
200SRJL.04150.1	4	8	20	80	150	2	1°56'
200SRJL.05150	5	6	7.5	60	150	2	0°30'
200SRJL.05150.1	5	6	20	80	150	2	0°30'
200SRJL.06150	6	8	9	80	150	2	0°45'
200SRJL.06150.1	6	8	20	60	150	2	1°
200SRJL.08150	8	10	12	60	150	2	1°

→ Help 167

*d1 < ø 6 = -0.01 / - 0.02

d1 ≤ ø 8 = f7



HRC
< 55

CAST
IRON

MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

30°

HSC
HHC

U

Z 2

GOLD

R
± 0.01

GOLD

GOLD

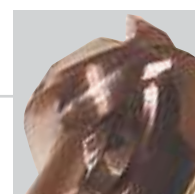
Fresa testa sferica 3D rastremata extralunga in metallo duro integrale

Solid carbide 3D ball nose end mill, extra long tapered neck

VHM-3D- Radiusfräser mit Kugelstirn, überlang - Fraise carbure 3D hémisphérique, ultra-longue

Фреза концевая твердосплавная полусферическая 3D, длинная

Sk 3D kulová fréza extra dlouhá kuželová stopka



CODE	*d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	Z no.	α°
400SRJ.040150	4	6	6	60	150	4	1°
400SRJ.040150.1	4	8	20	60	150	4	1°30'
400SRJ.060150	6	8	9	80	150	4	0°45'
400SRJ.060150.1	6	8	20	60	150	4	1°30'
400SRJ.080150	8	10	12	60	150	4	1°
400SRJ.100150	10	10	15	-	150	4	-
400SRJ.120150	12	12	18	-	150	4	-

→ Help 167

*d1 < ø 6 = -0.01 / - 0.02

d1 ≤ ø 12 = f7



HRC
< 55

CAST
IRON

INOX
Stainless
Steel

MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

30°

HSC
HHC

U

Z 4

GOLD

R
± 0.01

GOLD

GOLD

Fresa testa torica in metallo duro integrale

Solid carbide corner radius end mill

VHM - Torusfräser - Fraise carbure avec rayon d'angle

Фреза концевая твердосплавная с угловым радиусом - Sk fréza s rohovým rádiusem

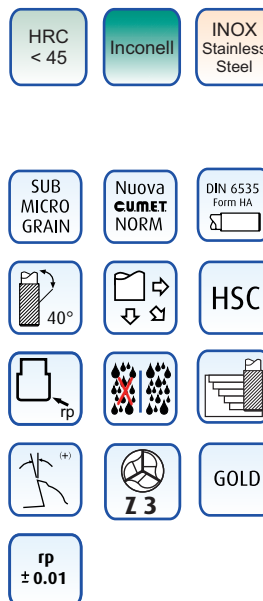


CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y300R.030.03	3	6	0.3	4.5	7	75	2.9	3
Y300R.040.04	4	6	0.4	6	9	75	3.9	3
Y300R.060.05	6	6	0.5	9	13	100	5.8	3
Y300R.060.1	6	6	1.0	9	13	100	5.8	3
Y300R.080.05	8	8	0.5	12	18	100	7.7	3
Y300R.080.1	8	8	1.0	12	18	100	7.7	3
Y300R.100.05	10	10	0.5	15	25	100	9.7	3
Y300R.100.1	10	10	1.0	15	25	100	9.7	3
Y300R.120.05	12	12	0.5	18	30	100	11.7	3
Y300R.120.1	12	12	1.0	18	30	100	11.7	3

→ Help 169-170

*d1 < ø 6 = -0.01 / - 0.02

d1 ≤ ø12 = f7



Fresa testa sferica 3D Hard Cut in metallo duro integrale

Solid carbide 3D ball nose end mill, Hard Cut

VHM - 3D Radiusfräser, Hard Cut - Fraise carbure 3D hémisphérique, Hard Cut

Фреза концевая твердосплавная полусферическая 3D для твердых материалов

Sk 3D kulová fréza pro těžký řez

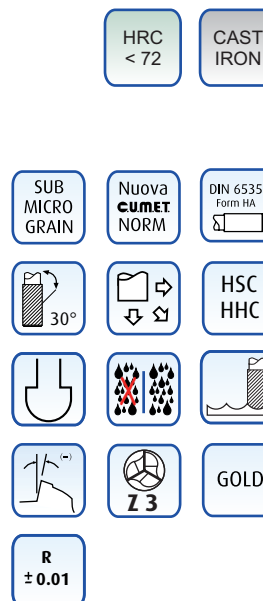


CODE	*d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
300NRJ.030	3	6	4.5	7.5	75	2.9	3
300NRJ.040	4	6	6	9	75	3.9	3
300NRJ.050	5	6	7	10	75	4.9	3
300NRJ.060	6	6	9	15	100	5.9	3
300NRJ.080	8	8	12	20	100	7.8	3
300NRJ.100	10	10	15	25	100	9.8	3
300NRJ.120	12	12	18	25	100	11.8	3

→ Help 168

*d1 < ø 6 = -0.01 / - 0.02

d1 ≤ ø12 = f7

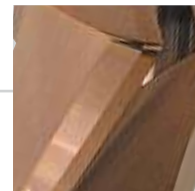


Fresa ad Alto avanzamento in metallo duro integrale

Solid carbide High speed end mill

VHM - Torusfräser High feed - Fraise carbure avec rayon d'angle pour haute avancement

Фреза твердосплавная концевая для высокоскоростной обработки - Sk vysoko rychlostní fréza



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y303.030.02	3	6	0.2	4	9	57	2.95	4
Y303.030.05	3	6	0.5	4	9	57	2.95	4
Y303.040.05	4	6	0.5	5	12	57	3.95	4
Y303.040.1	4	6	1	5	12	57	3.95	4
Y303.060.05	6	6	0.5	6	18	57	5.8	4
Y303.060.1	6	6	1	6	18	57	5.8	4
Y303.060.15	6	6	1.5	6	18	57	5.8	4
Y303.080.05	8	8	0.5	8	24	75	7.8	4
Y303.080.1	8	8	1	8	24	75	7.8	4
Y303.080.15	8	8	1.5	8	24	75	7.8	4
Y303.100.05	10	10	0.5	10	30	80	9.8	4
Y303.100.1	10	10	1	10	30	80	9.8	4
Y303.100.15	10	10	1.5	10	30	80	9.8	4
Y303.100.2	10	10	2	10	30	80	9.8	4
Y303.120.05	12	12	0.5	12	36	100	11.8	4
Y303.120.1	12	12	1	12	36	100	11.8	4
Y303.120.15	12	12	1.5	12	36	100	11.8	4
Y303.120.2	12	12	2	12	36	100	11.8	4

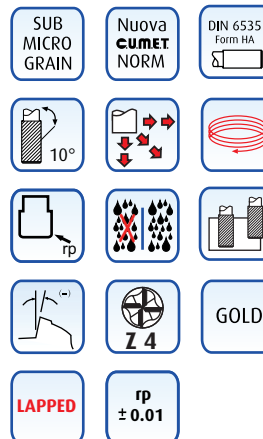
→ Help 177

*d1 < ø 6 = h9

d1 ≤ ø 12 = f7



HRC
< 70

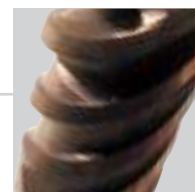


Fresa per lavorazioni estreme in metallo duro integrale

Solid carbide extreme milling end mill

VHM-Fräser für extremerspannung - Fraise carbure pour fraisages extrême

Фреза концевая твердосплавная для тяжелого фрезерования - Sk fréza pro etrémní frézování



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	L mm	Z no.	α°
406.02057	2	6	-	4	57	3	15°
406.025057	2.5	6	-	5	57	3	15°
406.03057	3	6	-	8	57	4	15°
406.035057	3.5	6	-	7	57	4	15°
406.04057	4	6	-	12	57	4	15°
406.045057	4.5	6	-	9	57	4	15°
406.05057	5	6	-	15	57	4	15°
406.06057	6	6	-	18	57	4	-
406.06075	6	6	-	18	75	4	-
406.08063	8	8	-	16	63	4	-
406.08075	8	8	-	20	75	4	-
406.08100	8	8	-	24	100	4	-
406.09072	9	10	-	18	72	4	15°
406.10080	10	10	-	25	80	4	-
406.10100	10	10	-	30	100	4	-
406.12083	12	12	-	24	83	4	-
406.12100	12	12	-	30	100	4	-
406.12120	12	12	-	40	120	4	-
406.16092	16	16	-	32	92	4	-
406.16140	16	16	-	48	140	4	-
406.20100	20	20	-	40	100	4	-
406.20150	20	20	-	60	150	4	-

→ Help 175-176

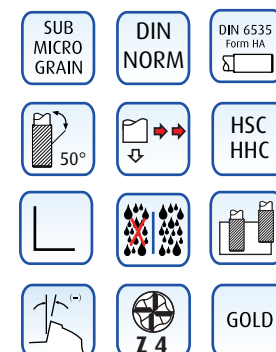
*d1 < ø 6 = h9

d1 ≤ ø 20 = f7



HRC
< 70

INOX
Stainless
Steel



Fresa testa torica per lavorazioni estreme in metallo duro integrale

Solid carbide extreme milling corner radius end mill

VHM-Eckenradius fräser für extremerspannung - Fraise carbure avec rayon pour fraisages extrême
Фреза концевая твердосплавная с угловым радиусом для тяжелого фрезерования
Sk fréza pro extrémní frézování



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	L mm	Z no.	α°
Y406.03057.02	3	6	0.2	8	57	4	15°
Y406.04057.02	4	6	0.2	12	57	4	15°
Y406.05057.02	5	6	0.2	15	57	4	15°
Y406.06057.02	6	6	0.2	18	57	4	-
Y406.06057.03	6	6	0.3	18	57	4	-
Y406.06057.05	6	6	0.5	18	57	4	-
Y406.06057.1	6	6	1.0	18	57	4	-
Y406.06075.02	6	6	0.2	18	75	4	-
Y406.06075.05	6	6	0.5	18	75	4	-
Y406.06075.1	6	6	1.0	18	75	4	-
Y406.08075.02	8	8	0.2	20	75	4	-
Y406.08075.05	8	8	0.5	20	75	4	-
Y406.08075.1	8	8	1.0	20	75	4	-
Y406.08100.02	8	8	0.2	24	100	4	-
Y406.08100.05	8	8	0.5	24	100	4	-
Y406.08100.1	8	8	1.0	24	100	4	-
Y406.10072.05	10	10	0.5	20	72	4	-
Y406.10080.02	10	10	0.2	25	80	4	-
Y406.10080.05	10	10	0.5	25	80	4	-
Y406.10080.1	10	10	1	25	80	4	-
Y406.10100.02	10	10	0.2	30	100	4	-
Y406.10100.05	10	10	0.5	30	100	4	-
Y406.10100.1	10	10	1	30	100	4	-
Y406.12100.05	12	12	0.5	30	100	4	-
Y406.12100.1	12	12	1	30	100	4	-
Y406.16100.05	16	16	0.5	40	100	4	-
Y406.16100.1	16	16	1	40	100	4	-
Y406.16140.1	16	16	1	60	140	4	-
Y406.20100.05	20	20	0.5	40	100	4	-
Y406.20100.1	20	20	1	40	100	4	-
Y406.20150.1	20	20	1	60	150	4	-

→ Help 175-176

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7

HRC
< 70

INOX
Stainless
Steel



SUB
MICRO
GRAIN

DIN
NORM

DIN 6535
Form HA

50°

HSC
HHC

HSC
HHC

rp

Z 4

GOLD

GOLD

Z 4

GOLD

rp
± 0.01

Fresa testa torica in metallo duro integrale Hard Cut

Solid carbide corner radius end mill Hard Cut

VHM-Gesenkräser mit Eckenradius Hard Cut - Fraise carbure avec rayon d'angle Hard Cut

Фреза концевая твердосплавная с угловым радиусом для тяжелого фрезерования

Sk fréza s rohovým rádiusem pro těžký řez



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y400RS.02057.02	2	6	0.2	3	6	57	1.95	4
Y400RS.02057.05	2	6	0.5	3	6	57	1.95	4
Y400RS.02075.02	2	6	0.2	3	6	75	1.95	4
Y400RS.02075.05	2	6	0.5	3	6	75	1.95	4
Y400RS.03057.02	3	6	0.2	4	9	57	2.95	4
Y400RS.03057.05	3	6	0.5	4	9	57	2.95	4
Y400RS.03075.03	3	6	0.3	4	9	75	2.95	4
Y400RS.03075.1	3	6	1	4	9	75	2.95	4
Y400RS.04057.02	4	6	0.2	5	12	57	3.9	4
Y400RS.04057.05	4	6	0.5	5	12	57	3.9	4
Y400RS.04075.05	4	6	0.5	5	12	75	3.9	4
Y400RS.04075.1	4	6	1	5	12	75	3.9	4
Y400RS.05057.05	5	6	0.5	6	16	57	4.9	4
Y400RS.05057.1	5	6	1	6	16	57	4.9	4
Y400RS.05075.05	5	6	0.5	6	16	75	4.9	4
Y400RS.05075.1	5	6	1	6	16	75	4.9	4
Y400RS.06057.05	6	6	0.5	7	20	57	5.8	4
Y400RS.06057.1	6	6	1	7	20	57	5.8	4
Y400RS.06057.15	6	6	1.5	7	20	57	5.8	4
Y400RS.06075.05	6	6	0.5	7	20	75	5.8	4
Y400RS.06075.1	6	6	1	7	20	75	5.8	4
Y400RS.06075.15	6	6	1.5	7	20	75	5.8	4
Y400RS.06100.05	6	6	0.5	7	20	100	5.8	4
Y400RS.06100.1	6	6	1	7	20	100	5.8	4
Y400RS.06100.15	6	6	1.5	7	20	100	5.8	4
Y400RS.08075.03	8	8	0.3	10	29	75	7.8	4
Y400RS.08075.05	8	8	0.5	10	29	75	7.8	4
Y400RS.08075.1	8	8	1	10	29	75	7.8	4
Y400RS.08075.15	8	8	1.5	10	29	75	7.8	4
Y400RS.08075.2	8	8	2	10	29	75	7.8	4
Y400RS.08100.05	8	8	0.5	10	29	100	7.8	4
Y400RS.08100.1	8	8	1	10	29	100	7.8	4
Y400RS.08100.15	8	8	1.5	10	29	100	7.8	4
Y400RS.08100.2	8	8	2	10	29	100	7.8	4
Y400RS.10080.05	10	10	0.5	11	35	80	9.8	4
Y400RS.10080.1	10	10	1	11	35	80	9.8	4
Y400RS.10080.15	10	10	1.5	11	35	80	9.8	4
Y400RS.10100.05	10	10	0.5	11	35	100	9.8	4
Y400RS.10100.1	10	10	1	11	35	100	9.8	4
Y400RS.10100.15	10	10	1.5	11	35	100	9.8	4
Y400RS.10100.2	10	10	2	11	35	100	9.8	4
Y400RS.12100.05	12	12	0.5	15	37	100	11.8	4
Y400RS.12100.1	12	12	1	15	37	100	11.8	4
Y400RS.12100.15	12	12	1.5	15	37	100	11.8	4
Y400RS.12100.2	12	12	2	15	37	100	11.8	4

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7

→ Help 174

HRC
< 70

CAST
IRON



SUB
MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

20°

HSC
HHC

rp

Z 4

GOLD

rp
± 0.01

Z 4

GOLD

Fresa testa torica per alto avanzamento in metallo duro integrale

Solid carbide milling corner radius high feed end mill

VHM-Ekenradius fräser für high feed - Fraise carbure avec rayon pour haute avancement

Фреза концевая твердосплавная с угловым радиусом для тяжелого фрезерования

Sk fréza s rohovým rádiusem pro extrémní frézování



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y400D.02060.03	2	6	0.3	0.8	5	57	1.8	4
Y400D.02060.05	2	6	0.5	0.8	5	57	1.8	4
Y400D.03060.05	3	6	0.5	1.2	6	57	2.7	4
Y400D.03060.075	3	6	0.75	1.2	6	57	2.7	4
Y400D.03060.1	3	6	1	1.2	6	57	2.7	4
Y400D.04075.05	4	6	0.5	1.6	9	75	3.6	4
Y400D.04075.1	4	6	1	1.6	9	75	3.6	4
Y400D.05075.05	5	6	0.5	2	12	75	4.6	4
Y400D.05075.1	5	6	1	2	12	75	4.6	4
Y400D.05075.12	5	6	1.2	2	12	75	4.6	4
Y400D.06100.05	6	6	0.5	2.5	13	100	5.4	4
Y400D.06100.1	6	6	1	2.5	13	100	5.4	4
Y400D.06100.15	6	6	1.5	2.5	13	100	5.4	4
Y400D.08100.05	8	8	0.5	3.5	16	100	7.2	4
Y400D.08100.1	8	8	1	3.5	16	100	7.2	4
Y400D.08100.15	8	8	1.5	3.5	16	100	7.2	4
Y400D.08100.2	8	8	2	3.5	16	100	7.2	4
Y400D.10100.05	10	10	0.5	4	20	100	9	4
Y400D.10100.1	10	10	1	4	20	100	9	4
Y400D.10100.15	10	10	1.5	4	20	100	9	4
Y400D.10100.2	10	10	2	4	20	100	9	4
Y400D.12100.05	12	12	0.5	5	25	100	11	4
Y400D.12100.1	12	12	1	5	25	100	11	4
Y400D.12100.15	12	12	1.5	5	25	100	11	4
Y400D.12100.2	12	12	2	5	25	100	11	4
Y400D.16100.05	16	16	0.5	7	32	100	15	4
Y400D.16100.1	16	16	1	7	32	100	15	4
Y400D.16100.15	16	16	1.5	7	32	100	15	4
Y400D.16100.2	16	16	2	7	32	100	15	4
Y400D.16100.3	16	16	3	7	32	100	15	4

*d1 ≤ ø 6 h9

d1 ≤ ø16 f7

→ Help 177

HRC
< 65

CAST
IRON

ALLOY
STEEL



SUB
MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA
6



HSC
HHC



GOLD

rp
± 0.01

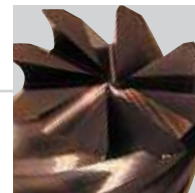


Fresa testa piana per superfinitura in metallo duro integrale

Solid carbide flat nose end mill for superfinish

VHM - Schaftfräser für superfinition - Fraise carbure pour superfinition

Фреза концевая твердосплавная для чистовой обработки - Sk rohová fréza pro super dokončování

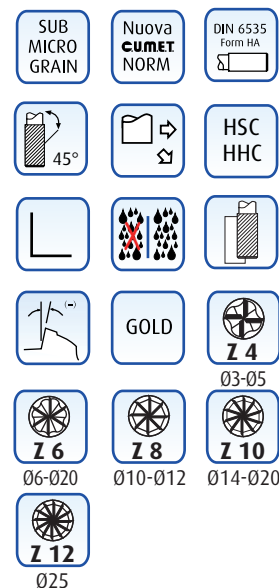


CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
506.030	3	3	10	40	4
506.030.1	3	6	10	57	4
50603060	3	3	30	60	4
506.040	4	4	12	50	4
506.040.1	4	6	12	57	4
50604060	4	4	30	60	4
506.050	5	5	12	50	4
506.050.1	5	6	15	57	4
50605070	5	5	35	70	4
506.060	6	6	16	50	6
506.060.1	6	6	25	75	6
50606100	6	6	40	100	6
506.080	8	8	20	60	6
506.080.1	8	8	24	75	6
50608100	8	8	40	100	6
506.100.1	10	10	25	75	6
50610100.1	10	10	45	100	6
506.120.1	12	12	27	83	6
50612100.1	12	12	55	109	6
50616100.1	16	16	45	100	6
50616150.1	16	16	65	150	6
50620100	20	20	45	100	6
50620150.2	20	20	75	150	6

CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
506.100	10	10	22	70	8
50610100	10	10	45	100	8
506.120	12	12	27	75	8
50612100	12	12	45	100	8
506.140	14	14	27	85	10
50614100	14	14	45	100	10
506.160	16	16	30	85	10
50616100	16	16	45	100	10
50616150	16	16	65	150	10
506.180	18	18	38	100	10
506.200	20	20	38	100	10
50620150	20	20	65	150	10
50620150.1	20	20	75	150	10
50625150	25	25	75	150	12

→ Help 173-184

*d1 ≤ ø 6 h9
d1 ≤ ø25 f7



In questa sezione viene utilizzato esclusivamente Metallo duro Sub Micrograno al 9-12% Co, 0,5 Micron, specifico per lavorazione a secco ad alta velocità degli acciai temperati.

On this section we use only solid carbide grade with 9-12% Co, 0.5 Microns, specifically designed for high speed machining of hardened steels. Dry cutting.

Dieser Abschnitt ist ausschließlich Sub Micro Grain Hartmetall 9-12% Co, 0,5 Micron, die speziell für High-Speed-trockenen Bearbeitung von gehärteten Stählen verwendet.

Cette section utilise seulement carbure Sub Micrograin avec 9-12 % Co, 0.5 Micron, convenant sec coupe, haute vitesse des aciers trempés.

Твердый сплав 9-12% Co, 0,5 микрон, специальная разработка для высокоскоростной обработки закаленной стали. Сухая резка.

V této části budeme používat pouze slinutý karbid s 9-12% CO, 0,5 mikronů, speciálně navržen pro vysokorychlostní obrábění kalené oceli. Bez chlazení.

Fresa testa torica Hard Cut in metallo duro integrale

Solid carbide corner radius end mill, Hard Cut

VHM - Schaftfräser mit Eckenradius, Hard Cut - Fraise carbure avec rayon d'angle, Hard Cut

Фреза концевая твердосплавная с угловым радиусом для труднообрабатываемых материалов
Sk fréza s rohovým rádiusem pro těžký řez



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y508.06057.02	6	6	0.2	7	20	57	5.8	6
Y508.06057.05	6	6	0.5	7	20	57	5.8	6
Y508.062057.05	6	6	0.5	20	-	57	-	6
Y508.06057.1	6	6	1	7	20	57	5.8	6
Y508.06075.02	6	6	0.2	7	20	75	5.8	6
Y508.06075.05	6	6	0.5	7	20	75	5.8	6
Y508.062575.05	6	6	0.5	25	-	75	-	6
Y508.06075.1	6	6	1	7	20	75	5.8	6
Y508.06100.02	6	6	0.2	7	20	100	5.8	6
Y508.06100.05	6	6	0.5	7	20	100	5.8	6
Y508.08075.02	8	8	0.2	9	29	75	7.8	6
Y508.08075.05	8	8	0.5	9	29	75	7.8	6
Y508.082575.05	8	8	0.5	25	-	75	-	6
Y508.08075.1	8	8	1	9	29	75	7.8	6
Y508.08100.02	8	8	0.2	8	29	100	7.8	6
Y508.08100.05	8	8	0.5	8	29	100	7.8	6
Y508.0840100.05	8	8	0.5	40	-	100	-	6
Y508.08100.1	8	8	1	8	29	100	7.8	6
Y508.10080.02	10	10	0.2	11	35	80	9.8	6
Y508.10080.05	10	10	0.5	11	35	80	9.8	6
Y508.103280.05	10	10	0.5	32	-	80	-	6
Y508.10080.1	10	10	1	11	35	80	9.8	6
Y508.10100.02	10	10	0.2	10	35	100	9.8	6
Y508.10100.05	10	10	0.5	10	35	100	9.8	6
Y508.1050100.05	10	10	0.5	50	-	100	-	6
Y508.10100.1	10	10	1	10	35	100	9.8	6
Y508.12100.02	12	12	0.2	13	37	100	11.7	6
Y508.12100.05	12	12	0.5	13	37	100	11.7	6
Y508.12100.1	12	12	1	13	37	100	11.7	6
Y508.1250109.05	12	12	0.5	50	-	109	-	8
Y508.1260109.05	12	12	0.5	60	-	109	-	8
Y508.16100.05	16	16	0.5	16	37	100	15.7	6
Y508.16100.1	16	16	1	16	37	100	15.7	6
Y508.1650100.05	16	16	0.5	50	-	100	-	10
Y508.1675150.05	16	16	0.5	75	-	150	-	10
Y508.20100.05	20	20	0.5	20	40	100	19.7	6
Y508.20100.1	20	20	1	20	40	100	19.7	6
Y508.2063109.05	20	20	0.5	63	-	109	-	8
Y508.20100150.05	20	20	0.5	100	-	150	-	8

→ Help 184

*d1 ≤ ø 6 h9
d1 ≤ ø25 f7

HRC
< 72

CAST
IRON



AEROSPACE

Materiali difficili da lavorare

Difficult machining materials

Fräser für schwierig materialen

Outils de coupe pour difficile - à - machine matériaux

Фреза концевая для труднообрабатываемых материалов

Fréza pro obtížně obrobitelné materiály



Fresa a sgrossare testa piana in metallo duro integrale rivestita in diamante

Solid carbide flat nose roughing end mill diamond coated

VHM - Schaft Schrumpfräser, Diamant Beschichtet - Fraise carbure a degrossir à bout plat, revêtement en diamant

Фреза концевая твердосплавная плоский торец для черновой обработки с алмазным покрытием

Sk hrubovací fréza s diamantovým povlakem

CODE	d1 mm	d2h6 mm	CH mm	l1 mm	L mm
5040.030	3	3	0.2	12	40
5040.040	4	4	0.2	16	5
5040.060	6	6	0.2	19	50
5040.060.1	6	6	0.2	40	100
5040.080	8	8	0.2	25	60
5040.080.1	8	8	0.2	40	100
5040.100	10	10	0.2	25	70
5040.100.1	10	10	0.2	40	100
5040.120	12	12	0.2	25	75
5040.120.1	12	12	0.2	40	100

Graphyte

CARBON FIBER



MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

Variable

HSC

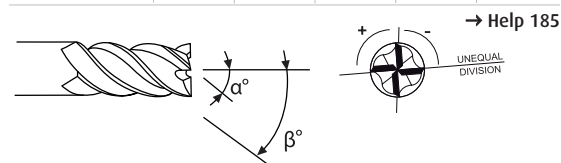
45°

UNCOATED

d1
-0
-0.1

Z 2

UNCOATED



→ Help 185

Fresa a sgrossare testa torica in metallo duro integrale rivestita in diamante

Solid carbide corner radius roughing end mill diamond coated

VHM - Torus Schrumpfräser, Diamant Beschichtet - Fraise carbure a degrossir avec rayon d'angle, revêtement en diamant

Фреза концевая твердосплавная с угловым радиусом с алмазным покрытием

Sk hrubovací fréza s rohovým rádiusem a diamantovým povlakem

CODE	d1 mm	d2h6 mm	rp mm	l1 mm	L mm
5040F.030	3	3	0.2	12	40
5040F.040	4	4	0.2	16	50
5040F.060	6	6	0.2	19	50
5040F.060.1	6	6	0.2	40	100
5040F.080	8	8	0.2	25	60
5040F.080.1	8	8	0.2	40	100
5040F.100	10	10	0.2	25	70
5040F.100.1	10	10	0.2	40	100
5040F.120	12	12	0.2	25	75
5040F.120.1	12	12	0.2	40	100

CARBON FIBER



MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

Variable

HSC

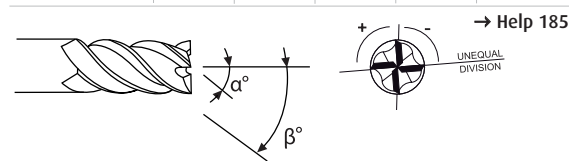
45°

UNCOATED

d1
-0
-0.1

Z 2

DIAMOND F



→ Help 185

Fresa per contornatura e finitura in metallo duro integrale

Solid carbide end mill for profiling and finishing

VHM - Fräser Für die Profilerstellung und Veredelung - Fraise carbure pour le profilage et finition

Фреза концевая твердосплавная для профильной финишной обработки

Sk fréza pro profilování a dokončování

CODE	d1 mm	d2h6 mm	l1 mm	L mm
5010.020	2	3	9	40
5010.030	3	3	12	40
5010.040	4	4	16	50
5010.060	6	6	19	50
5010.060.1	6	6	40	100
5010.080	8	8	25	60
5010.080.1	8	8	40	100
5010.100	10	10	25	70
5010.100.1	10	10	40	100
5010.120	12	12	25	75
5010.120.1	12	12	40	100

HRC < 60

Graphyte

CARBON FIBER

GLASS FIBER



MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

30°

HSC

UNCOATED

d1
-0
-0.1

Z 2

UNCOATED

→ Help 194

Fresa per contornatura e finitura in metallo duro integrale

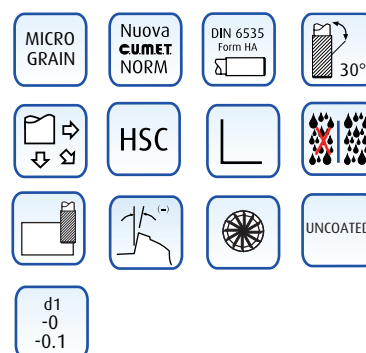
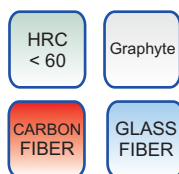
Solid carbide end mill for profiling and finishing

VHM - Fräser Für die Profilerstellung und Veredelung - Fraise carbure pour le profilage et finition
Фреза концевая твердосплавная для профильной финишной обработки
Sk fréza pro profilování a dokončování



CODE	d1 mm	d2h6 mm	l1 mm	L mm
5020.020	2	3	9	40
5020.030	3	3	12	40
5020.040	4	4	16	50
5020.060	6	6	19	50
5020.060.1	6	6	40	100
5020.080	8	8	25	60
5020.080.1	8	8	40	100
5020.100	10	10	25	70
5020.100.1	10	10	40	100
5020.120	12	12	25	75
5020.120.1	12	12	40	100

→ Help 194



Fresa per foratura, contornatura e finitura in metallo duro integrale

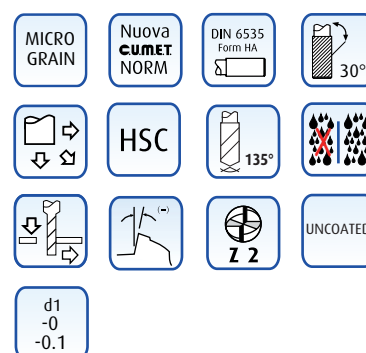
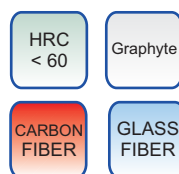
Solid carbide end mill for drilling, profiling and finishing

VHM - Schaftfraser Für bohren, profilerstellung und finishing - Fraises carbure pour le perçage, profilage et finition
Sk fréza pro profilování a dokončování s možností zavrtání



CODE	d1 mm	d2h6 mm	l1 mm	L mm
5030.030	3	3	12	40
5030.040	4	4	16	50
5030.060	6	6	19	50
5030.060.1	6	6	40	100
5030.080	8	8	25	60
5030.080.1	8	8	40	100
5030.100	10	10	25	70
5030.100.1	10	10	40	100
5030.120	12	12	25	75
5030.120.1	12	12	40	100

→ Help 194



Fresa Forante in metallo duro integrale alto avanzamento

Solid carbide Drilling end mill for High Feed

VHM – schaftfräser Bohrer für Hoch Vorschub - Fraise à Piercer en carbure a bout plat pour Haute avances
Фреза концевая твердосплавная с опцией сверления и высокими параметрами подачи
Sk rychloposuvová rohová fréza s možností vrtání



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	L mm	Z no.
Y300.020	2	6	-	4	50	3
Y300.025	2.5	6	-	5	50	3
Y300.030	3	6	-	6	50	3
Y300.035	3.5	6	-	7	50	3
Y300.040	4	6	-	8	50	3
Y300.045	4.5	6	-	9	50	3
Y300.050	5	6	-	10	50	3
Y300.055	5.5	6	-	11	50	3
Y300.060	6	6	-	13	57	3
Y300.065	6.5	8	-	16	60	3
Y300.070	7	8	-	16	60	3
Y300.075	7.5	8	-	16	60	3
Y300.080	8	8	-	19	60	3
Y300.085	8.5	10	-	19	70	3
Y300.090	9	10	-	19	70	3
Y300.095	9.5	10	-	19	70	3
Y300.100	10	10	-	22	70	3
Y300.110	11	12	-	22	75	3
Y300.120	12	12	-	26	100	3
Y300.130	13	14	-	26	100	3
Y300.140	14	14	-	26	100	3
Y300.150	15	16	-	26	100	3
Y300.160	16	16	-	30	100	3
Y300.200	20	20	-	32	100	3

→ Help 171

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



Fresa con fori in elica a semifinire in metallo duro integrale

Solid carbide semi-finishing end mill with coolant feed

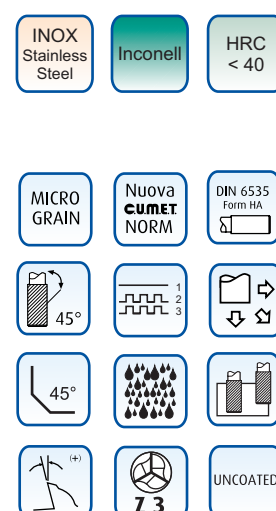
VHM - Schrupp-Schlichtfräser mit Durchgewendelten Kühlkanälen - Fraise carbure pour semifinition à trous de réfrigération
Фреза концевая твердосплавная с подачей СОЖ для полустойковой обработки
Sk středně dokončovací fréza s chlazením všech břitů



CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
455.060	6	6	20	50	3
455.080	8	8	22	60	3
455.100	10	10	25	70	3
455.120	12	12	27	75	3
455.160	16	16	30	85	3

→ Help 192

*d1 ≤ ø 6 h9
d1 ≤ ø16 f7



Fresa con fori in elica a sgrossare in metallo duro integrale

Solid carbide coolant feed roughing end mill

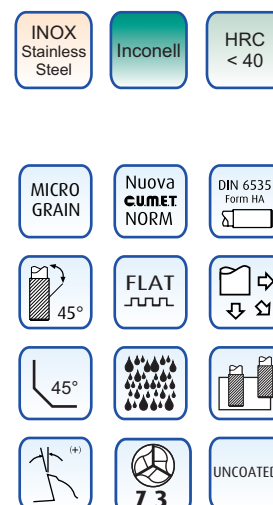
VHM - Schruppfräser mit Durchgewendelten Kühlkanälen - Fraise carbure ébauche à trous de réfrigération
Фреза концевая твердосплавная с подачей СОЖ для черновой обработки
Sk hrubovací fréza s chlazením všech břitů



CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
454.060	6	6	20	50	3
454.080	8	8	22	60	3
454.100	10	10	25	70	3
454.120	12	12	27	75	3
454.160	16	16	30	85	3
454.180	18	18	40	100	3

→ Help 192

*d1 ≤ ø 6 h9
d1 ≤ ø18 f7



Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

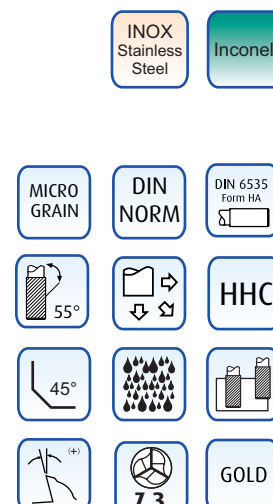
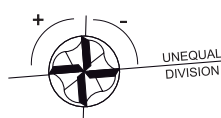
VHM - Schaftfräser - Fraise carbure à bout plat
Фреза концевая твердосплавная с плоским торцом - Sk rohová fréza



CODE	*d1 mm	d2h6 mm	CH mm	l1 mm	l2 mm	L mm	d3 mm	Z no.	α°
302.030	3	6	0.10	4	14	57	2.8	3	15°
302.040	4	6	0.10	5	16	57	3.8	3	15°
302.050	5	6	0.15	6	18	57	4.8	3	15°
302.060	6	6	0.15	7	20	57	5.5	3	-
302.080	8	8	0.15	9	26	63	7.5	3	-
302.100	10	10	0.20	11	30	72	9.2	3	-
302.120	12	12	0.20	13	37	83	11.2	3	-
302.160	16	16	0.20	17	45	92	15.2	3	-
302.200	20	20	0.20	22	55	100	19.2	3	-

→ Help 172

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



Fresa con fori in elica in metallo duro integrale

Solid carbide coolant feed end mill

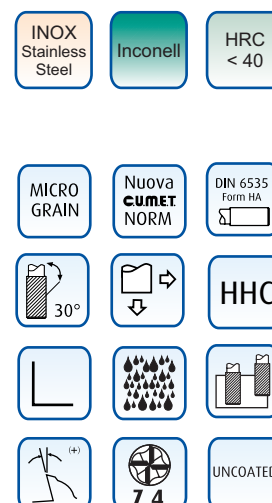
VHM - Schlichtfräser mit Durchgewendelten Kühlkanälen - Fraise carbure à trous de réfrigération
Фреза концевая твердосплавная с подачей СОЖ - Sk fréza s chlazením všech břitů



CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
410.060	6	6	20	50	4
410.080	8	8	22	60	4
410.100	10	10	25	70	4
410.120	12	12	27	75	4
410.140	14	14	30	85	4
410.160	16	16	30	85	4
410.200	20	20	40	100	4

→ Help 196-198

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



Fresa con fori in elica a semifinire in metallo duro integrale

Solid carbide coolant feed semi-finishing end mill

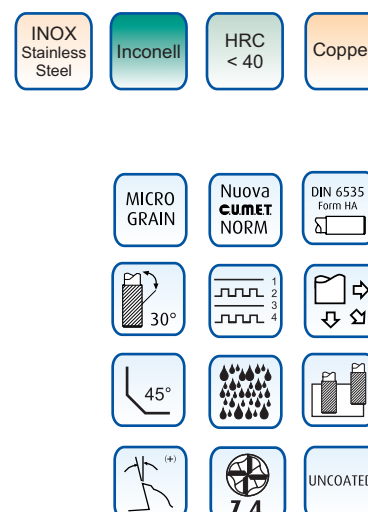
VHM - Schrapp-Schlichtfräser mit Durchgewendelten Kühlkanälen - Fraise carbure pour semifinition à trous de réfrigération
Фреза концевая твердосплавная с подачей СОЖ для полустиковой обработки
Sk polodokončovací fréza s chlazením všech břitů



CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
T3006	6	6	20	50	4
T3008	8	8	22	60	4
T3010	10	10	25	70	4
T3012	12	12	27	75	4
T3016	16	16	30	85	4
T3020	20	20	40	100	4

→ Help 192

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



Fresa con fori in elica a sgrossare in metallo duro integrale

Solid carbide coolant feed roughing end mill

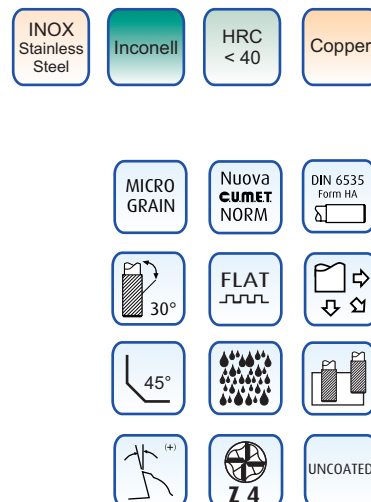
VHM - Schrappfräser mit Durchgewendelten Kühlkanälen - Fraise carbure a degrosir à trous de réfrigération
Фреза концевая твердосплавная с подачей СОЖ для полустической обработки
Sk hrubovací fréza s chlazením všech břitů



CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
T2206	6	6	20	50	4
T2208	8	8	22	60	4
T2210	10	10	25	70	4
T2212	12	12	27	75	4
T2216	16	16	30	85	4
T2220	20	20	40	100	4

→ Help 192

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



Frese testa piana in metallo duro integrale

Solid carbide flat nose end mill

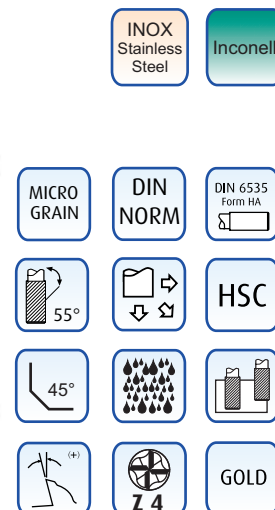
VHM - Schaftfräser - Fraise carbure à bout plat
Фреза концевая твердосплавная с плоским торцом - Sk rohová fréza



CODE	*d1 mm	d2h6 mm	CH	l1 mm	l2 mm	L mm	d3 mm	Z no.	α°
40403057	3	6	0.10	8	-	57	-	3	15°
40403057.1	3	6	0.10	4	14	57	2.8	3	15°
40404057	4	6	0.10	11	-	57	-	3	15°
40404057.1	4	6	0.10	5	16	57	3.8	3	15°
40405057	5	6	0.15	13	-	57	-	4	15°
40405057.1	5	6	0.15	6	18	57	4.8	4	15°
40406057	6	6	0.15	13	-	57	-	4	-
40406057.1	6	6	0.15	7	20	57	5.5	4	-
40408063	8	8	0.15	19	-	63	-	4	-
40408063.1	8	8	0.15	9	26	63	7.5	4	-
40410072	10	10	0.20	22	-	72	-	4	-
40410072.1	10	10	0.20	11	31	72	9.2	4	-
40412083	12	12	0.20	26	-	83	-	4	-
40412083.1	12	12	0.20	13	37	83	11.2	4	-
40416092	16	16	0.20	32	-	92	15.2	4	-

*d1 ≤ ø 6 h9
d1 ≤ ø16 f7

→ Help 172



Fresa ad alto avanzamento in metallo duro integrale

Solid carbide High feed end mill

VHM- Fräser für Hoch Vorschub - Fraise carbure pour Haut avances

Фреза концевая твердосплавная для обработки с высокими параметрами подачи

Sk vysokoposuvová fréza



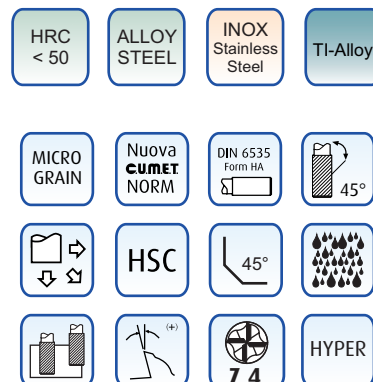
CODE	*d1 mm	d2h6 mm	CH mm	l1 mm	L mm	Z no.
Y400P.030	3	6	0.05	8	60	4
Y400P.040	4	6	0.05	11	60	4
Y400P.050	5	6	0.05	13	60	4
Y400P.060	6	6	0.05	13	60	4
Y400P.080	8	8	0.10	19	75	4
Y400P.100	10	10	0.10	22	80	4
Y400P.120	12	12	0.10	25	100	4
Y400P.160	16	16	0.10	30	100	4
Y400P.200	20	20	0.10	40	100	4

Ad esaurimento - by exhaustion

→ Help 181

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



Fresa testa torica alto avanzamento in metallo duro integrale

Solid carbide corner radius end mill, High Feed

VHM - Gesenkräfer mit Eckenradius High Feed - Fraise carbure avec rayon d'angle, High Feed

Фреза концевая твердосплавная с угловым радиусом - Sk vysokoposuvová fréza s rohovým rádiusem



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	L mm	Z no.
Y400.030.02	3	6	0.2	8	60	4
Y400.030.05	3	6	0.5	8	60	4
Y400.040.02	4	6	0.2	11	60	4
Y400.040.05	4	6	0.5	11	60	4
Y400.040.1	4	6	1.0	11	60	4
Y400.050.02	5	6	0.2	13	60	4
Y400.050.05	5	6	0.5	13	60	4
Y400.050.1	5	6	1.0	13	60	4
Y400.060.03	6	6	0.3	13	60	4
Y400.060.05	6	6	0.5	13	60	4
Y400.060.1	6	6	1.0	13	60	4
Y400.060.15	6	6	1.5	13	60	4
Y400.080.03	8	8	0.3	19	75	4
Y400.080.05	8	8	0.5	19	75	4
Y400.080.1	8	8	1.0	19	75	4
Y400.080.15	8	8	1.5	19	75	4
Y400.080.2	8	8	2.0	19	75	4
Y400.100.03	10	10	0.3	22	80	4
Y400.100.05	10	10	0.5	22	80	4
Y400.100.1	10	10	1.0	22	80	4
Y400.100.15	10	10	1.5	22	80	4
Y400.100.2	10	10	2.0	22	80	4
Y400.100.3	10	10	3.0	22	80	4
Y400.120.05	12	12	0.5	25	100	4
Y400.120.1	12	12	1.0	25	100	4
Y400.120.15	12	12	1.5	25	100	4
Y400.120.2	12	12	2.0	25	100	4
Y400.120.3	12	12	3.0	25	100	4
Y400.160.05	16	16	0.5	30	100	4
Y400.160.1	16	16	1.0	30	100	4
Y400.160.15	16	16	1.5	30	100	4
Y400.160.2	16	16	2.0	30	100	4
Y400.160.3	16	16	3.0	30	100	4
Y400.160.5	16	16	5.0	30	100	4
Y400.200.1	20	20	1.0	40	100	4
Y400.200.15	20	20	1.5	40	100	4
Y400.200.2	20	20	2.0	40	100	4
Y400.200.3	20	20	3.0	40	100	4
Y400.200.5	20	20	5.0	40	100	4

Ad esaurimento - by exhaustion

→ Help 181

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



Fresa a divisione irregolare antivibrante in metallo duro integrale

Solid carbide unequal division anti-vibration end mill

VHM-Ungleiche Drillwinkel Fräser - Fraise carbure avec division irregular

Фреза концевая твердосплавная с переменным углом наклона винтовой канавки

Sk fréza s nerovnoměrným úhlem šroubovice

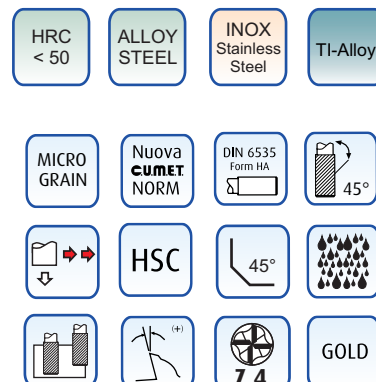


CODE	*d1 mm	d2h6 mm	CH mm	l1 mm	L mm	Z no.
400V.030	3	6	0.05	8	60	4
400V.040	4	6	0.05	11	60	4
400V.050	5	6	0.05	13	60	4
400V.060	6	6	0.05	13	60	4
400V.080	8	8	0.10	20	75	4
400V.100	10	10	0.10	22	80	4
400V.120	12	12	0.10	25	100	4
400V.160	16	16	0.10	30	100	4
400V.200	20	20	0.10	40	100	4

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



→ Help 181



Fresa testa torica a divisione irregolare antivibrante in metallo duro integrale

Solid carbide anti-vibration corner radius end mill unequal division

VHM-Ungleiche Drillwinkel Fräser - Fraise carbure rayon d'angle avec division irregular

Фреза концевая твердосплавная с переменным углом наклона винтовой канавки

Sk fréza s rohovým rádiusem a nerovnoměrným úhlem šroubovice



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	L mm	Z no.
Y400V.030.02	3	6	0.2	8	60	4
Y400V.030.05	3	6	0.5	8	60	4
Y400V.040.02	4	6	0.2	11	60	4
Y400V.040.05	4	6	0.5	11	60	4
Y400V.040.1	4	6	1.0	11	60	4
Y400V.050.02	5	6	0.2	13	60	4
Y400V.050.05	5	6	0.5	13	60	4
Y400V.050.1	5	6	1.0	13	60	4
Y400V.060.03	6	6	0.3	13	60	4
Y400V.060.05	6	6	0.5	13	60	4
Y400V.060.1	6	6	1.0	13	60	4
Y400V.060.15	6	6	1.5	13	60	4
Y400V.080.03	8	8	0.3	20	75	4
Y400V.080.05	8	8	0.5	20	75	4
Y400V.080.1	8	8	1.0	20	75	4
Y400V.080.15	8	8	1.5	20	75	4
Y400V.080.2	8	8	2.0	20	75	4
Y400V.100.03	10	10	0.3	22	80	4
Y400V.100.05	10	10	0.5	22	80	4
Y400V.100.1	10	10	1.0	22	80	4
Y400V.100.15	10	10	1.5	22	80	4
Y400V.100.2	10	10	2.0	22	80	4
Y400V.100.3	10	10	3.0	22	80	4
Y400V.120.05	12	12	0.5	25	100	4
Y400V.120.1	12	12	1.0	25	100	4
Y400V.120.15	12	12	1.5	25	100	4
Y400V.120.2	12	12	2.0	25	100	4
Y400V.120.3	12	12	3.0	25	100	4
Y400V.160.05	16	16	0.5	30	100	4
Y400V.160.1	16	16	1.0	30	100	4
Y400V.160.15	16	16	1.5	30	100	4
Y400V.160.2	16	16	2.0	30	100	4
Y400V.160.3	16	16	3.0	30	100	4
Y400V.160.5	16	16	5.0	30	100	4
Y400V.200.1	20	20	1.0	40	100	4
Y400V.200.15	20	20	1.5	40	100	4
Y400V.200.2	20	20	2.0	40	100	4
Y400V.200.3	20	20	3.0	40	100	4
Y400V.200.5	20	20	5.0	40	100	4

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



→ Help 181



Fresa a Divisione Irregolare-Elica Variabile in metallo duro integrale

Solid carbide end mill, unequal division - Variable Helix

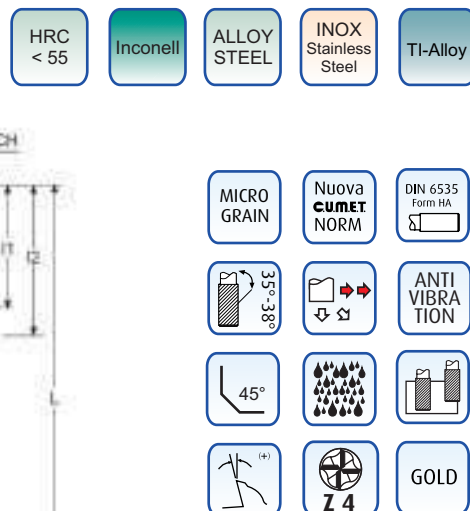
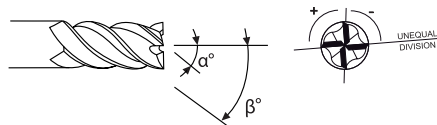
VHM-Torusfräser Ungleiche Drallwinkel-Ungleiche Teilung - Fraise end carbur avec rayon d'angle, Irrégulière Division-Hélice Variable
Фреза концевая твердосплавная с угловым радиусом с переменным углом наклона винтовой канавки
Sk fréza s rohovým rádiusem a nerovnoměrným úhlem šroubovice - Variabilní helix



CODE	*d1 mm	d2 mm	CH mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
400SV.030	3	6	0.1x45°	9	12	57	2.8	4
400SV.040	4	6	0.1x45°	11	16	57	3.8	4
400SV.050	5	6	0.1x45°	15	20	57	4.8	4
400SV.060	6	6	0.3x45°	13	23	57	5.8	4
400SV.080	8	8	0.3x45°	22	29	63	7.8	4
400SV.100	10	10	0.3x45°	25	34	70	9.8	4
400SV.120	12	12	0.3x45°	27	42	83	11.8	4
400SV.140	14	14	0.3x45°	30	45	83	13.8	4
400SV.160	16	16	0.3x45°	34	49	92	15.8	4
400SV.200	20	20	0.3x45°	40	55	104	19.8	4

→ Help 182

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



Fresa testa torica antivibrante ad alto avanzamento in metallo duro integrale

Solid carbide anti-vibrating corner radius end mill, High Feed

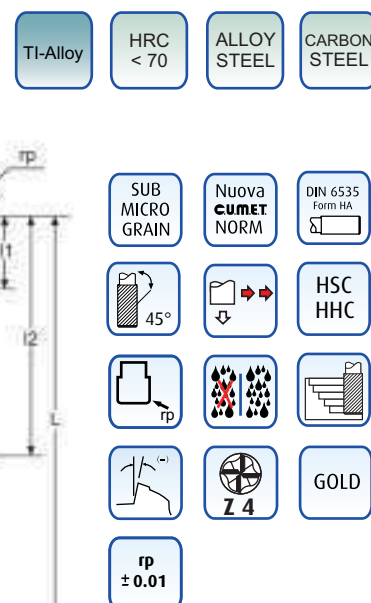
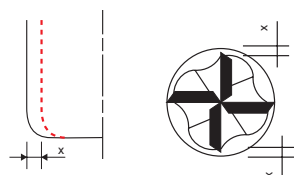
VHM - Gesenkfräser mit Eckenradius High Feed - Fraise carbure avec rayon d'angle, High Feed
Фреза концевая твердосплавная с угловым радиусом
Sk rychloposuvová fréza s rohovým rádiusem



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y400R.040	4	6	1	8	12	75	3.95	4
Y400R.050	5	6	1.2	10	15	75	-	4
Y400R.060	6	6	1.5	12	-	100	-	4
Y400R.060.1	6	6	1.5	9	30	75	5.85	4
Y400R.080	8	8	2	16	-	100	-	4
Y400R.080.1	8	8	2	12	40	100	7.8	4
Y400R.100	10	10	2	20	-	100	-	4
Y400R.100.1	10	10	2	15	50	100	9.75	4
Y400R.120	12	12	2	24	-	100	-	4
Y400R.120.1	12	12	2	18	50	100	11.75	4

→ Help 178-179-180

*d1 ≤ ø 6 h9
d1 ≤ ø12 f7



Fresa testa torica a Divisione Irregolare-Elica Variabile in metallo duro integrale

Solid carbide corner radius end mill, unequal division - Variable Helix

VHM-Torusfräser Ungleiche Drallwinkel-Ungleiche Teilung - Fraise end carbur avec rayon d'angle, Irrégulière Division-Hélice Variable

Фреза концевая твердосплавная с угловым радиусом с переменным углом наклона винтовой канавки

Sk fréza s rohovým rádiusem a nerovnoměrným úhlem šroubovice - Variabilní helix



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	L mm	Z no.
500RV03.050R03	3	6	0.3	10	50	4
500RV03.050R05	3	6	0.5	10	50	4
500RV04.050R05	4	6	0.5	12	50	4
500RV05.050R05	5	6	0.5	14	50	4
500RV06.050R05	6	6	0.5	20	50	4
500RV06.100R05	6	6	0.5	40	100	4
500RV06.050R1	6	6	1	20	50	4
500RV06.075R1	6	6	1	20	75	4
500RV06.075R15	6	6	1.5	20	75	4
500RV08.060R05	8	8	0.5	22	60	4
500RV08.100R05	8	8	0.5	40	100	4
500RV08.060R1	8	8	1	22	60	4
500RV08.100R1	8	8	1	22	100	4
500RV08.100R15	8	8	1.5	22	100	4
500RV08.100R2	8	8	2	22	100	4
500RV08.100R25	8	8	2.5	22	100	4
500RV10.070R05	10	10	0.5	25	70	4
500RV10.100R05	10	10	0.5	45	100	4
500RV10.070R1	10	10	1	25	70	4
500RV10.100R1	10	10	1	25	100	4
500RV10.100R15	10	10	1.5	25	100	4
500RV10.100R2	10	10	2	25	100	4
500RV10.100R25	10	10	2.5	25	100	4
500RV10.100R3	10	10	3	25	100	4
500RV12.075R05	12	12	0.5	27	75	4
500RV12.100R05	12	12	0.5	45	100	4
500RV12.075R1	12	12	1	27	75	4
500RV12.100R1	12	12	1	27	100	4
500RV12.100R15	12	12	1.5	27	100	4
500RV12.100R2	12	12	2	27	100	4
500RV12.100R25	12	12	2.5	27	100	4
500RV12.100R3	12	12	3	27	100	4
500RV14.085R05	14	14	0.5	30	85	4
500RV14.100R05	14	14	0.5	45	100	4
500RV16.085R05	16	16	0.5	30	85	4
500RV16.100R05	16	16	0.5	45	100	4
500RV16.150R05	16	16	0.5	65	150	4
500RV16.085R1	16	16	1	30	85	4
500RV16.100R1	16	16	1	30	100	4
500RV16.100R15	16	16	1.5	30	100	4
500RV16.100R2	16	16	2	30	100	4
500RV16.100R3	16	16	3	30	100	4
500RV16.100R5	16	16	5	30	100	4
500RV20.100R05	20	20	0.5	40	100	4
500RV20.150R05	20	20	0.5	65	150	4
500RV20.100R1	20	20	1	40	100	4
500RV20.100R15	20	20	1.5	40	100	4
500RV20.100R2	20	20	2	40	100	4
500RV20.100R3	20	20	3	40	100	4
500RV20.100R5	20	20	5	40	100	4

→ Help 182-183

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7

HRC
< 55

Inconel

ALLOY
STEEL

INOX
Stainless
Steel

Ti-Alloy



MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

Variable

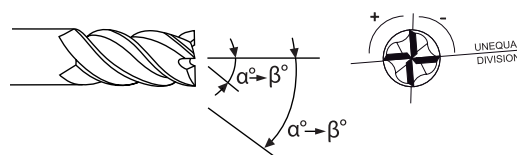
ANTI
VIBRA
TION

rp

GOLD

Z 4

rp
± 0.01

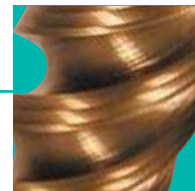


Fresa testa torica in metallo duro integrale

Solid carbide corner radius end mill

VHM - Stirn Radiusfräser - Fraise carbure avec rayon d'angle

Фреза концевая твердосплавная с угловым радиусом - Sk fréza s rohovým rádiusem



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	L mm	Z no.
Y401.060.05	6	6	0.5	13	57	4
Y401.060.1	6	6	1	13	57	4
Y401.080.05	8	8	0.5	19	63	4
Y401.080.1	8	8	1	19	63	4
Y401.100.05	10	10	0.5	22	72	4
Y401.100.1	10	10	1	22	72	4
Y401.100.15	10	10	1.5	22	72	4
Y401.120.05	12	12	0.5	26	83	4
Y401.120.1	12	12	1	26	83	4
Y401.120.15	12	12	1.5	26	83	4
Y401.160.05	16	16	0.5	32	92	4
Y401.160.1	16	16	1	32	92	4
Y401.160.15	16	16	1.5	32	92	4
Y401.200.05	20	20	0.5	40	100	4
Y401.200.1	20	20	1	40	100	4
Y401.200.15	20	20	1.5	40	100	4

→ Help 172-173

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



INOX
Stainless
Steel

Inconell

MICRO
GRAIN

DIN
NORM

DIN 6535
Form HA

55°

HHC

HHC

rp

Z 4

GOLD

rp
± 0.01

GOLD

GOLD

Fresa testa torica a Divisione Irregolare-Elica Variabile in metallo duro integrale

Solid carbide corner radius end mill, unequal division - Variable Helix

VHM-Torusfräser Ungleiche Drillwinkel-Ungleiche Teilung - Fraise end carbur avec rayon d'angle, Irrégulière Division-Hélice Variable

Фреза концевая твердосплавная с угловым радиусом с переменным углом наклона винтовой канавки

Sk fréza s rohovým rádiusem a nerovnomerným úhlem šroubovice - Variabilní helix

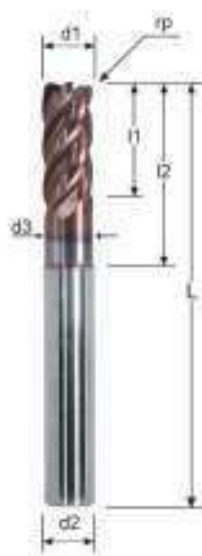


CODE	*d1 mm	d2 mm	rp-CH mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
500SV.060	6	6	0.1x45°	13	23	57	5.8	5
500SV.060R05	6	6	0.5	13	23	57	5.8	5
500SV.060R1	6	6	1	13	23	57	5.8	5
500SV.080	8	8	0.2x45°	22	32	63	7.5	5
500SV.080R05	8	8	0.5	22	32	63	7.5	5
500SV.080R1	8	8	1	22	32	63	7.5	5
500SV.080R2	8	8	2	22	32	63	7.5	5
500SV.100	10	10	0.2x45°	25	35	72	9.5	5
500SV.100R05	10	10	0.5	25	35	72	9.5	5
500SV.100R1	10	10	1	25	35	72	9.5	5
500SV.100R2	10	10	2	25	35	72	9.5	5
500SV.120	12	12	0.3x45°	27	42	83	11.5	5
500SV.120R05	12	12	0.5	27	42	83	11.5	5
500SV.120R1	12	12	1	27	42	83	11.5	5
500SV.120R2	12	12	2	27	42	83	11.5	5
500SV.160	16	16	0.3x45°	32	47	92	15.5	5
500SV.160R1	16	16	1	32	47	92	15.5	5
500SV.160R2	16	16	2	32	47	92	15.5	5
500SV.160R3	16	16	3	32	47	92	15.5	5
500SV.200	20	20	0.3x45°	40	55	104	19.5	5
500SV.200R1	20	20	1	40	55	104	19.5	5
500SV.160R2	20	20	2	40	55	104	19.5	5
500SV.160R3	20	20	3	40	55	104	19.5	5
500SV.160R4	20	20	4	40	55	104	19.5	5

→ 182

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



Ti-Alloy

INOX
Stainless
Steel

Inconell

HRC
< 55

MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

Variable

ANTI
VIBRA
TION

ANTI
VIBRA
TION

rp

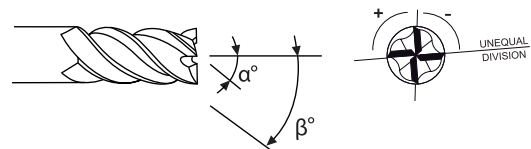
CH
45°

GOLD

rp
± 0.01

Z 5

GOLD

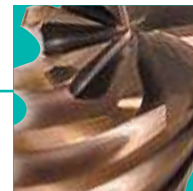


Fresa testa torica per lavorazione pale in metallo duro integrale

Solid carbide corner radius end mill for turbine blades

VHM - Fräser mit eckenradius für Turbinenschaufeln - Fraise carbure avec rayon d'angle pour aubes de turbine

Sk vysoce výkonná fréza s rohovým rádiusem



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y507.030.03	3	6	0.3	8	12	75	2.9	4
Y507.030.05	3	6	0.5	8	12	75	2.9	4
Y507.040.03	4	6	0.3	10	15	75	3.9	4
Y507.040.05	4	6	0.5	10	15	75	3.9	4
Y507.050.03	5	6	0.3	12	18	75	4.9	4
Y507.050.05	5	6	0.5	12	18	75	4.9	4
Y507.060.05	6	6	0.5	13	21	75	5.9	6
Y507.060.1	6	6	1.0	13	21	75	5.9	6
Y507.060.1.5	6	6	1.5	13	21	75	5.9	6
Y507.080.05	8	8	0.5	20	28	100	7.8	6
Y507.080.1	8	8	1.0	20	28	100	7.8	6
Y507.080.1.5	8	8	1.5	20	28	100	7.8	6
Y507.080.2	8	8	2.0	20	28	100	7.8	6
Y507.080.2.5	8	8	2.5	20	28	100	7.8	6
Y507.100.05	10	10	0.5	22	35	100	9.8	8
Y507.100.1	10	10	1.0	22	35	100	9.8	8
Y507.100.1.5	10	10	1.5	22	35	100	9.8	8
Y507.100.2	10	10	2.0	22	35	100	9.8	8
Y507.120.05	12	12	0.5	25	40	100	11.7	8
Y507.120.1	12	12	1.0	25	40	100	11.7	8
Y507.120.1.5	12	12	1.5	25	40	100	11.7	8
Y507.120.2	12	12	2.0	25	40	100	11.7	8
Y507.120.3	12	12	3.0	25	40	100	11.7	8
Y507.160.05	16	16	0.5	30	45	100	15.7	10
Y507.160.1	16	16	1.0	30	45	100	15.7	10
Y507.160.1.5	16	16	1.5	30	45	100	15.7	10
Y507.160.2	16	16	2.0	30	45	100	15.7	10
Y507.160.3	16	16	3.0	30	45	100	15.7	10
Y507.160.5	16	16	5.0	30	45	100	15.7	10
Y507.200.05	20	20	0.5	40	50	100	19.7	10
Y507.200.1	20	20	1.0	40	50	100	19.7	10
Y507.200.1.5	20	20	1.5	40	50	100	19.7	10
Y507.200.2	20	20	2.0	40	50	100	19.7	10
Y507.200.3	20	20	3.0	40	50	100	19.7	10
Y507.200.5	20	20	5.0	40	50	100	19.7	10
Y507.250.1	25	25	1	40	50	100	24.8	10
Y507.250.1.5	25	25	1.5	40	50	100	24.8	10
Y507.250.2	25	25	2	40	50	100	24.8	10
Y507.250.3	25	25	3	40	50	100	24.8	10
Y507.250.5	25	25	5	40	50	100	24.8	10



Inconell

INOX
Stainless
Steel

HRC
< 52

SUB
MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

45°

HSC
HHC

rp

GOLD

Z 4

Z 6

Z 8

Z 10

06 - 08

010-012

016-025

rp
± 0.01

→ Help 173-185

*d1 ≤ ø 6 h9

d1 ≤ ø25 f7

Fresa per kevlar in metallo duro integrale

Solid carbide kevlar end mill

VHM - Fräser für Kevlar - Fraise carbure pour kevlar

Фреза концевая твердосплавная для кевлара - Sk fréza pro obrábění kevlaru



CODE	d1h10 mm	d2h6 mm	l1 mm	L mm	Z no.
200K.050	5.0	5.0	20	60	2
200K.060	6.0	6.0	25	75	2
200K.063	6.35	6.35	25	75	2
200K.080	8.0	8.0	25	75	2
200K.100	10.0	10.0	25	75	2
200K.120	12.0	12.0	25	75	2

Vc = 250~450m/min

Fz = 0.4~2.0mm



KEVLAR

MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA



HSC



UNCOATED

d1
-0
-0.1

Fresa a forare e fresare per kevlar in metallo duro integrale

Solid carbide end mill-drill for kevlar

VHM - Fräser - Bohren für Kevlar - Fraise carbure a forer pour kevlar

Сверло-фреза для кевлара - Sk fréza pro obrábění kevlaru s možností vrtání



CODE	d1h6 mm	d2h6 mm	l1 mm	l2 mm	L mm	Z no.
200KF.047	4.7	4.7	2.0	20	60	2
200KF.050	5.0	5.0	2.0	20	60	2
200KF.060	6.0	6.0	2.0	25	75	2
200KF.063	6.35	6.35	2.0	25	75	2
200KF.080	8.0	8.0	2.0	25	75	2
200KF.100	10.0	10.0	2.5	25	75	2



KEVLAR

MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA



HSC



Z 2

UNCOATED

d1
-0
-0.1

Punta per kevlar in metallo duro integrale

Solid carbide kevlar drill

VHM - Spiralböhler für Kevlar - Foret carbure pour kevlar

Сверло спиральное твердосплавное для кевлара - Sk vrták pro vrtání kevlaru



CODE	d1h6 mm	d2h6 mm	l1 mm	L mm	Z no.
170.024	2.4	2.4	14	45	2
170.027	2.7	2.7	16	45	2
170.030	3.0	3.0	16	45	2
170.031	3.1	3.1	18	49	2
170.0317	3.17	3.17	18	49	2
170.032	3.2	3.2	18	49	2
170.035	3.5	3.5	20	53	2
170.036	3.6	3.6	20	53	2
170.037	3.7	3.7	20	53	2
170.038	3.8	3.8	22	53	2
170.040	4.0	4.0	22	53	2
170.041	4.1	4.1	22	53	2
170.044	4.4	4.4	24	58	2
170.045	4.5	4.5	24	58	2
170.0476	4.76	4.76	24	58	2
170.048	4.8	4.8	26	60	2
170.050	5.0	5.0	26	60	2
170.055	5.5	5.5	28	66	2
170.0555	5.55	5.55	28	66	2
170.056	5.6	5.6	28	66	2
170.060	6.0	6.0	28	66	2
170.061	6.1	6.1	31	70	2
170.062	6.2	6.2	31	70	2
170.0635	6.35	6.35	31	70	2
170.065	6.5	6.5	31	70	2
170.070	7.0	7.0	34	74	2
170.0793	7.93	7.93	37	79	2
170.080	8.0	8.0	37	79	2
170.085	8.5	8.5	37	79	2
170.090	9.0	9.0	40	84	2
170.0952	9.52	9.52	40	84	2
170.100	10.0	10.0	43	89	2
170.120	12.0	12.0	51	100	2

Vc = 120~160m/min

Fz = 0.04~0.16mm

KEVLAR



MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

30°

HSC

HSC

UNCOATED

UNCOATED

UNCOATED

UNCOATED

UNCOATED

UNCOATED

Il metallo duro integrale utilizzato in questa sezione ha un basso contenuto di cobalto e alta resistenza all'abrasione.

The solid carbide used for this section has a low percentage of cobalt content with high resistance to the abrasion.

Das Carbid in diesem Abschnitt verwendet wird, hat einen niedrigen Gehalt an Kobalt und mit hoher Abriebfestigkeit.

Le carbure utilisé est au moins cobalt contenu à haute résistance à l'abrasion.

Твердый сплав с небольшим содержанием кобальта для высокой резистентности к абразивным материалам.

Pevný karbid v této sekci má nízké procento kobaltu s vysokou odolností proti oděru.

Frese per grafite

End mills for graphite

Fräser für Nichtmetallische Werkstoffe
Outils pour les matériaux non métalliques
Фреза концевая для неметаллических материалов
Fréza pro neželezné materiály



Fresa a sgrossare testa piana in metallo duro integrale rivestita in diamante

Solid carbide flat nose roughing end mill diamond coated

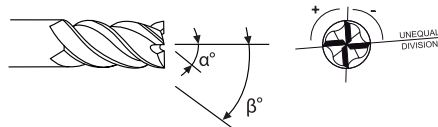
VHM - Schaft Schrappfräser, Diamant Beschichtet - Fraise carbure a degrossir à bout plat, revêtement en diamant

Фреза концевая твердосплавная плоский торец для черновой обработки с алмазным покрытием

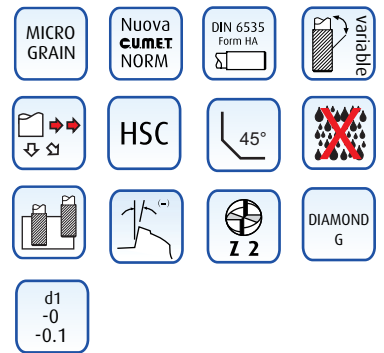
Sk hrubovací fréza s diamantovým povlakem

Code	d1 mm	d2h6 mm	CH mm	l1 mm	L mm
5040G.030	3	3	0.2	12	40
5040G.040	4	4	0.2	16	50
5040G.060	6	6	0.2	19	50
5040G.060.1	6	6	0.2	40	100
5040G.080	8	8	0.2	25	60
5040G.080.1	8	8	0.2	40	100
5040G.100	10	10	0.2	25	70
5040G.100.1	10	10	0.2	40	100
5040G.120	12	12	0.2	25	75
5040G.120.1	12	12	0.2	40	100

→ Help 185



Graphyte



Fresa a sgrossare testa torica in metallo duro integrale rivestita in diamante

Solid carbide corner radius roughing end mill diamond coated

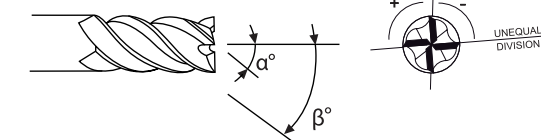
VHM - Torus Schrappfräser, Diamant Beschichtet - Fraise carbure a degrossir avec rayon d'angle, revêtement en diamant

Фреза концевая твердосплавная с угловым радиусом с алмазным покрытием

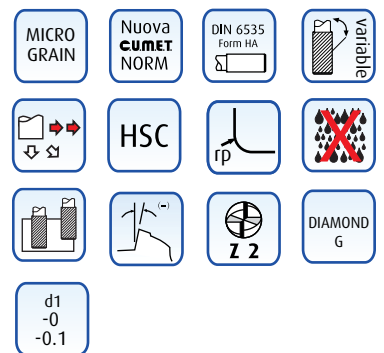
Sk hrubovací fréza s rohovým rádiusem a diamantovým povlakem

Code	d1 mm	d2h6 mm	rp mm	l1 mm	L mm
Y5040.060.05	6	6	0.5	20	50
Y5040.060.05L	6	6	0.5	32	75
Y5040.080.05	8	8	0.5	25	60
Y5040.080.05L	8	8	0.5	40	100
Y5040.100.05	10	10	0.5	25	70
Y5040.100.05L	10	10	0.5	40	100
Y5040.120.05	12	12	0.5	25	75
Y5040.120.05L	12	12	0.5	40	100

→ Help 185



Graphyte



Fresa a sgrossare testa raggiata in metallo duro integrale rivestita in diamante

Solid carbide ball nose roughing end mill diamond coated

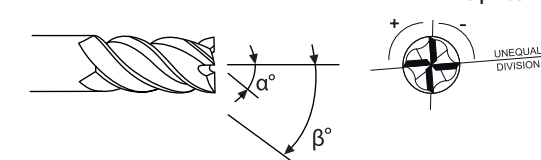
VHM - Radius Schrappfräser, Diamant Beschichtet - Fraise carbure a degrossir hémisphérique, revêtement en diamant

Фреза концевая твердосплавная радиусная для черновой обработки с алмазным покрытием

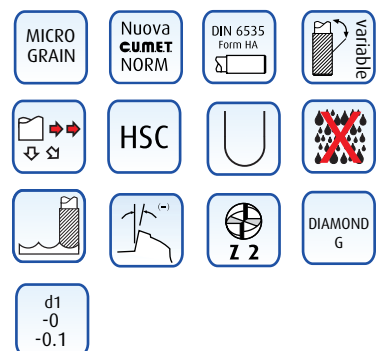
Sk kulová hrubovací fréza s diamantovým povlakem

Code	d1 mm	d2h6 mm	l1 mm	L mm
5040R.060	6	6	20	50
5040R.060.1	6	6	32	75
5040R.080	8	8	25	60
5040R.080.1	8	8	40	75
5040R.100	10	10	25	70
5040R.100.1	10	10	40	100
5040R.120	12	12	25	75
5040R.120.1	12	12	40	100

→ Help 185



Graphyte



Fresa a semi-finire testa piana rivestita in diamante in metallo duro integrale

Solid carbide flat nose semi-finishing diamond coated end mill

VHM - Schaft Vorschlichtenfräser, Diamant Beschichtet - Fraise carbure semi-finition à bout plat, avec revêtement en diamant
Фреза концевая твердосплавная плоский торец для получистовой обработки с алмазным покрытием
Sk polodokončovací fréza s diamantovým povlakem



Code	d1 mm	d2h6 mm	CH mm	l1 mm	l2 mm	L mm	d3 mm
6010D.030	3	3	0.2	12	-	50	-
6010D.040	4	4	0.2	16	-	50	-
6010D.060	6	6	0.2	19	-	50	-
6010D.060.1	6	6	0.2	19	45	100	5.7
6010D.080	8	8	0.2	25	-	60	-
6010D.080.1	8	8	0.2	25	55	100	7.7
6010D.100	10	10	0.2	25	-	70	-
6010D.100.1	10	10	0.2	25	60	100	9.7
6010D.120	12	12	0.2	25	-	75	-
6010D.120.1	12	12	0.2	30	60	100	11.7

→ Help 185



Graphyte

MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

25°

HSC

45°

Z 2

DIAMOND
G

d1
-0
-0.1

Z 2

DIAMOND
G

Fresa a semi-finire testa raggiata rivestita in diamante in metallo duro integrale

Solid carbide ball nose semi-finishing diamond coated end mill

VHM - Radius Vorschlichtenfräser, Diamant Beschichtet - Fraise carbure semi-finition à bout hémisphérique, revêtement en diamant
Фреза концевая твердосплавная радиусная для получистовой обработки с алмазным покрытием
Sk kulová polodokončovací fréza s diamantovým povlakem



Code	d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm
6010RD.030	3	3	12	-	50	-
6010RD.040	4	4	16	-	50	-
6010RD.060	6	6	19	-	50	-
6010RD.060.1	6	6	19	45	100	5.7
6010RD.080	8	8	25	-	60	-
6010RD.080.1	8	8	25	55	100	7.7
6010RD.100	10	10	25	-	70	-
6010RD.100.1	10	10	25	60	100	9.7
6010RD.120	12	12	25	-	75	-
6010RD.120.1	12	12	30	60	100	11.7

→ Help 185



Graphyte

MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

25°

HSC

U

Z 4

Z 6

d1
-0
-0.1

Z 4

Z 6

03-06

08-012

DIAMOND
G

d1
-0
-0.1

Microfresa testa torica in metallo duro integrale gambo Ø 3 mm

Solid carbide miniature corner radius end mill, shank Ø 3 mm

VHM - Mini Schaftfräser mit Eckenradius, Schaft Ø 3 mm - Microfraise carbure avec rayon d'angle, queue Ø 3 mm

Мини-фреза концевая твердосплавная 3 с угловым радиусом, хвостовик Ø 3 мм

Sk miniaturní fréza s rohovým rádiusem se stopkou Ø 3 mm

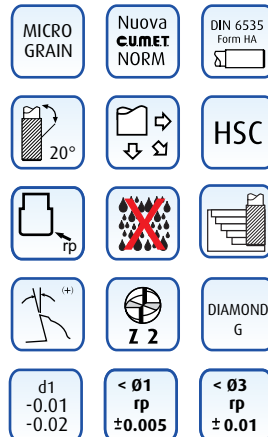


Code	d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
200GD.004	0.4	3	-	0.6	-	50	-	2
200GDL.004	0.4	3	-	0.6	1.5	50	0.35	2
200GD.005	0.5	3	0.05	0.7	2.5	50	0.45	2
200GDL.005	0.5	3	0.05	0.7	4.0	50	0.45	2
200GD.006	0.6	3	0.05	0.9	5.0	50	0.55	2
200GDL.006	0.6	3	0.05	0.9	9.0	50	0.55	2
200GD.008	0.8	3	0.05	1.2	4.0	50	0.75	2
200GDL.008	0.8	3	0.05	1.2	7.0	50	0.75	2
200GDXL.008	0.8	3	0.05	1.2	12.0	50	0.75	2
200GD.010	1.0	3	0.10	1.5	5.0	50	0.95	2
200GDL.010	1.0	3	0.10	1.5	8.5	50	0.95	2
200GD.012	1.2	3	0.10	1.8	7.5	50	1.15	2
200GDL.012	1.2	3	0.10	1.8	12.0	50	1.15	2
200GD.015	1.5	3	0.15	2.2	7.5	50	1.45	2
200GDL.015	1.5	3	0.15	2.2	12.0	50	1.45	2
200GD.020	2.0	3	0.15	2.2	10.0	50	1.95	2
200GDL.020	2.0	3	0.15	2.2	16.0	50	1.95	2
200GD.025	2.5	3	0.15	3.5	-	50	-	2
200GDL.025	2.5	3	0.15	3.5	15.0	50	2.45	2

→ Help 186



Graphyte



Microfresa testa sferica 3D in metallo duro integrale gambo Ø 3 mm

Solid carbide miniature ball nose end mill, shank Ø 3 mm

VHM - 3D Mini Radiusfräser, Schaft Ø 3 mm - Microfraise carbure mini 3D hémisphérique, queue Ø 3 mm

Мини-фреза концевая твердосплавная полусферическая 3D, хвостовик Ø 3 мм

Sk miniaturní kulová fréza se stopkou Ø 3 mm

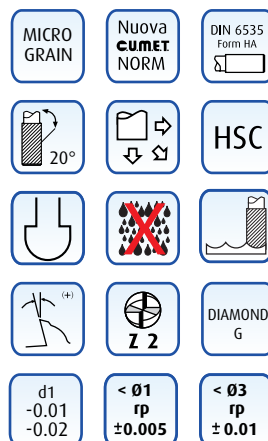


CODE	d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
200GRD.004	0.4	3	0.4	-	50	-	2
200GRDL.004	0.4	3	0.4	1.5	50	0.35	2
200GRD.005	0.5	3	0.5	2.5	50	0.45	2
200GRDL.005	0.5	3	0.5	4.0	50	0.45	2
200GRDXL.005	0.5	3	0.5	7.5	50	0.45	2
200GRD.006	0.6	3	0.6	5.0	50	0.55	2
200GRDL.006	0.6	3	0.6	9.0	50	0.55	2
200GRD.008	0.8	3	0.8	4.0	50	0.75	2
200GRDL.008	0.8	3	0.8	7.0	50	0.75	2
200GRDXL.008	0.8	3	0.8	12.0	50	0.75	2
200GRD.010	1.0	3	1.0	8.5	50	0.95	2
200GRDL.010	1.0	3	1.0	15.0	50	0.95	2
200GRD.012	1.2	3	1.2	6.0	50	1.15	2
200GRDL.012	1.2	3	1.2	10.0	50	1.15	2
200GRD.015	1.5	3	1.5	12.0	50	1.45	2
200GRDL.015	1.5	3	1.5	20.0	50	1.45	2
200GRD.020	2.0	3	2.0	10.0	50	1.95	2
200GRDL.020	2.0	3	2.0	16.0	50	1.95	2
200GRD.025	2.5	3	2.5	15.0	50	2.45	2

→ Help 186



Graphyte



Microfresa testa torica in metallo duro integrale gambo Ø 4 mm

Solid carbide miniature corner radius end mill, shank Ø 4 mm

VHM - Mini Schaftfräser mit Eckenradius, Schaft Ø 4 mm - Microfraise carbure avec rayon d'angle, queue Ø 4 mm

Мини-фреза концевая твердосплавная 3 с угловым радиусом, хвостовик Ø 4 mm

Sk miniaturní fréza s rohovým rádiusem se stopkou Ø 4 mm



CODE	d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
204GD.004	0.4	4	0.05	0.6	2.5	50	0.37	2
204GD.004.1	0.4	4	0.05	0.6	5	50	0.37	2
204GD.005	0.5	4	0.05	0.8	-	50	-	2
204GD.005.1	0.5	4	0.05	0.8	3.5	50	0.45	2
204GD.005.2	0.5	4	0.05	0.8	5	50	0.45	2
204GD.005.3	0.5	4	0.05	0.8	7	50	0.45	2
204GD.005.4	0.5	4	0.05	0.8	10	50	0.45	2
204GD.006	0.6	4	0.05	0.9	3.5	50	0.55	2
204GD.006.1	0.6	4	0.05	0.9	7	50	0.55	2
204GD.008	0.8	4	0.05	1.2	5	50	0.75	2
204GD.008.1	0.8	4	0.05	1.2	10	50	0.75	2
204GD.010	1.0	4	-	1.0	-	50	-	2
204GD.010.1	1.0	4	0.05	1.5	5	50	0.95	2
204GD.010.2	1.0	4	0.1	1.5	5	50	0.95	2
204GD.010.3	1.0	4	0.05	1.5	10	50	0.95	2
204GD.010.4	1.0	4	0.1	1.5	10	50	0.95	2
204GD.010.5	1.0	4	0.2	1.5	10	50	0.95	2
204GD.010.6	1.0	4	0.1	1.5	15	50	0.95	2
204GD.010.7	1.0	4	0.2	1.5	15	50	0.95	2
204GD.010.8	1.0	4	0.1	1.5	20	75	0.95	2
204GD.015	1.5	4	0.15	2.3	-	50	-	2
204GD.015.1	1.5	4	0.15	2.3	10	50	1.40	2
204GD.015.2	1.5	4	0.2	2.3	10	50	1.40	2
204GD.015.3	1.5	4	0.15	2.3	15	50	1.40	2
204GD.015.4	1.5	4	0.2	2.3	15	50	1.40	2
204GD.015.5	1.5	4	0.2	2.3	25	75	1.40	2
204GD.020	2.0	4	0.2	3.0	-	50	-	2
204GD.020.1	2.0	4	0.2	3.0	5	50	1.90	2
204GD.020.2	2.0	4	0.1	3.0	10	50	1.90	2
204GD.020.3	2.0	4	0.2	3.0	10	50	1.90	2
204GD.020.4	2.0	4	0.3	3.0	10	50	1.90	2
204GD.020.5	2.0	4	0.3	3.0	15	50	1.90	2
204GD.020.6	2.0	4	0.2	3.0	20	75	1.90	2
204GD.020.7	2.0	4	0.3	3.0	20	75	1.90	2
204GD.020.8	2.0	4	0.2	3.0	25	75	1.90	2
204GD.030	3.0	4	0.2	4.5	15	75	2.90	2

→ Help 186



In questa sezione il rivestimento in diamante 2 nano cristallino multi-layer è specifico per la lavorazione della fibra di carbonio. Lo spessore di rivestimento è di 8+2 Micron. L'esecuzione lucida del rivestimento consente di limitare gli attriti durante la lavorazione. L'innovativa geometria anti vibrante da noi ideata è particolarmente indicata per le lavorazioni dal pieno.

Nano-crystalline diamond coating 2 multi-layer specific to the processing of carbon fiber. Coating thickness 8 + 2 microns. Shiny execution of the coating to reduce friction during the processing. The innovative anti vibrating geometry designed by us is particularly suitable for machining full diameter.

In diesem Abschnitt wird die nanokristalline Diamantschicht 2 mehrschichtigen spezifisch ist für die Bearbeitung der Kohlenstofffaser. Die Schichtdicke beträgt 8 + 2 Micron. Die Ausführung der glänzenden Beschichtung hilft Limit Reibung während der Verarbeitung. L'innovativa Geometrie anti Vibrieren von uns entwickelt ist besonders geeignet für die Bearbeitung aus dem Vollen

Dans cette section le multicouche de revêtement nano diamant 2 cristallin est spécifique pour le fraisage de la fibre de carbone. L'épaisseur du revêtement est 8 + 2 microns. La surface lisse de revêtement permet de limiter la friction pendant le traitement. La géométrie innovante antivibration que nous avons conçu convient particulièrement pour le fraisage.

Нано-кристаллическое алмазное многослойное покрытие предназначенное для обработки карбоновой фибры. Толщина покрытия 8 + 2 микрон. Полированная поверхность для уменьшения трения при обработке. Инновационная антивибрационная геометрия для обработки общим диаметром фрезы.

Nano-krytalická diamantová 2 vícevrstvá-vrstva specifická pro zpracování uhlíkových vláken. Tloušťka vrstvy 8 + 2 mikronů. Lesklé provedení povrchové úpravy pro snížení tření při obrábění. Inovatívni protivibrační geometrie, je vhodný zejména pro obrábění plným průměrem.

Microfresa testa sferica 3D in metallo duro integrale gambo Ø 4 mm

Solid carbide miniature ball nose end mills, shank Ø 4 mm

VHM - 3D Mini Radiusfräser, Schaft Ø 4 mm - Microfraise carbure mini 3D hémisphérique, queue Ø 4 mm

Мини-фреза концевая твердосплавная полусферическая, хвостовик Ø 4 мм

Sk miniaturní kulová fréza se stopkou Ø 4 mm

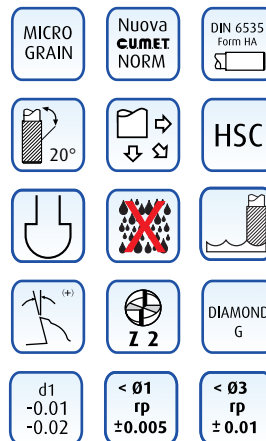


CODE	d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
204GRD.004	0.4	4	0.6	2.5	50	0.37	2
204GRD.004.1	0.4	4	0.6	5	50	0.37	2
204GRD.005	0.5	4	0.8	-	50	-	2
204GRD.005.1	0.5	4	0.8	3.5	50	0.45	2
204GRD.005.2	0.5	4	0.8	5	50	0.45	2
204GRD.005.3	0.5	4	0.8	7	50	0.45	2
204GRD.005.4	0.5	4	0.8	10	50	0.45	2
204GRD.006	0.6	4	0.9	3.5	50	0.55	2
204GRD.006.1	0.6	4	0.9	7	50	0.55	2
204GRD.008	0.8	4	1.2	5	50	0.75	2
204GRD.008.1	0.8	4	1.2	10	50	0.75	2
204GRD.010	1.0	4	1.5	-	50	-	2
204GRD.010.1	1.0	4	1.5	5	50	0.95	2
204GRD.010.2	1.0	4	1.5	10	50	0.95	2
204GRD.010.3	1.0	4	1.5	15	50	0.95	2
204GRD.010.4	1.0	4	1.5	20	50	0.95	2
204GRD.015	1.5	4	2.3	-	50	-	2
204GRD.015.1	1.5	4	2.3	10	50	1.40	2
204GRD.015.2	1.5	4	2.3	25	75	1.40	2
204GRD.020	2.0	4	3.0	-	50	-	2
204GRD.020.1	2.0	4	3.0	5	50	1.90	2
204GRD.020.2	2.0	4	3.0	10	50	1.90	2
204GRD.020.3	2.0	4	3.0	15	50	1.90	2
204GRD.020.4	2.0	4	3.0	20	75	1.90	2
204GRD.020.5	2.0	4	3.0	25	75	1.90	2
204GRD.030	3.0	4	4.5	5	50	2.90	2
204GRD.030.1	3.0	4	4.5	10	50	2.90	2
204GRD.030.2	3.0	4	4.5	15	50	2.90	2
204GRD.030.3	3.0	4	4.5	20	75	2.90	2
204GRD.030.4	3.0	4	4.5	25	75	2.90	2
204GRD.030.5	3.0	4	4.5	30	100	2.90	2

→ Help 186



Graphyte



Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

VHM - Schaftfräser - Fraise carbure a bout plat

Фреза концевая твердосплавная плоский торец - Sk rohová fréza

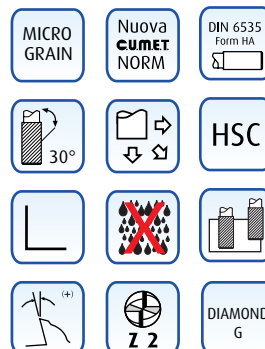


CODE	d1f7 mm	d2h6 mm	l1 mm	L mm	Z no.
200G.010	1	3	3	40	2
200G.010.1	1	3	10	50	2
200G.020	2	3	9	40	2
200G.030	3	3	12	40	2
200G.040	4	4	14	50	2
200G.050	5	5	14	50	2
200G.060	6	6	20	64	2
200G.080	8	8	20	60	2
200G.080.1	8	8	40	100	2
200G.100	10	10	25	70	2
200G.100.1	10	10	45	100	2
200G.120	12	12	25	75	2
200G.120.1	12	12	50	100	2

→ Help 186



Graphyte



Fresa testa torica in metallo duro integrale

Solid carbide corner radius end mill

VHM - Gesenkräser mit Eckenradius - Fraise carbure de matrice avec rayon d'angle

Фреза концевая твердосплавная с угловым радиусом 3D длинная - Sk fréza s rohovým rádiusem

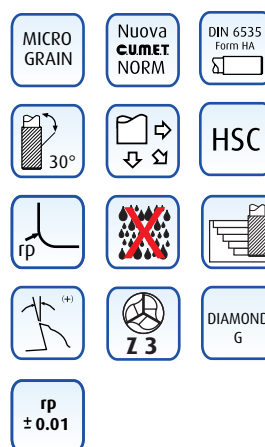


CODE	d1f7 mm	d2h6 mm	rp mm	l1 mm	L mm	Z no.
300GD.01060.02	1	2	0.2	5	60	3
300GD.02100.02	2	2	0.2	10	100	3
300GD.03050.02	3	3	0.2	12	50	3
300GD.03100.02	3	3	0.2	15	100	3
300GD.03150.02	3	3	0.2	20	150	3
300GD.04050.05	4	4	0.5	16	50	3
300GD.04100.05	4	4	0.5	20	100	3
300GD.04150.05	4	4	0.5	20	150	3
300GD.05050.05	5	5	0.5	20	50	3
300GD.05100.05	5	5	0.5	20	100	3
300GD.05150.05	5	5	0.5	20	150	3
300GD.06050.05	6	6	0.5	20	50	3
300GD.06100.05	6	6	0.5	20	100	3
300GD.06150.05	6	6	0.5	30	150	3
300GD.08060.05	8	8	0.5	22	60	3
300GD.08100.05	8	8	0.5	30	100	3
300GD.08150.05	8	8	0.5	30	150	3
300GD.10070.05	10	10	0.5	22	70	3
300GD.10100.05	10	10	0.5	30	100	3
300GD.10150.05	10	10	0.5	40	150	3
300GD.12075.05	12	12	0.5	27	75	3
300GD.12100.05	12	12	0.5	30	100	3
300GD.12150.05	12	12	0.5	40	150	3

→ Help 186



Graphyte



Fresa testa sferica 3D in metallo duro integrale

Solid carbide 3D ball nose end mill

VHM - 3D Radiusfräser - Fraise carbure 3D hémisphérique

Фреза концевая твердосплавная полусферическая 3D - Sk 3D kulová fréza

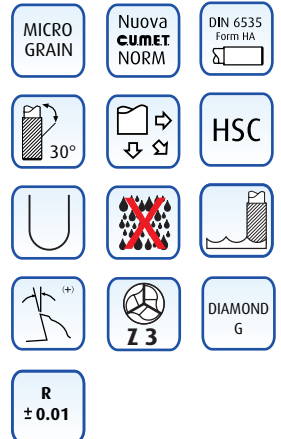


CODE	d1f7 mm	d2h6 mm	l1 mm	L mm	Z no.
300GRD.01050	1	2	6	50	3
300GRD.02060	2	2	8	60	3
300GRD.02100.1	2	2	12	100	3
300GRD.02100	2	2	20	100	3
300GRD.03040	3	3	12	40	3
300GRD.03100	3	3	15	100	3
300GRD.03150	3	3	20	150	3
300GRD.04050	4	4	16	50	3
300GRD.04100	4	4	20	100	3
300GRD.04150	4	4	20	150	3
300GRD.05050	5	5	20	50	3
300GRD.05100	5	5	20	100	3
300GRD.05150	5	5	20	150	3
300GRD.06050	6	6	20	50	3
300GRD.06100	6	6	35	100	3
300GRD.06150	6	6	35	150	3
300GRD.08060	8	8	22	60	3
300GRD.08100	8	8	35	100	3
300GRD.08150	8	8	40	150	3
300GRD.10070	10	10	20	70	3
300GRD.10100	10	10	35	100	3
300GRD.10150	10	10	40	150	3
300GRD.12075	12	12	27	75	3
300GRD.12100	12	12	35	100	3
300GRD.12150	12	12	45	150	3

→ Help 186



Graphyte



Fresa testa sferica 3D rastremata extralunga in metallo duro integrale

Solid carbide 3D ball nose end mill, extra long tapered neck

VHM-3D- Radiusfräser mit Kugelstirn, überlang - Fraise carbure 3D hémisphérique, ultra-longue

Фреза концевая твердосплавная полусферическая 3D длинная

Sk 3D kulová fréza s extra dlouhým zužením stopky

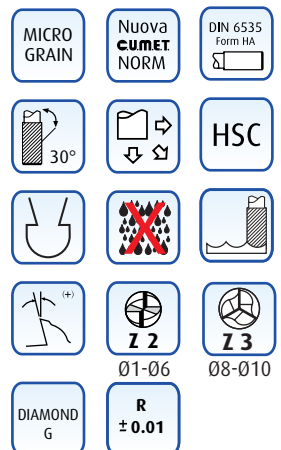


CODE	d1f7 mm	d2h6 mm	l1 mm	l2 mm	L mm	Z no.
200GRL.010	1	3	2	30	100	2
200GRL.015	1.5	3	3	30	100	2
200GRL.020	2	3	4	30	100	2
200GRL.020.1	2	4	4	70	150	2
200GRL.030	3	5	6	70	150	2
200GRL.040	4	6	8	70	150	2
200GRL.050	5	6	10	50	150	2
200GRL.060	6	8	10	70	150	2
200GRL.080	8	10	10	70	150	2
200GRL.100	10	12	10	70	150	2

→ Help 186



Graphyte



Frese per alluminio

End mills for aluminum

Fräser für Aluminium
Fraises pour Aluminium
Фрезы концевые для алюминия
Dokončovací fréza pro Obrábění Hliníku

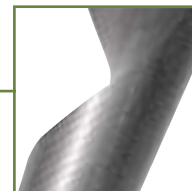


Fresa monotagliante in metallo duro integrale

Solid carbide one-tooth end mill

VHM - Einzahn-Schaftfräser - Fraise carbure, 1 lèvre

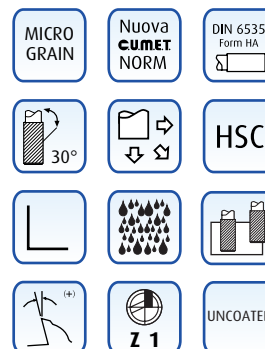
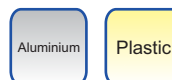
Фреза концевая твердосплавная с одним зубом - Sk jednozubé frézy



CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
100.010	1	2	5	40	1
100.010.1	1	3	5	40	1
100.015	1.5	3	6	40	1
100.020	2	2	10	40	1
100.020.1	2	3	10	40	1
100.030	3	3	10	40	1
100.030.1	3	6	12	50	1
100.040	4	4	15	50	1
100.040.1	4	6	15	50	1
100.050	5	5	15	50	1
100.060	6	6	20	50	1
100.080	8	8	22	60	1
100.100	10	10	25	70	1
100.120	12	12	35	75	1

→ Help 187

*d1 ≤ ø 6 h9
d1 ≤ ø12 f7



Fresa con fori in elica testa piana in metallo duro integrale

Solid carbide coolant feed flat nose end mill

VHM - Gesenkfräser mit Durchgewendelten Kühlkanälen - Fraise carbure à trous de refrigeration à bout plat

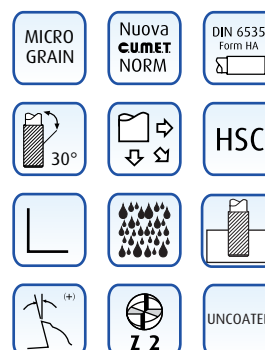
Фреза концевая твердосплавная с подачей СОЖ - Sk rohová fréza s chlazením všch zubů



CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
210.060	6	6	20	50	2
210.080	8	8	22	60	2
210.100	10	10	25	70	2
210.120	12	12	27	75	2
210.160	16	16	30	85	2
210.200	20	20	40	100	2

→ Help 198

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



Fresa con fori in elica testa piana in metallo duro integrale

Solid carbide coolant feed flat nose end mill

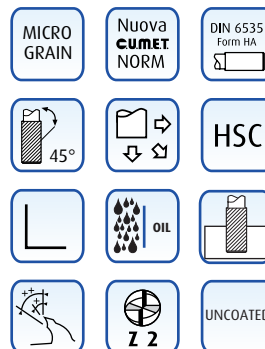
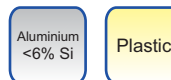
VHM - Gesenkräser mit Durchgewendelten Kühlkanälen - Fraise carbure à trous de refrigeration à bout plat
Фреза концевая твердосплавная с подачей СОЖ - Sk rohová fréza s chlazením všech zubů



CODE	d1h7 mm	d2h6 mm	l1 mm	L mm	Z no.
750.060	6	6	20	50	2
750.080	8	8	25	60	2
75008100	8	8	40	100	2
75008100.1	8	8	60	100	2
750.100	10	10	25	70	2
75010100	10	10	50	100	2
75010150	10	10	75	150	2
750.120	12	12	30	75	2
75012100	12	12	50	100	2
75012150	12	12	75	150	2
75014150	14	14	75	150	2
75014160	14	14	100	160	2
750.160	16	16	30	85	2
75016100	16	16	50	100	2
75018150	18	18	65	150	2
75018150.1	18	18	75	150	2
750.200	20	20	40	100	2
75020150	20	20	65	150	2

→ Help 187

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

VHM - Gesenkräser - Fraise carbure à bout plat

Фреза концевая твердосплавная с плоским торцом - Sk rohová fréza

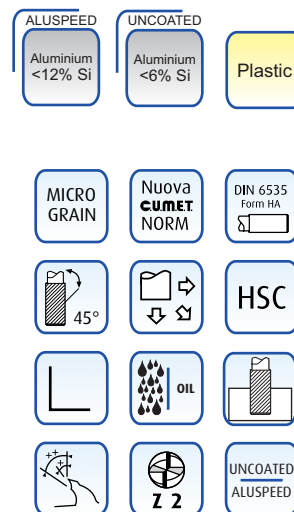
LOW SPEED



Code UNCOATED	Code ALUSPEED	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
700.010	700T.010	1	4	2	50	2
700.020	700T.020	2	6	6	50	2
700.030	700T.030	3	6	10	50	2
700.040	700T.040	4	6	15	50	2
70004060	700T04060	4	6	25	60	2
700.050	700T.050	5	6	20	50	2
70005060	700T05060	5	6	30	60	2
700.060	700T.060	6	6	20	50	2
70006100	700T06100	6	6	40	100	2
700.080	700T.080	8	8	25	60	2
70008100	700T08100	8	8	40	100	2
70008100.1	700T08100.1	8	8	60	100	2
700.100	700T.100	10	10	25	70	2
70010100	700T10100	10	10	50	100	2
70010150	700T10150	10	10	75	150	2
700.120	700T.120	12	12	30	75	2
70012100	700T12100	12	12	50	100	2
70012150	700T12150	12	12	75	150	2
700.140	700T.140	14	14	30	85	2
70014100	700T14100	14	14	50	100	2
70014150	700T14150	14	14	75	150	2
70014160	700T14160	14	14	100	160	2
700.160	700T.160	16	16	30	85	2
70016100	700T16100	16	16	50	100	2
70016150	700T16150	16	16	75	150	2
70016160	700T16160	16	16	100	160	2
700.180	700T.180	18	18	40	100	2
70018150	700T18150	18	18	65	150	2
70018150.1	700T18150.1	18	18	75	150	2
70018160	700T18160	18	18	100	160	2
700.200	700T.200	20	20	40	100	2
70020150	700T20150	20	20	65	150	2
70020150.1	700T20150.1	20	20	75	150	2
70020160	700T20160	20	20	100	160	2
700.250	700T.250	25	25	40	100	2
70025150	700T25150	25	25	65	150	2
70025150.1	700T25150.1	25	25	75	150	2
70025160	700T25160	25	25	100	160	2

→ Help 187

*d1 ≤ ø 6 h9
d1 ≤ ø25 h7



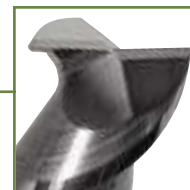
Fresa Alufast ad alto avanzamento testa piana in metallo duro itegrale

Alufast solid carbide high feed flat nose end mill

VHM-Alufast Gesenkräser - Fraise carbure Alufast à bout plat

Sk rohová fréza alufast

HIGH FEED

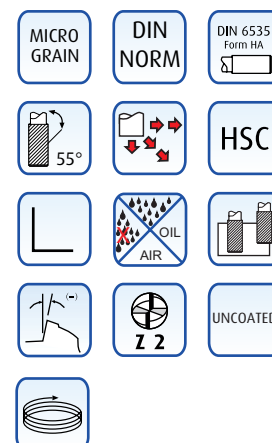


CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
755.030	3	6	9	57	2
755.040	4	6	12	57	2
755.050	5	6	15	57	2
755.060	6	6	18	57	2
755.080	8	8	20	63	2
755.100	10	10	25	70	2
755.120	12	12	25	75	2
755.160	16	16	32	85	2
755.200	20	20	40	100	2

→ Help 187

*d1 ≤ ø 6 h9
d1 ≤ ø20 h7

Aluminium



Fresa testa torcia antivibrante ad alto avanzamento in metallo duro integrale

Solid carbide corner radius end mill high feed

VHM- Stirn RadiusFräser High feed - Fraise carbure avec rayon d'angle à Haute avancement

Sk vysokorychlostní fréza s rohovým rádiusem

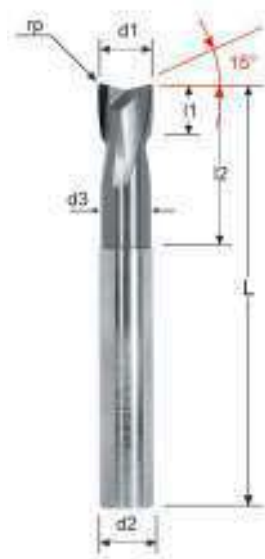


CODE	*d1 mm	d2h6 mm	rp-CH mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y703.030	3	6	0.05x45°	3	10	60	5.8	2
Y703.030.03	3	6	0.3	3	10	60	2.9	2
Y703.040	4	6	0.05x45°	3	10	60	2.9	2
Y703.040.05	4	6	0.5	3	10	60	2.9	2
Y703.050.05	5	6	0.5	3	10	60	2.9	2
Y703.060	6	6	0.05x45°	6	18	60	5.8	2
Y703.060.05	6	6	0.5	6	18	60	5.8	2
Y703.060.1	6	6	1	6	18	60	5.8	2
Y703.060.15	6	6	1.5	6	18	60	5.8	2
Y703.080	8	8	0.05x45°	8	24	75	7.8	2
Y703.080.05	8	8	0.5	8	24	75	7.8	2
Y703.080.1	8	8	1	8	24	75	7.8	2
Y703.080.15	8	8	1.5	8	24	75	7.8	2
Y703.080.2	8	8	2	8	24	75	7.8	2
Y703.100	10	10	0.05x45°	10	30	80	9.7	2
Y703.100.05	10	10	0.5	10	30	80	9.7	2
Y703.100.1	10	10	1	10	30	80	9.7	2
Y703.100.15	10	10	1.5	10	30	80	9.7	2
Y703.100.2	10	10	2	10	30	80	9.7	2
Y703.120	12	12	0.05x45°	12	36	100	11.7	2
Y703.120.05	12	12	0.5	12	36	100	11.7	2
Y703.120.1	12	12	1	12	36	100	11.7	2
Y703.120.15	12	12	1.5	12	36	100	11.7	2
Y703.120.2	12	12	2	12	36	100	11.7	2
Y703.120.3	12	12	3	12	36	100	11.7	2
Y703.160	16	16	0.05x45°	16	50	100	15.5	2
Y703.160.05	16	16	0.5	16	50	100	15.5	2
Y703.160.1	16	16	1	16	50	100	15.5	2
Y703.160.15	16	16	1.5	16	50	100	15.5	2
Y703.160.2	16	16	2	16	50	100	15.5	2
Y703.160.3	16	16	4	16	50	100	15.5	2
Y703.200	20	20	0.05x45°	20	60	109	19.5	2
Y703.200.1	20	20	1	20	60	109	19.5	2
Y703.200.2	20	20	2	20	60	109	19.5	2

→ Help 188

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



AL
Alloy

MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

10°

HSC

rp

45°

UNCOATED

(+)

Z 2

LAPPED

Fresa testa torica in metallo duro integrale

Solid carbide corner radius end mill

VHM - Gesenkräser mit Eckenradius - Fraise carbure avec rayon d'angle

Фреза концевая твердосплавная с угловым радиусом - Sk fréza s rohovým rádiusem



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
Y700R.030.05	3	6	0.5	4	10	75	2.95	2
Y700R.040.1	4	6	1.0	5	13	75	3.95	2
Y700R.050.15	5	6	1.5	6	14	75	4.8	2
Y700R.060.15	6	6	1.5	8	30	100	5.8	2
Y700R.080.2	8	8	2.0	10	30	100	7.8	2
Y700R.100.25	10	10	2.5	12	35	100	9.7	2
Y700R.120.3	12	12	3.0	12	40	100	11.7	2
Y700R.160.4	16	16	4.0	16	50	100	15.5	2

→ Help 188-189

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7

Ad esaurimento - by exhaustion



AL
Alloy

Plastic

SUB
MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

30°

HSC

rp

Z 2

SILVER

(+)

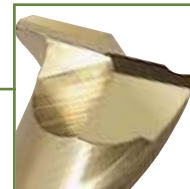
Z 2

Fresa testa torica in metallo duro integrale

Solid carbide corner radius end mill

VHM - Gesenckfräser mit Eckenradius - Fraise carbure avec rayon d'angle

Фреза концевая твердосплавная с угловым радиусом - Sk fréza s rohovým rádiusem



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	L mm	Z no.
730.030	3	6	0.2	10	50	2
730.040	4	6	0.2	15	50	2
730.050	5	6	0.2	20	50	2
730.060	6	6	0.2	20	50	2
730.080	8	8	0.3	25	60	2
730.100	10	10	0.3	25	70	2
730.120	12	12	0.3	30	75	2
730.140	14	14	0.5	30	85	2
730.160	16	16	0.5	30	85	2
730.200	20	20	0.5	40	100	2

→ Help 187

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



Aluminium
<12% Si

Plastic

MICRO
GRAIN

NUOVA
CUMET
NORM

DIN 6535
Form HA

45°

HSC

rp

OIL

(+)

Z 2

ALU
SPEED

rp
± 0.01

Fresa testa sferica 3D in metallo duro integrale

Solid carbide 3D ball nose end mill

VHM - 3D Radiusfräser - Fraise carbure 3D hémisphérique

Фреза концевая твердосплавная полусферическая 3D - Sk 3D kulová fréza



Code UNCOATED	Code ALUSPEED	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
700SR.030	700SRT.030	3	6	10	75	2
700SR.040	700SRT.040	4	6	10	75	2
700SR.060	700SRT.060	6	6	15	100	2
700SR.080	700SRT.080	8	8	20	100	2
700SR.100	700SRT.100	10	10	25	100	2
700SR.120	700SRT.120	12	12	25	100	2
700SR.160	700SRT.160	16	16	30	100	2
700SR.200	700SRT.200	20	20	30	100	2

→ Help 190

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



ALUSPEED

Aluminium
<12% Si

UNCOATED

Aluminium
<6% Si

Plastic

MICRO
GRAIN

NUOVA
CUMET
NORM

DIN 6535
Form HA

45°

HSC

U

OIL

(+)

Z 2

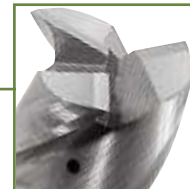
UNCOATED
ALUSPEED

R
± 0.01

Fresa con fori in elica in metallo duro integrale

Solid carbide coolant feed end mill

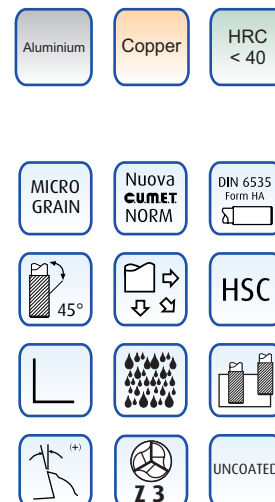
VHM - Schlichtfräser mit Durchgewendelten Kühlkanälen - Fraise carbure à trous de réfrigération
Фреза концевая твердосплавная с подачей СОЖ - Sk fréza s chlazením všech zubů



CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
453.060	6	6	20	50	3
453.080	8	8	22	60	3
453.100	10	10	25	70	3
45310100	10	10	45	100	3
453.120	12	12	27	75	3
45312100	12	12	45	100	3
453.160	16	16	30	85	3
45316100	16	16	45	100	3
453.180	18	18	40	100	3
453.200	20	20	40	100	3
45320150	20	20	65	150	3

→ Help 195

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

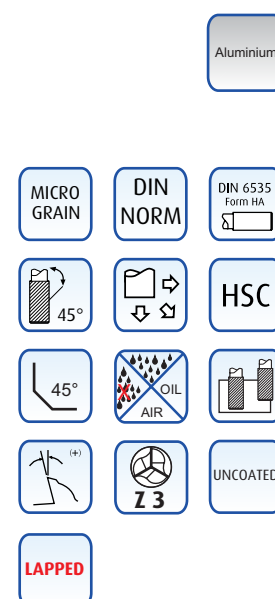
VHM - Gesenkräser - Fraise carbure à bout plat
Фреза концевая твердосплавная с плоским торцом - Sk rohová fréza



CODE	*d1 mm	d2h6 mm	CH mm	l1 mm	L mm	Z no.
456.030	3	6	0.05	10	57	3
456.040	4	6	0.05	15	57	3
456.050	5	6	0.05	18	57	3
456.060	6	6	0.05	20	57	3
456.080	8	8	0.05	25	63	3
456.100	10	10	0.05	25	70	3
456.120	12	12	0.05	30	83	3
456.160	16	16	0.05	32	92	3
456.200	20	20	0.05	38	100	3

→ Help 187

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



Fresa antivibrante a elica differenziata in metallo duro integrale

Solid carbide flat end mill differentiated helix anti-vibration

VHM-Schat fräser ungleiche drallwinkel - Fraise carbure à bout plat pour haut performance

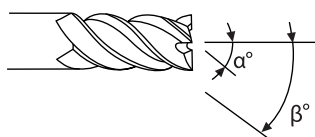
Фреза концевая твердосплавная с прямым зубом - Sk rohová fréza



CODE	*d1 mm	d2 mm	CH mm	l1 mm	L mm	Z no.
300V.030	3	6	0.2x45°	8	57	3
300V.040	4	6	0.2x45°	11	57	3
300V.050	5	6	0.2x45°	13	57	3
300V.060	6	6	0.2x45°	13	57	3
300V.080	8	8	0.3x45°	16	60	3
300V.100	10	10	0.3x45°	20	70	3
300V.120	12	12	0.3x45°	26	83	3
300V.160	16	16	0.3x45°	32	92	3
300V.200	20	20	0.3x45°	38	104	3

→ 187

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7



Fresa testa torica per alta velocità in metallo duro integrale

Solid carbide corner radius end mill for high speed

VHM-stirn radius fräser für High Speed - Fraise carbure avec rayon angle pour haut vitesse

Фреза твердосплавная концевая с угловым радиусом для высокоскоростной обработки

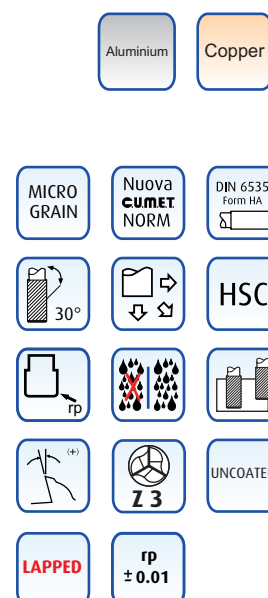
Sk vysokorychlostní fréza s rohovým rádiusem



CODE	*d1 mm	d2h6 mm	rp mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
756.060.1	6	6	1	7	20	75	5.5	3
756.080.1	8	8	1	9	26	75	7.5	3
756.100.15	10	10	1.5	11	31	80	9.5	3
756.100.25	10	10	2.5	11	31	80	9.5	3
756.120.15	12	12	1.5	13	37	100	11.5	3
756.120.25	12	12	2.5	13	37	100	11.5	3
756.160.2	16	16	2	17	43	100	15.5	3
756.160.25	16	16	2.5	17	43	100	15.5	3
756.200.2	20	20	2	21	53	100	19.5	3
756.200.25	20	20	2.5	21	53	100	19.5	3

→ Help 191

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7







Il mare non è altro che il veicolo di un'esistenza soprannaturale e prodigiosa;
non è che ***movimento*** e amore, è l'infinito vivente, come ha detto uno dei vostri poeti.

La mer n'est que le véhicule d'une surnaturelle et prodigieuse existence;
elle n'est que ***mouvement*** et amour. c'est l'infini vivant,
comme l'a dit un de vos poètes.

Jules Verne

Frese a sgrossare

Roughing end mills

Schruppfräser
Fraises d'ébauche
Фрезы концевые для черновой обработки
Hrubovací fréza



Fresa a semifinire in metallo duro integrale

Solid carbide semi-finishing end mill

VHM - Schrapp Schlichtfräser - Fraise carbure pour semifinition

Фреза концевая твердосплавная для полужесткой обработки - Sk polodokončovací fréza

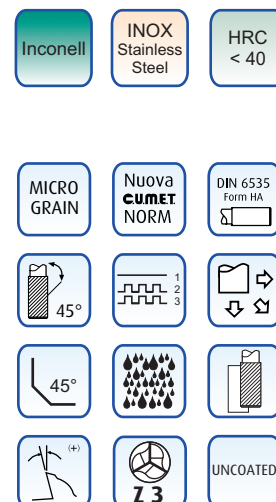


CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
451.060	6	6	16	50	3
451.080	8	8	20	60	3
45108100	8	8	40	100	3
451.100	10	10	22	70	3
45110100	10	10	45	100	3
451.120	12	12	27	75	3
45112100	12	12	45	100	3
451.140	14	14	27	85	3
451.150	15	15	30	85	3
451.160	16	16	30	85	3
45116100	16	16	45	100	3
45116150	16	16	65	150	3
451.180	18	18	38	100	3
451.200	20	20	38	100	3
45120150	20	20	65	150	3

→ Help 192

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



Frese rompitruciolo in metallo duro integrale

Solid carbide roughing end mill

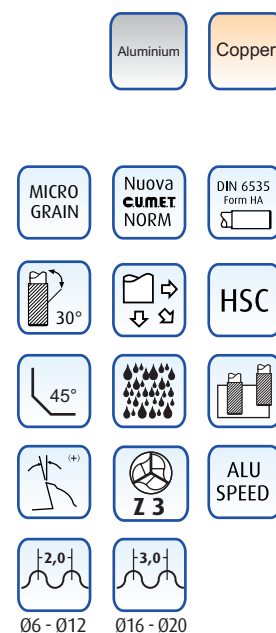
VHM-Schrappfräser - Fraise carbure à degrossir

Фреза твердосплавная концевая черновая - Sk hrubovací fréza



CODE	d1h11 mm	d2h6 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
T220206057	6	6	13	-	57	-	3
T220208063	8	8	19	-	63	-	3
T220208075	8	8	19	35	75	7.4	3
T220208075.1	8	8	28	-	75	-	3
T220210072	10	10	22	-	72	-	3
T220210080	10	10	22	43	80	9.5	3
T220210080.1	10	10	34	-	80	-	3
T220212083	12	12	26	-	83	-	3
T220212100	12	12	26	50	100	11.5	3
T220212100.1	12	12	40	-	100	-	3
T220216092	16	16	32	-	92	-	3
T220216109	16	16	32	60	109	15.5	3
T220216100	16	16	45	-	100	-	3
T220220100	20	20	40	-	100	-	3
T220220120	20	20	40	70	120	19.5	3
T220220150	20	20	65	-	150	-	3

→ Help 191



Fresa a sgrossare in metallo duro integrale

Solid carbide roughing end mill

VHM - Schrappfräser - Fraise carbure à dégrossir

Фреза концевая твердосплавная для черновой обработки - Sk hrubovací fréza

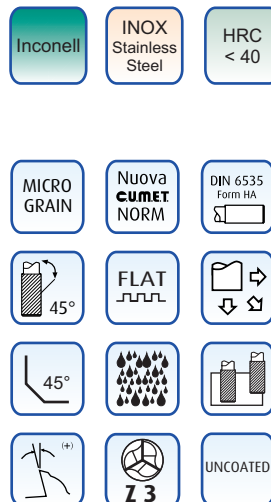


CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
452.030	3	3	10	40	3
452.035	3.5	3.5	10	40	3
452.040	4	4	12	50	3
452.045	4.5	4.5	12	50	3
452.050	5	5	12	50	3
452.060	6	6	16	50	3
452.080	8	8	20	60	3
452.090	9	9	20	70	3
452.100	10	10	22	70	3
452.110	11	11	22	70	3
452.120	12	12	27	75	3
452.140	14	14	27	85	3
452.150	15	15	30	85	3
452.160	16	16	30	85	3
452.180	18	18	38	100	3
452.200	20	20	38	100	3

→ Help 192

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



Fresa a sgrossare in metallo duro integrale

Solid carbide roughing end mill

VHM - Schrappfräser - Fraise carbure à dégrossir

Фреза концевая твердосплавная для черновой обработки - Sk hrubovací fréza

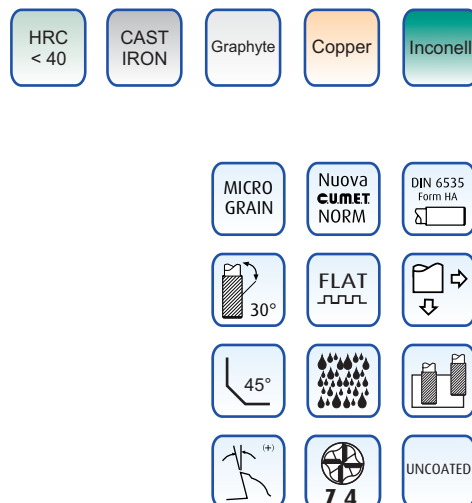


CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
T2006	6	6	20	50	4
T2006L	6	6	40	100	4
T2008	8	8	22	60	4
T2008L	8	8	40	100	4
T2010	10	10	25	70	4
T2010L	10	10	45	100	4
T2012	12	12	27	75	4
T2012L	12	12	45	100	4
T2012L.1	12	12	75	150	4
T2014	14	14	27	85	4
T2014L	14	14	45	100	4
T2014L.1	14	14	65	150	4
T2016	16	16	30	85	4
T2016L	16	16	45	100	4
T2016L.1	16	16	75	150	4
T2018	18	18	40	100	4
T2018L	18	18	65	150	4
T2018L.1	18	18	75	150	4
T2020	20	20	40	100	4
T2020L	20	20	55	150	4
T2020L.1	20	20	65	150	4
T2020L.2	20	20	75	150	4
T2025	25	25	40	100	4
T2025L	25	25	65	150	4
T2025L.1	25	25	75	150	4

→ Help 192

*d1 ≤ ø 6 h9

d1 ≤ ø25 f7



Fresa a semifinire in metallo duro integrale

Solid carbide semi-finishing end mill

VHM - Schrupp Schlichtfräser - Fraise carbure pour semifinition

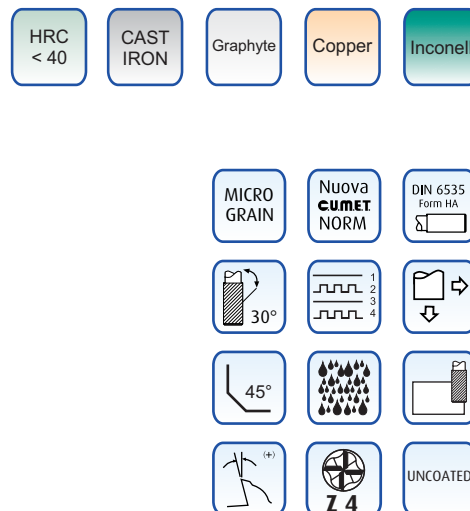
Фреза концевая твердосплавная для получистовой обработки - Sk polodokončovací fréza



CODE	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
T4006	6	6	20	50	4
T4006L	6	6	40	100	4
T4008	8	8	22	60	4
T4008L	8	8	40	100	4
T4010	10	10	25	70	4
T4010L	10	10	45	100	4
T4012	12	12	27	75	4
T4012L	12	12	45	100	4
T4012L.1	12	12	75	150	4
T4014	14	14	27	85	4
T4014L	14	14	45	100	4
T4014L.1	14	14	65	150	4
T4016	16	16	30	85	4
T4016L	16	16	45	100	4
T4016L.1	16	16	75	150	4
T4018	18	18	40	100	4
T4018L	18	18	65	150	4
T4018L.1	18	18	75	150	4
T4020	20	20	40	100	4
T4020L	20	20	55	150	4
T4020L.1	20	20	65	150	4
T4020L.2	20	20	75	150	4
T4025	25	25	40	100	4
T4025L	25	25	65	150	4
T4025L.1	25	25	75	150	4

*d1 ≤ ø 6 h9
d1 ≤ ø25 f7

→ Help 192



Fresa rompitruciolo antivibrante in metallo duro integrale

Solid carbide anti-vibration roughing end mill

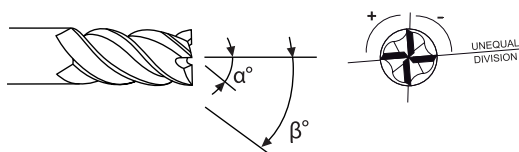
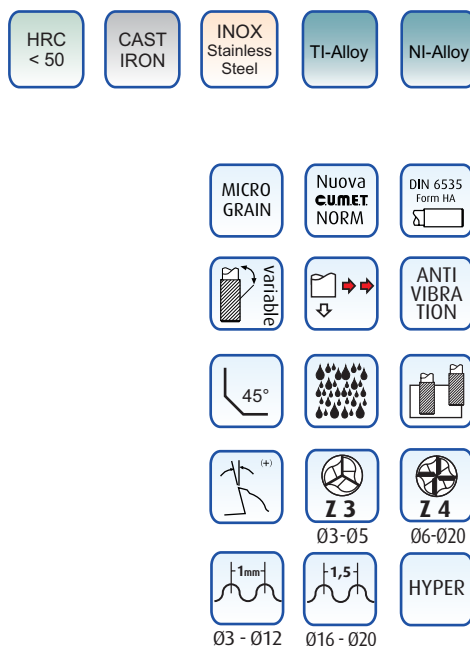
VHM - Schruppfräser Schwingungsdämpfer - Fraise carbure à dégrossir à Haute Performance

Фреза концевая твердосплавная для черновой обработки высокопроизводительная
Sk hrubovací vysoce výkonná fréza



CODE	d1h11 mm	d2h6 mm	l1 mm	L mm	Z no.
T220103050	3	6	8	50	3
T220104050	4	6	12	50	3
T220105050	5	6	15	50	3
T220106050	6	6	16	50	4
T220108060	8	8	22	60	4
T220110070	10	10	25	70	4
T220112075	12	12	27	75	4
T220116085	16	16	30	85	4
T220116100	16	16	45	100	4
T220116150	16	16	65	150	4
T220120100	20	20	40	100	4
T220120150	20	20	65	150	4

→ Help 182



Fresa rompitruciolo in metallo duro integrale

Solid carbide roughing end mill

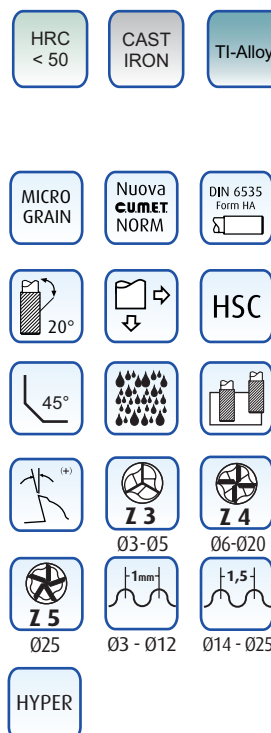
VHM - Schrappfräser - Fraise carbure profil ébauche

Фреза концевая твердосплавная для черновой обработки - Sk hrubovací fréza



CODE	d1h11 mm	d2h6 mm	l1 mm	L mm	Z no.	α°
T220303050	3	6	8	50	3	13°
T220304050	4	6	12	50	3	14°
T220305050	5	6	15	50	3	4° 1/2
T220306050	6	6	20	50	4	-
T220306100	6	6	40	100	4	-
T220308060	8	8	22	60	4	-
T220308100	8	8	40	100	4	-
T220310070	10	10	25	70	4	-
T220310100	10	10	45	100	4	-
T220312075	12	12	27	75	4	-
T220312100	12	12	45	100	4	-
T220314085	14	14	27	85	4	-
T220314100	14	14	45	100	4	-
T220314150	14	14	65	150	4	-
T220316085	16	16	30	85	4	-
T220316100	16	16	45	100	4	-
T220316150	16	16	75	150	4	-
T220318100	18	18	40	100	4	-
T220318150	18	18	65	150	4	-
T220318150.1	18	18	75	150	4	-
T220320100	20	20	40	100	4	-
T220320150	20	20	65	150	4	-
T220320150.1	20	20	75	150	4	-
T220325100	25	25	40	100	5	-
T220325150	25	25	65	150	5	-
T220325150.1	25	25	75	150	5	-

→ Help 192



Fresa rompitruciolo in metallo duro integrale

Solid carbide roughing end mill

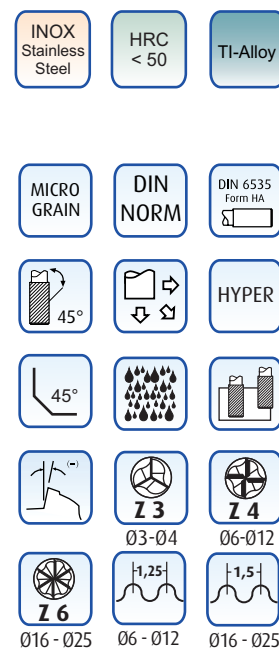
VHM - Schrappfräser - Fraise carbure profil ébauche

Фреза концевая твердосплавная для черновой обработки - Sk hrubovací fréza



CODE	d1h11 mm	d2h6 mm	l1 mm	L mm	Z no.	α°
T22040308057	3	6	8	57	3	13°
T22040412057	4	6	12	57	3	14°
T22040613057	6	6	13	57	4	4° 1/2
T22040816063	8	8	16	63	4	-
T22041022070	10	10	22	70	4	-
T22041226075	12	12	26	75	4	-
T22041632092	16	16	32	92	6	-
T22042038104	20	20	38	104	6	-
T22042545121	25	25	45	121	6	-

→ Help 184



Fresa rompitruciolo testa raggiata in metallo duro integrale

Solid carbide ball nose roughing end mill

VHM - Radius Schruffräser - Fraise carbure hémisphérique a profil ébauche

Фреза концевая твердосплавная для черновой обработки - Sk kulová hrubovací fréza



CODE	d1h11 mm	d2h6 mm	l1 mm	L mm	Z no.
T2204R.050	5	6	13	57	3
T2204R.060	6	6	13	57	3
T2204R.080	8	8	16	63	4
T2204R.100	10	10	22	70	4
T2204R.120	12	12	26	75	4
T2204R.140	14	14	26	85	4
T2204R.160	16	16	32	92	4
T2204R.180	18	18	32	92	4
T2204R.200	20	20	38	100	4

→ Help 198

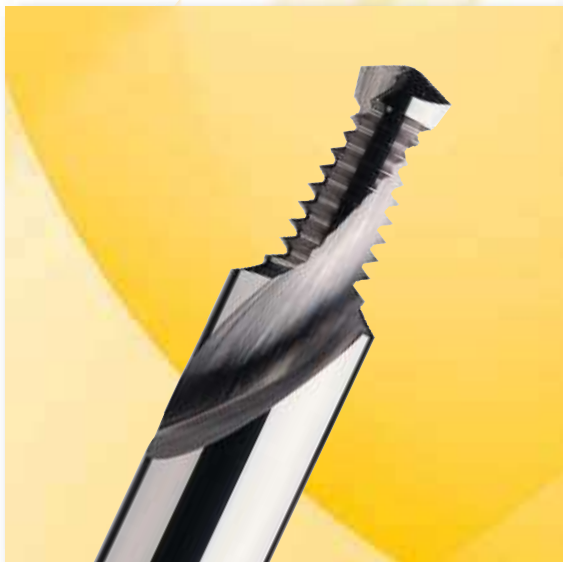
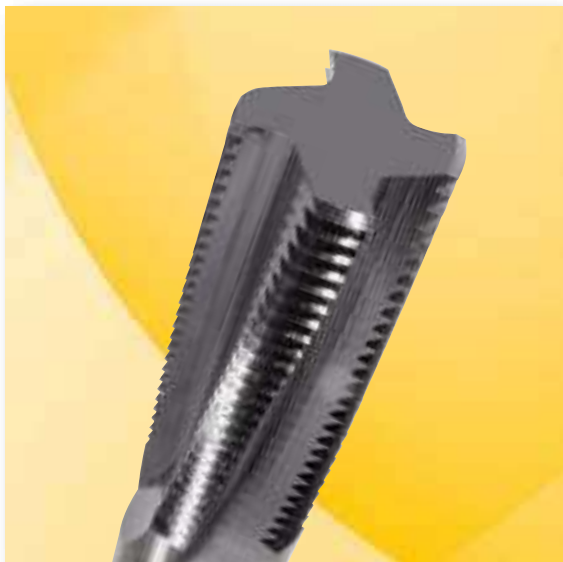


INOX Stainless Steel	CAST IRON	HRC < 50
MICRO GRAIN	DIN NORM	DIN 6535 Form HA
45°	HYP	HYPER
U	DR	DR
13	13	14
05-06	08-020	
06 - 012	014 - 020	

Frese a filettare

Thread Milling end mills

Gewinderfräser
Fraises à fileter
Фрезы резьбонарезные
Frézy pro frézování závitů



Fresa a filettare in metallo duro integrale

Solid carbide thread end mill

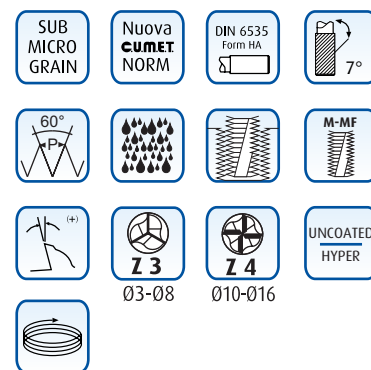
VHM - Gewinderfräser - Fraise carbure à fileter

Фреза резьбонарезная твердосплавная - Sk frézy pro frézování závitů



CODE UNCOATED	CODE HYPER	DIN mm	P mm	d hole mm	d1e9 mm	d2h6 mm	l1 mm	L mm	Z no.
600.04.050	600T.04.050	MF4	0.5	3.5	3.0	6	16	57	3
600.04.070	600T.04.070	M4	0.7	3.3	3.0	6	11	57	3
600.05.050	600T.05.050	MF5	0.5	4.5	3.8	6	20	57	3
600.05.080	600T.05.080	M5	0.8	4.2	3.8	6	12	57	3
600.06.075	600T.06.075	MF6	0.75	5.2	4.8	6	12	57	3
600.06.100	600T.06.100	M6	1.0	5.0	4.8	6	12	57	3
600.08.100	600T.08.100	MF8	1.0	7.0	6.0	6	15	57	3
600.08.125	600T.08.125	M8	1.25	6.8	6.0	6	15	57	3
600.10.100	600T.10.100	MF10	1.0	9.0	8.0	8	20	60	3
600.10.150	600T.10.150	M10	1.5	8.5	8.0	8	20	60	3
600.12.100	600T.12.100	MF12	1.0	11.0	8.0	8	20	60	3
600.12.150	600T.12.150	MF12	1.5	10.5	8.0	8	20	60	3
600.12.175	600T.12.175	M12	1.75	10.2	8.0	8	20	60	3
600.14.150	600T.14.150	MF14	1.5	12.5	10.0	10	25	70	4
600.14.200	600T.14.200	M14	2.0	12.0	10.0	10	25	70	4
600.16.150	600T.16.150	MF16	1.5	14.5	12.0	12	25	75	4
600.16.200	600T.16.200	M16	2.0	14.0	12.0	12	25	75	4
600.20.100	600T.20.100	MF20	1.0	19.0	16.0	16	40	100	4
600.20.150	600T.20.150	MF20	1.5	18.5	16.0	16	40	100	4
600.20.200	600T.20.200	M20	2.0	18.0	16.0	16	40	100	4
600.20.250	600T.20.250	M20	2.5	17.5	16.0	16	40	100	4

→ Help 205



Fresa fora, filetta e Smussa in metallo duro integrale senza fori di refrigerazione

Solid carbide threading, drilling, chamfering end mill without coolant holes

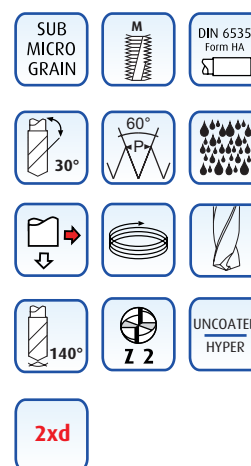
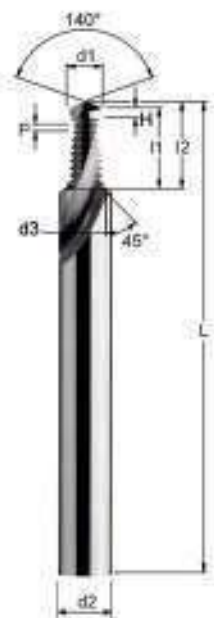
Fraise a fileter, forer et chanfreiner en carbure sans trous de réfrigération

Комбинированные твердосплавные инструменты для сверления, обработки фасок и нарезания резьбы без внутреннего подвода СОЖ or – Dokončovací fréza se sraženým rohem bez vnitřního chlazení



CODE UNCOATED	CODE HYPER	Filetto Thread	P mm	d1h7 mm	d2h6 mm	d3 mm	H mm	l1 mm	l2 mm	L mm	Z mm
620.04.070	620T.04.070	M4	0.7	3.3	6	4.3	0.7	8.9	9.4	57	2
620.05.080	620T.05.080	M5	0.8	4.2	6	5.3	0.8	11	11.7	57	2
620.06.100	620T.06.100	M6	1	5	8	6.3	1	13.7	14.5	63	2
620.08.125	620T.08.125	M8	1.25	6.75	10	8.3	1.3	17.1	18.2	72	2
620.10.150	620T.10.150	M10	1.5	8.5	12	10.3	1.5	22.1	23.4	83	2
620.12.175	620T.12.175	M12	1.75	10.25	14	12.3	1.5	25.5	27.1	85	2
620.14.200	620T.14.200	M14	2	12	16	14.3	1.5	30.9	32.8	92	2
620.16.200	620T.16.200	M16	2	14	18	16.3	1.5	35	37.1	100	2

→ Help 206

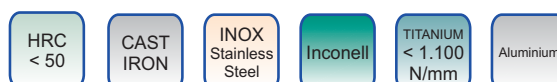


Frese fora, filetta e Smussa in metallo duro integrale con fori di refrigerazione

Solid carbide threading, drilling, chamfering end mill with coolant holes

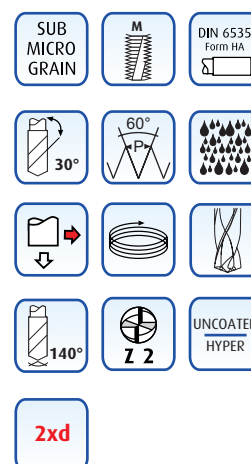
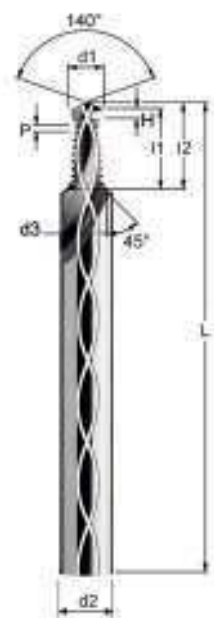
Fraise a fileter, forer et chanfreiner en carbure avec trous de réfrigération

Комбинированные твердосплавные инструменты для сверления, обработки фасок и нарезания резьбы со внутренним подводом СОЖ or – Dokončovací fréza se sraženým rohem bez vnitřního chlazení



CODE UNCOATED	CODE HYPER	Filetto Thread	P mm	d1h7 mm	d2h6 mm	d3 mm	H mm	l1 mm	l2 mm	L mm	Z mm
620F.04.070	620FT.04.070	M4	0.7	3.3	6	4.3	0.7	8.9	9.4	57	2
620F.05.080	620FT.05.080	M5	0.8	4.2	6	5.3	0.8	11	11.7	57	2
620F.06.100	620FT.06.100	M6	1	5	8	6.3	1	13.7	14.5	63	2
620F.08.125	620FT.08.125	M8	1.25	6.75	10	8.3	1.3	17.1	18.2	75	2
620F.10.150	620FT.10.150	M10	1.5	8.5	12	10.3	1.5	22.1	23.4	80	2
620F.12.175	620FT.12.175	M12	1.75	10.25	14	12.3	1.5	25.5	27.1	100	2
620F.14.200	620FT.14.200	M14	2	12	16	14.3	1.5	30.9	32.8	100	2
620F.16.200	620FT.16.200	M16	2	14	18	16.3	1.5	35	37.1	100	2

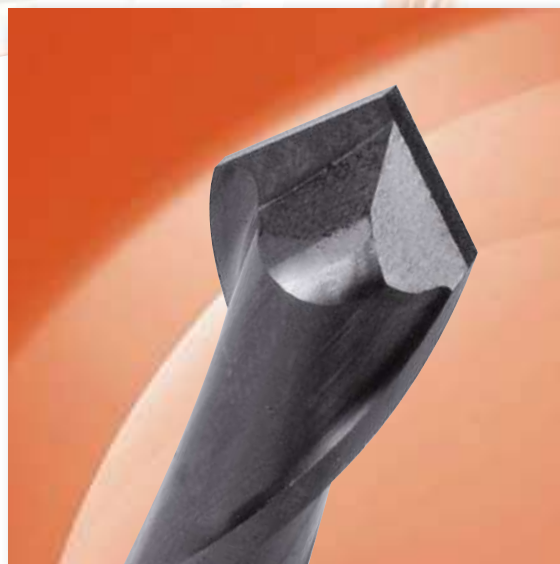
→ Help 206



Frese per svasatura

Countersink end mills

Kegelsenker fräser
Fraises à ébavurer
Зенкеры
Záhlubníky, srážče



Fresa per esecuzione raggi in metallo duro integrale

Solid carbide concave radius end mill

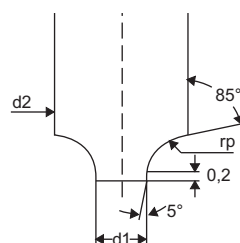
VHM- Viertelkreisentgrater - Fraise en carbure a rayon concave

Фреза твердосплавная концевая с радиусом - Fréza pro zaoblení hran



CODE UNCOATED	CODE HYPER	d1 mm	d2h6 mm	rp mm	L mm	Z no.
CTK.R0020	CTK.RT0020	5.4	6	0.2	50	4
CTK.R0025	CTK.RT0025	5.3	6	0.25	50	4
CTK.R0030	CTK.RT0030	5.2	6	0.3	50	4
CTK.R0040	CTK.RT0040	5	6	0.4	50	4
CTK.R0050	CTK.RT0050	6.8	8	0.5	50	4
CTK.R0060	CTK.RT0060	6.6	8	0.6	50	4
CTK.R0075	CTK.RT0075	6.3	8	0.75	50	4
CTK.R0080	CTK.RT0080	6.2	8	0.8	50	4
CTK.R0100	CTK.RT0100	5.8	8	1	50	4
CTK.R0125	CTK.RT0125	5.3	8	1.25	50	4
CTK.R0150	CTK.RT0150	6.8	10	1.5	50	4
CTK.R0175	CTK.RT0175	6.3	10	1.75	50	4
CTK.R0200	CTK.RT0200	7.8	12	2	50	4
CTK.R0225	CTK.RT0225	7.3	12	2.25	50	4
CTK.R0250	CTK.RT0250	6.8	12	2.5	50	4
CTK.R0275	CTK.RT0275	6.3	12	2.75	50	4
CTK.R0300	CTK.RT0300	5.8	12	3	63	4
CTK.R0351	CTK.RT0351	8.6	16	3.5	80	4
CTK.R0401	CTK.RT0401	7.6	16	4	80	4
CTK.R0451	CTK.RT0451	6.6	16	4.5	80	4
CTK.R0501	CTK.RT0501	9.6	20	5	80	4
CTK.R0601	CTK.RT0601	7.6	20	6	80	4

→ Help 193



HRC < 60

CAST IRON

NE NON FERROUS

INOX Stainless Steel

MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

0°

rp

Z 4

UNCOATED HYPER

d1 -0 -0.1

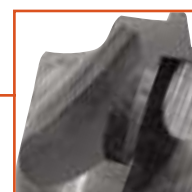
Fresa per esecuzione raggi gambo in HSS

Concave radius end mill with Steel Shank

Viertelkreisentgrater mit stal Schaft - Fraise a rayon concave avec queue en acier

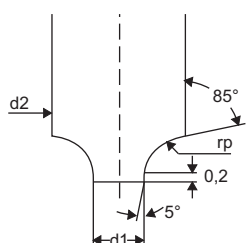
Фреза твердосплавная концевая с радиусом со стальным хвостовиком

Fréza pro zaoblení hran s ocelovou stopkou



CODE	d1 mm	d2 mm	d3h7 mm	rp mm	L mm	Z no.
CTK.R0350	7.6	15	12	3.5	82	4
CTK.R0400	6.6	15	12	4	82	4
CTK.R0450	7.6	17	12	4.5	85	4
CTK.R0500	8.6	19	12	5	85	4
CTK.R0600	7.6	20	12	6	85	4
CTK.R0800	7.6	24	20	8	93	4
CTK.R1000	10.6	31	20	10	98	4
CTK.R1200	12.6	37	20	12	100	6

→ Help 193



HRC < 40

CAST IRON

NE NON FERROUS

INOX Stainless Steel

MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

0°

rp

Z 4

Z 6

015-031

037

UNCOATED

d1 -0 -0.1

Fresa multifunzione a 90°

Solid carbide multimill 90°

VHM- Multimill 90° - Fraise en carbure multifunction 90° - Sk fréza pro zaoblení hran



CODE UNCOATED	CODE HYPER	d1h7 mm	d2h6 mm	l1 mm	L mm	S mm	Z no.
200V.001	200VT.001	0.1	3	0.2	40	0.01	2
200V.002	200VT.002	0.2	3	0.4	40	0.02	2
200V.003	200VT.003	0.3	3	0.6	40	0.03	2
200V.004	200VT.004	0.4	3	0.8	40	0.04	2
200V.005	200VT.005	0.5	3	1	40	0.05	2
200V.006	200VT.006	0.6	3	1.2	40	0.06	2
200V.007	200VT.007	0.7	3	1.4	40	0.07	2
200V.008	200VT.008	0.8	3	1.6	40	0.08	2
200V.009	200VT.009	0.9	3	1.8	40	0.09	2
200V.010	200VT.010	1	3	2	40	0.10	2
200V.011	200VT.011	1.1	3	2.2	40	0.11	2
200V.012	200VT.012	1.2	3	2.4	40	0.12	2
200V.013	200VT.013	1.3	3	2.6	40	0.13	2
200V.014	200VT.014	1.4	3	2.8	40	0.14	2
200V.015	200VT.015	1.5	3	3	40	0.15	2
200V.016	200VT.016	1.6	3	3.2	40	0.16	2
200V.017	200VT.017	1.7	3	3.4	40	0.17	2
200V.018	200VT.018	1.8	3	3.6	40	0.18	2
200V.019	200VT.019	1.9	3	3.8	40	0.19	2
200V.020	200VT.020	2	3	4	40	0.20	2
200V.025	200VT.025	2.5	3	5	40	0.25	2
200V.030	200VT.030	3	4	6	50	0.30	2
200V.040	200VT.040	4	5	8	50	0.40	2
200V.050	200VT.050	5	6	10	50	0.50	2
200V.060	200VT.060	6	8	12	60	0.60	2
200V.080	200VT.080	8	10	16	70	0.80	2
200V.100	200VT.100	10	12	18	75	1.00	2
200V.120	200VT.120	12	12	20	75	1.20	2
200V.160	200VT.160	16	16	26	85	1.60	2
200V.200	200VT.200	20	20	32	100	2.00	2

→ Help 199



Sbavatore a spingere e a tirare in metallo duro integrale

Solid carbide forward and backward burr remover end mill

VHM-Vorwärts und Rückwärtsgentgrater - Fraise en carbure de retoucher bavure en deux direction

Фреза твердосплавная концевая с поступательным движением - Sk fréza pro čelní a zpětné sražení hran



CODE	d1 mm	d2h6 mm	S MAX mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
CTM.010060	1	3	0.3	0.5	5.5	60	0.7	3
CTM.015060	1.5	3	0.45	0.7	6.7	60	1.1	3
CTM.018060	1.8	3	0.6	0.75	8.7	60	1.5	3
CTM.020060	2	3	0.6	0.95	9	60	1.5	3
CTM.028060	2.8	3	0.9	1.3	10	60	2.1	3
CTM.028100	2.8	6	1.2	1.1	11	100	2.2	4
CTM.030060	3	3	0.9	1.5	11.5	60	2.1	3
CTM.030100	3	6	1.2	1.3	10	100	2.2	4
CTM.038100	3.8	6	1.6	1.55	14	100	2.9	4
CTM.040100	4	6	1.6	1.75	14	100	2.9	4
CTM.048100	4.8	6	2	2.1	17	100	3.4	4
CTM.050100	5	6	2	2.3	17	100	3.4	4
CTM.058100	5.8	6	2.4	2.7	20	100	3.8	4
CTM.060100	6	6	2.4	2.9	21	100	3.8	4
CTM.078100	7.8	6	4.9	2.8	37	100	4.9	4
CTM.080100	8	6	4.9	3.1	37	100	4.9	4
CTM.098100	9.8	6	5.9	3.8	38	100	5.9	4
CTM.100100	10	6	5.9	4.1	38	100	5.9	4
CTM.118100	11.8	6	5.9	5.8	40	100	5.9	4
CTM.120100	12	6	5.9	6.1	40	100	5.9	4

→ Help 204



Fresa a 60°-90° in metallo duro integrale

Solid carbide 60°-90° end mill

VHM-Entgrater 60°-90° - Fraise en carbure a Chanfrein 60°-90°

Фреза твердосплавная концевая, угол наклона винтовой канавки 60°- 90°- Sk fréza 60°-90°



CODE 60°	d1 mm	d2h6 mm	l1 mm	L mm	Z no.
CTS60.030	0.3	3	2.6	50	3
CTS60.040	0.4	4	3.4	50	4
CTS60.060	0.6	6	5.2	57	4
CTS60.080	0.8	8	6.9	60	5
CTS60.100	1.0	10	8.7	70	6
CTS60.120	1.2	12	10.4	75	6

CODE 90°	d1 mm	d2h6 mm	l1 mm	L mm	Z no.
CTS90.030	0.3	3	1.5	50	3
CTS90.040	0.4	4	2	50	4
CTS90.060	0.6	6	3	57	4
CTS90.080	0.8	8	4	60	5
CTS90.100	1.0	10	5	70	6
CTS90.120	1.2	12	6	75	6

→ Help 201



HRC < 60

CAST IRON

INOX Stainless Steel

Inconell

MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

0°

30°

45°

Z 4

Z 5

Z 6

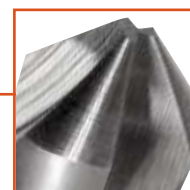
Ø10 - Ø16

d1 -0 -0.1

Svasatore a 60°-90°

Countersink 60°-90°

Kegelsenker 60°-90° - Chanfrein 60°-90° - Záhlučníky, srážeče 60°-90°



CODE 60°	CODE 90°	d1 mm	d3 mm	d2 mm	L mm	Z no.	DIN
CTK60053/3	CTK90053/3	5.3	1.5	6	50	3	M2.6
CTK60058/3	CTK90058/3	5.8	1.5	6	50	3	M3.0
CTK60063/3	CTK90063/3	6.3	1.5	6	50	3	M3.5
CTK60073/3	CTK90073/3	7.3	1.8	6	50	3	M4.0
CTK60083/3	CTK90083/3	8.3	2.0	6	50	3	-
CTK60094/3	CTK90094/3	9.4	2.2	6	50	3	M5.0
CTK60104/3	CTK90104/3	10.4	2.5	6	54	3	M6.0
CTK60124/3	CTK90124/3	12.4	2.8	6	54	3	-
CTK60165/3	CTK90165/3	16.5	3.2	6	60	3	-
CTK60165/3.1	CTK90165/3.1	16.5	3.2	10	60	3	-
CTK60205/3	CTK90205/3	20.5	3.5	10	63	3	-
CTK60250/3	CTK90250/3	25.0	3.8	10	66	3	M12

→ Help 193

Dal Ø 7,3 mm gambo in acciaio
From Ø 7,3 mm Steel Shank
Von Ø 7,3 mm Stahl Shaft



HRC < 40

CAST IRON

INOX Stainless Steel

Inconell

NON FERROUS

MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

0°

60°-90°

UNCOATED

Z 3

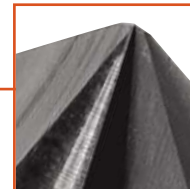
d1 -0 -0.1

Punta a forare e svasare in metallo duro integrale

Solid carbide chanfer and spot drill

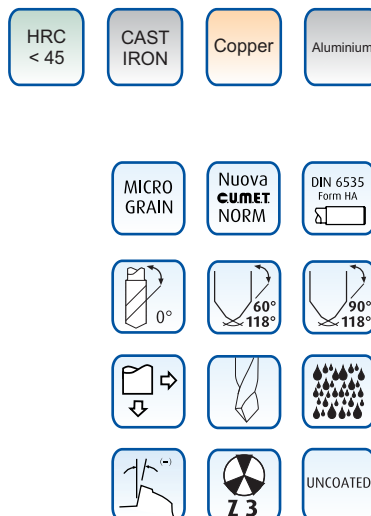
VHM - Anböhler - Fraise carbure

Сверло твердосплавное - Sk srážecí a navrtávký



CODE	d2h6 mm	l1 mm	l2 mm	L mm	Z no.
142.060	6	2.5	4.5	50	3
142.080	8	3.5	6.0	60	3
142.100	10	4.5	8.0	70	3
142.120	12	5.5	9.5	75	3

→ Help 201



Frese convenzionali

Conventional end mills

Universal Fräser
Fraises universelle
Фрезы концевые стандартные
Konvenční frézy

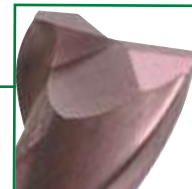


Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

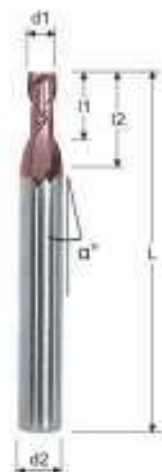
VHM - Schaftfräser - Fraise carbure à bout plat

Фреза концевая твердосплавная с прямым зубом - Sk rohová fréza



CODE	d1h9 mm	d2h6 mm	l1 mm	L mm	Z no.	α°
201.010.4	1	4	2	50	2	15°
201.010	1	6	2.5	50	2	15°
201.015.4	1.5	4	3	50	2	15°
201.015	1.5	6	4	50	2	15°
201.020.4	2	4	4	50	2	15°
201.020	2	6	6	50	2	15°
201.025	2.5	6	6	50	2	15°
201.030.4	3	4	6	50	2	15°
201.030	3	6	7	50	2	15°
201.035	3.5	6	7	50	2	15°
201.040	4	6	8	50	2	10°
201.045	4.5	6	9	50	2	10°
201.050	5	6	10	50	2	5°
201.055	5.5	6	10	50	2	5°
201.060	6	6	12	50	2	-

→ Help 198-202



Fresa testa raggiata in metallo duro integrale

Solid carbide ball nose end mill

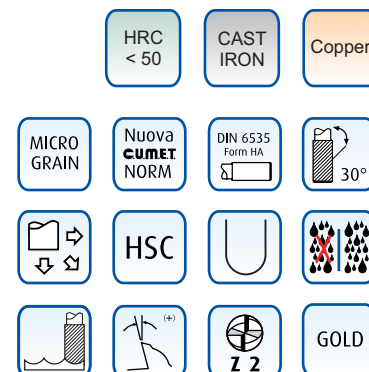
VHM - Radiusfräser - Fraise carbure à bout hémisphérique

Фреза концевая твердосплавная полусферическая - Sk kulová fréza



CODE	d1h9 mm	d2h6 mm	l1 mm	L mm	Z no.	α°
201R.010.4	1	4	2	50	2	15°
201R.010	1	6	2.5	50	2	15°
201R.015.4	1.5	4	3	50	2	15°
201R.015	1.5	6	4	50	2	15°
201R.020.4	2	4	4	50	2	15°
201R.020	2	6	6	50	2	15°
201R.025	2.5	6	6	50	2	15°
201R.030.4	3	4	6	50	2	15°
201R.030	3	6	7	50	2	15°
201R.035	3.5	6	7	50	2	15°
201R.040	4	6	8	50	2	10°
201R.045	4.5	6	9	50	2	10°
201R.050	5	6	10	50	2	5°
201R.055	5.5	6	10	50	2	5°
201R.060	6	6	12	50	2	-

→ Help 200



Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

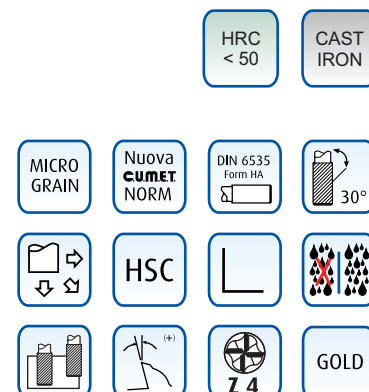
VHM - Schaftfräser - Fraise carbure à bout plat

Фреза концевая твердосплавная с прямым зубом - Sk rohová fréza



CODE	d1h9 mm	d2h6 mm	l1 mm	L mm	Z no.	α°
401.010.4	1	4	2	50	2	15°
401.010	1	6	2.5	50	4	15°
401.015.4	1.5	4	3	50	2	15°
401.015	1.5	6	4	50	4	15°
401.020.4	2	4	5	50	4	15°
401.020	2	6	6	50	4	15°
401.025	2.5	6	6	50	4	15°
401.030.4	3	4	7	50	2	15°
401.030	3	6	7	50	4	15°
401.035	3.5	6	7	50	4	15°
401.040	4	6	8	50	4	10°
401.045	4.5	6	9	50	4	10°
401.050	5	6	10	50	4	5°
401.055	5.5	6	10	50	4	5°
401.060	6	6	12	50	4	-

→ Help 200-202

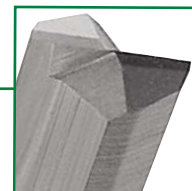


Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

VHM - Schaftfräser - Fraise carbure à bout plat

Фреза концевая твердосплавная с прямым зубом - Sk rohová fréza

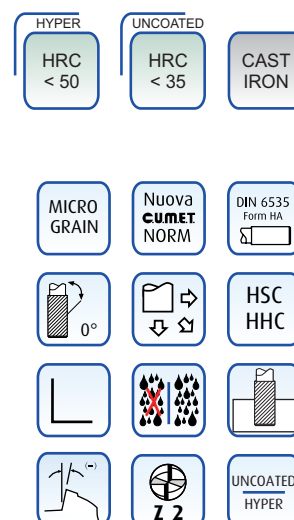


CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
200D.010	200DT.010	1	3	2.5	40	2
200D.015	200DT.015	1.5	3	4	40	2
200D.020	200DT.020	2	3	6	40	2
200D.025	200DT.025	2.5	3	6	40	2
200D.030	200DT.030	3	3	8	40	2
200D.035	200DT.035	3.5	3.5	10	40	2
200D.040	200DT.040	4	4	10	50	2
200D.045	200DT.045	4.5	4.5	10	50	2
200D.050	200DT.050	5	5	12	50	2
200D.060	200DT.060	6	6	12	50	2
200D.070	200DT.070	7	7	16	60	2
200D.080	200DT.080	8	8	20	60	2
200D.090	200DT.090	9	9	20	70	2
200D.100	200DT.100	10	10	22	70	2
200D.120	200DT.120	12	12	25	75	2
200D.140	200DT.140	14	14	30	85	2
200D.160	200DT.160	16	16	30	85	2
200D.200	200DT.200	20	20	40	100	2

→ Help 198

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

VHM - Schaftfräser - Fraise carbure à bout plat

Фреза концевая твердосплавная с прямым зубом - Sk rohová fréza

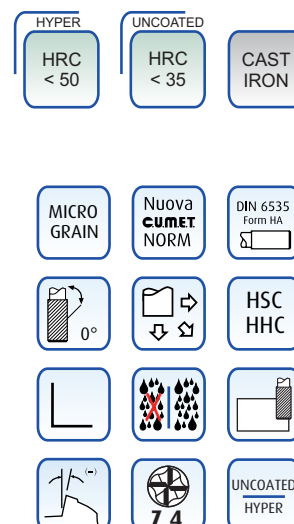


CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
400D.020	400DT.020	2	3	5	40	4
400D.030	400DT.030	3	3	12	40	4
400D.040	400DT.040	4	4	16	50	4
400D.060	400DT.060	6	6	20	50	4
400D.080	400DT.080	8	8	22	60	4
400D.100	400DT.100	10	10	25	70	4
400D.120	400DT.120	12	12	27	75	4
400D.160	400DT.160	16	16	30	85	4
400D.200	400DT.200	20	20	40	100	4

→ Help 198

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

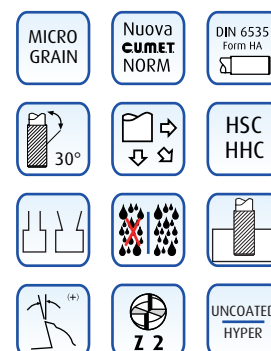
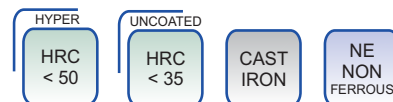
VHM - Gesenkräfer im Formenbau - Fraises a matrice en carbure à bout plat

Фреза концевая твердосплавная с плоским торцом удлиненная - Sk rohová fréza



CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	Z no.	α°
200S01075	200ST01075	1	6	1.5	15	75	2	11°
200S01575	200ST01575	1.5	6	2	15	75	2	11°
200S02075	200ST02075	2	6	3	15	75	2	9°30'
200S03075	200ST03075	3	6	6	15	75	2	9°
200S03075.1	200ST03075.1	3	6	10	20	75	2	8°30'
200S03575	200ST03575	3.5	6	10	20	75	2	6°30'
200S04075	200ST04075	4	6	10	20	75	2	6°30'
200S04075.1	200ST04075.1	4	6	15	25	75	2	6°
200S04575	200ST04575	4.5	6	10	25	75	2	2°51'
200S05075	200ST05075	5	6	12	25	75	2	2°10'
200S05075.1	200ST05075.1	5	6	18	25	75	2	4°
200S06100	200ST06100	6	6	15	-	100	2	-
200S06100.1	200ST06100.1	6	6	25	-	100	2	-
200S06150	200ST06150	6	6	20	-	150	2	-
200S06200.1	200ST06200.1	6	6	20	-	200	2	-
200S06200	200ST06200	6	8	20	80	200	2	50°
200S08100	200ST08100	8	8	20	-	100	2	-
200S08150	200ST08150	8	8	20	-	150	2	-
200S08200	200ST08200	8	8	20	-	200	2	-
200S08200.1	200ST08200.1	8	8	25	-	200	2	-
200S10100	200ST10100	10	10	25	-	100	2	-
200S10150	200ST10150	10	10	25	-	150	2	-
200S10200	200ST10200	10	10	25	-	200	2	-
200S12100	200ST12100	12	12	25	-	100	2	-
200S12150	200ST12150	12	12	25	-	150	2	-
200S12200	200ST12200	12	12	25	-	200	2	-
200S14100	200ST14100	14	14	30	-	100	2	-
200S14150	200ST14150	14	14	30	-	150	2	-
200S14200	200ST14200	14	14	30	-	200	2	-
200S16100	200ST16100	16	16	30	-	100	2	-
200S16150	200ST16150	16	16	30	-	150	2	-
200S16200	200ST16200	16	16	30	-	200	2	-
200S18200	200ST18200	18	18	30	-	200	2	-
200S20100	200ST20100	20	20	30	-	100	2	-
200S20150	200ST20150	20	20	30	-	150	2	-
200S20200	200ST20200	20	20	30	-	200	2	-

→ Help 198



*d1 ≤ ø 6 h9
d1 ≤ ø20 f7

Tutte le nostre frese standard vengono costruite con lo stesso procedimento delle frese ad alto rendimento: tolleranza del diametro di taglio h8, ottime finiture dei taglienti, controllo costante delle geometrie con sistemi ottici automatici.

All of our standard end mills are manufactured with the same process of our high performance cutters: cutting diameter tolerance h8, high flutes finishing, constant control of geometries with automatic optical systems.

Häckselgutdurchmesser h8, sehr gute Qualität von scharfen, ständige Kontrolle der Geometrie mit automatisierten optischen Systemen: Alle unsere Standard-Bohrer werden mit dem gleichen System Hochleistungsfräsen gebaut

Tous nos outils standards sont fabriqués avec le même système de coupe de nos fraises a haute performance : coupe diamètre tolérance h8, excellent finition de coupe, un suivi constant de géométries avec des systèmes optiques automatiques.

Наш стандартный инструмент производится с использованием системы высокопроизводительной резки: точность по диаметру h8, высокая точность зубьев, постоянный контроль геометрии с использованием автоматических оптических систем.

Všechny naše standardní frézy jsou vyrobeny stejným systémem našich vysoce výkonných fréz: řezný průměr v toleranci h8, vysoká kvalita úpravy zubů, stálou kontrolu nad geometrií s automatickým optickým kontrolním systémem.

Fresa testa torica in metallo duro integrale

Solid carbide corner radius end mill

VHM – Torusfräser - Fraise carbure avec rayon d'angle

Фреза концевая твердосплавная с угловым радиусом - Sk fréza s rohovým rádiusem

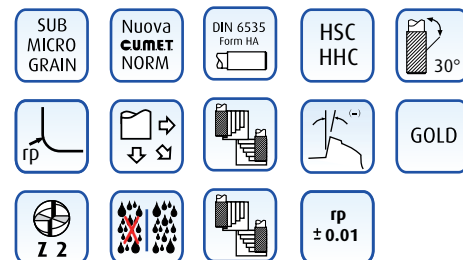


CODE	*d1 mm	d2 mm	rp mm	l1 mm	L mm	Z no.
200T03100R03	3	3	0.3	10	100	2
200T04100R05	4	4	0.5	12	100	2
200T05100R05	5	5	0.5	15	100	2
200T06100R05	6	6	0.5	20	100	2
200T06100R1	6	6	1	20	100	2
200T06150R05	6	6	0.5	30	150	2
200T06150R1	6	6	1	30	150	2
200T08100R05	8	8	0.5	40	100	2
200T08100R1	8	8	1	40	100	2
200T08150R05	8	8	0.5	50	150	2
200T08150R1	8	8	1	50	150	2
200T10100R05	10	10	0.5	45	100	2
200T10100R1	10	10	1	45	100	2
200T10150R05	10	10	0.5	60	150	2
200T10150R1	10	10	1	60	150	2
200T12100R05	12	12	0.5	45	100	2
200T12100R1	12	12	1	45	100	2
200T12150R05	12	12	0.5	65	150	2
200T12150R1	12	12	1	65	150	2



HRC
< 55

CAST
IRON



*d1 < ø 6 h9
d1 ≤ ø12 = f7

→ 198

Fresa testa sferica in metallo duro integrale

Solid carbide ball nose end mill

VHM - Radiusfräser im Formenbau - Fraises a matrice en carbure à bout hémisphérique

Фреза концевая твердосплавная полусферическая длинная для штампов - Sk kulová fréza



CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	Z no.	α°
200SR01075	200SRT01075	1	6	1.5	15	75	2	11°
200SR01575	200SRT01575	1.5	6	2	15	75	2	11
200SR02075	200SRT02075	2	6	3	15	75	2	9°30'
200SR03075	200SRT03075	3	6	6	15	75	2	9°
200SR03075.1	200SRT03075.1	3	6	10	20	75	2	8°30'
200SR04075	200SRT04075	4	6	10	20	75	2	6°30'
200SR04075.1	200SRT04075.1	4	6	15	25	75	2	6°
200SR04575	200SRT04575	4.5	6	10	25	75	2	2°51'
200SR05075	200SRT05075	5	6	12	25	75	2	2°10'
200SR05075.1	200SRT05075.1	5	6	18	25	75	2	4°
200SR06100	200SRT06100	6	6	15	-	100	2	-
200SR06100.1	200SRT06100.1	6	6	25	-	100	2	-
200SR06150	200SRT06150	6	6	20	-	150	2	-
200SR06200.1	200SRT06200.1	6	6	20	-	200	2	-
200SR06200	200SRT06200	6	8	20	80	200	2	50'
200SR08100	200SRT08100	8	8	20	-	100	2	-
200SR08150	200SRT08150	8	8	20	-	150	2	-
200SR08200	200SRT08200	8	8	20	-	200	2	-
200SR08200.1	200SRT08200.1	8	10	20	80	200	2	43'
200SR10100	200SRT10100	10	10	25	-	100	2	-
200SR10150	200SRT10150	10	10	25	-	150	2	-
200SR10200	200SRT10200	10	10	25	-	200	2	-
200SR12100	200SRT12100	12	12	25	-	100	2	-
200SR12150	200SRT12150	12	12	25	-	150	2	-
200SR12200	200SRT12200	12	12	25	-	200	2	-
200SR14100	200SRT14100	14	14	30	-	100	2	-
200SR14150	200SRT14150	14	14	30	-	150	2	-
200SR14200	200SRT14200	14	14	30	-	200	2	-
200SR14200.1	200SRT14200.1	14	16	30	80	200	2	43'
200SR16100	200SRT16100	16	16	30	-	100	2	-
200SR16150	200SRT16150	16	16	30	-	150	2	-
200SR16200	200SRT16200	16	16	30	-	200	2	-
200SR20100	200SRT20100	20	20	30	-	100	2	-
200SR20150	200SRT20150	20	20	30	-	150	2	-
200SR20200	200SRT20200	20	20	30	-	200	2	-

*d1 ≤ ø 6 h9
d1 ≤ ø20 f7

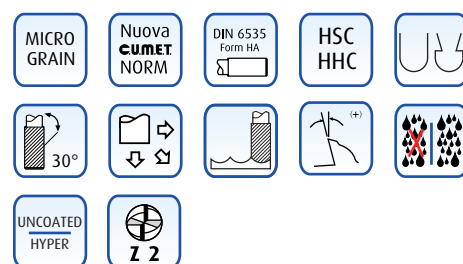
→ Help 161

HYPER
HRC
< 50

UNCOATED
HRC
< 35

CAST
IRON

NON
FERROUS

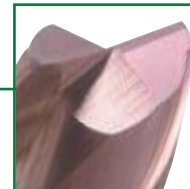


Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

VHM - Schaftfräser - Fraise carbure à bout plat

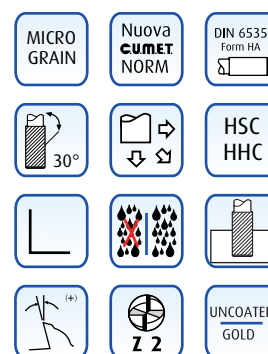
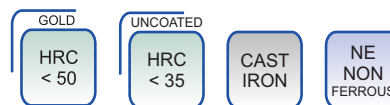
Фреза концевая твердосплавная с плоским торцом - Sk rohová fréza



CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
200.010G1	200T.010G1	1	1	5	40	2
200.010	200T.010	1	3	2.5	40	2
200.015G15	200T.015G15	1.5	1.5	5	40	2
200.015	200T.015	1.5	3	4	40	2
200.020G2	200T.020G2	2	2	8	40	2
200.020	200T.020	2	3	6	40	2
200.025G25	200T.025G25	2.5	2.5	8	40	2
200.025	200T.025	2.5	3	6	40	2
200.030	200T.030	3	3	8	40	2
20003060	200T03060	3	3	30	60	2
20003075	200T03075	3	3	30	75	2
200.035	200T.035	3.5	3.5	10	40	2
200.040	200T.040	4	4	10	50	2
20004060	200T04060	4	4	30	60	2
20004075	200T04075	4	4	30	75	2
200.045	200T.045	4.5	4.5	10	50	2
200.050	200T.050	5	5	12	50	2
20005070	200T05070	5	5	35	70	2
20005100	200T05100	5	5	40	100	2
200.055	200T.055	5.5	5.5	12	50	2
200.060	200T.060	6	6	12	50	2
20006100	200T06100	6	6	40	100	2
20006150	200T06150	6	6	50	150	2
200.070	200T.070	7	7	16	60	2
200.080	200T.080	8	8	20	60	2
20008100	200T08100	8	8	40	100	2
20008150	200T08150	8	8	50	150	2
200.090	200T.090	9	9	20	70	2
200.100	200T.100	10	10	22	70	2
20010100	200T10100	10	10	45	100	2
20010150	200T10150	10	10	60	150	2
200.110	200T.110	11	11	22	75	2
200.120	200T.120	12	12	25	75	2
20012100	200T12100	12	12	45	100	2
20012150	200T12150	12	12	75	150	2
200.130	200T.130	13	13	25	75	2
200.140	200T.140	14	14	30	85	2
20014100	200T14100	14	14	45	100	2
20014150	200T14150	14	14	65	150	2
20014150.1	200T14150.1	14	14	75	150	2
200.150	200T.150	15	15	30	85	2
20015100	200T15100	15	15	45	100	2
200.160	200T.160	16	16	30	85	2
20016100	200T16100	16	16	45	100	2
20016150	200T16150	16	16	65	150	2
20016150.1	200T16150.1	16	16	75	150	2
200.180	200T.180	18	18	38	100	2
20018150	200T18150	18	18	50	150	2
20018150.1	200T18150.1	18	18	65	150	2
20018150.2	200T18150.2	18	18	75	150	2
200.200	200T.200	20	20	40	100	2
20020150	200T20150	20	20	55	150	2
20020150.1	200T20150.1	20	20	65	150	2
20020150.2	200T20150.2	20	20	75	150	2
200.250	200T.250	25	25	40	100	2
20025150	200T25150	25	25	65	150	2
20025150.1	200T25150.1	25	25	75	150	2

→ Help 198

*d1 ≤ ø 6 h9
d1 ≤ ø25 f7

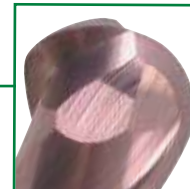


Fresa testa sferica in metallo duro integrale

Solid carbide ball nose end mill

VHM - Radiusfräser - Fraise carbure à bout hémisphérique

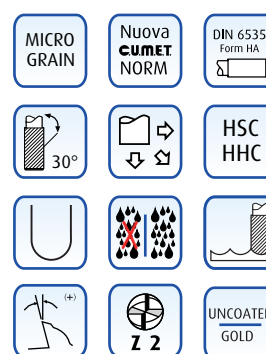
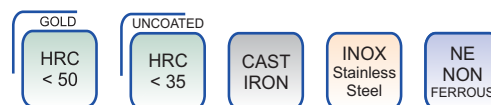
Фреза концевая твердосплавная полусферическая - Sk kulová fréza



CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
200R.010G1	200RT.010G1	1	1	5	38	2
200R.010	200RT.010	1	3	2.5	40	2
200R.015G15	200RT.015G15	1.5	1.5	5	38	2
200R.015	200RT.015	1.5	3	4	40	2
200R.020G2	200RT.020G2	2	2	8	38	2
200R.020	200RT.020	2	3	6	40	2
200R.025G25	200RT.025G25	2.5	2.5	8	38	2
200R.025	200RT.025	2.5	3	6	40	2
200R.030	200RT.030	3	3	8	40	2
200RL.030	200RLT.030	3	3	30	60	2
200RL.030.1	200RLT.030.1	3	3	30	75	2
200R.035	200RT.035	3.5	3.5	10	40	2
200R.040	200RT.040	4	4	10	50	2
200RL.040	200RLT.040	4	4	30	60	2
200RL.040.1	200RLT.040.1	4	4	30	75	2
200R.045	200RT.045	4.5	4.5	10	50	2
200R.050	200RT.050	5	5	12	50	2
200RL.050	200RLT.050	5	5	35	70	2
200RL.050.1	200RLT.050.1	5	5	40	100	2
200R.055	200RT.055	5.5	5.5	12	50	2
200R.060	200RT.060	6	6	12	50	2
200RL.060	200RLT.060	6	6	40	100	2
200RL.060.1	200RLT.060.1	6	6	50	150	2
200R.070	200RT.070	7	7	16	60	2
200R.080	200RT.080	8	8	20	60	2
200RL.080	200RLT.080	8	8	40	100	2
200RL.080.1	200RLT.080.1	8	8	50	150	2
200R.090	200RT.090	9	9	20	70	2
200R.100	200RT.100	10	10	22	70	2
200RL.100	200RLT.100	10	10	45	100	2
200RL.100.1	200RLT.100.1	10	10	60	150	2
200R.110	200RT.110	11	11	22	75	2
200R.120	200RT.120	12	12	25	75	2
200RL.120	200RLT.120	12	12	45	100	2
200RL.120.1	200RLT.120.1	12	12	75	150	2
200R.130	200RT.130	13	13	25	75	2
200R.140	200RT.140	14	14	30	85	2
200RL.140	200RLT.140	14	14	45	100	2
200RL.140.1	200RLT.140.1	14	14	65	150	2
200RL.140.2	200RLT.140.2	14	14	75	150	2
200R.150	200RT.150	15	15	30	85	2
200RL.150	200RLT.150	15	15	45	100	2
200R.160	200RT.160	16	16	30	85	2
200RL.160	200RLT.160	16	16	45	100	2
200RL.160.1	200RLT.160.1	16	16	65	150	2
200RL.160.2	200RLT.160.2	16	16	75	150	2
200R.180	200RT.180	18	18	38	100	2
200RL.180	200RLT.180	18	18	50	150	2
200RL.180.1	200RLT.180.1	18	18	65	150	2
200RL.180.2	200RLT.180.2	18	18	75	150	2
200R.200	200RT.200	20	20	40	100	2
200RL.200	200RLT.200	20	20	55	150	2
200RL.200.1	200RLT.200.1	20	20	65	150	2
200RL.200.2	200RLT.200.2	20	20	75	150	2
200R.250	200RT.250	25	25	40	100	2
200RL.250	200RLT.250	25	25	65	150	2
200RL.250.1	200RLT.250.1	25	25	75	150	2

→ Help 161-200

*d1 ≤ ø 6 h9
d1 ≤ ø25 f7



Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

VHM - Schafffräser - Fraise carbure à bout plat

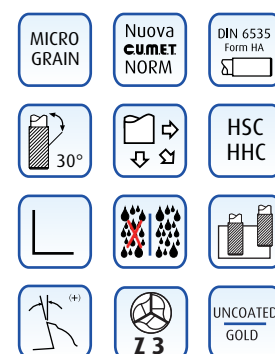
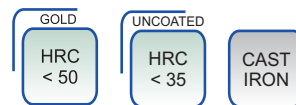
Фреза концевая твердосплавная с плоским торцом - Sk rohová fréza



CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
300.010	300T.010	1	3	2.5	40	3
300.015	300T.015	1.5	3	4	40	3
300.020	300T.020	2	3	5	40	3
300.025	300T.025	2.5	3	7	40	3
300.030	300T.030	3	3	12	40	3
30003060	300T03060	3	3	30	60	3
30003075	300T03075	3	3	30	75	3
300.035	300T.035	3.5	3.5	12	40	3
300.040	300T.040	4	4	16	50	3
30004060	300T04060	4	4	30	60	3
30004075	300T04075	4	4	30	75	3
300.045	300T.045	4.5	4.5	16	50	3
300.050	300T.050	5	5	20	50	3
30005070	300T05070	5	5	35	70	3
30005100	300T05100	5	5	40	100	3
300.055	300T.055	5.5	5.5	20	50	3
300.060	300T.060	6	6	20	50	3
30006100	300T06100	6	6	40	100	3
30006150	300T06150	6	6	50	150	3
300.070	300T.070	7	7	22	60	3
300.080	300T.080	8	8	22	60	3
30008100	300T08100	8	8	40	100	3
30008150	300T08150	8	8	50	150	3
300.090	300T.090	9	9	22	70	3
300.100	300T.100	10	10	25	70	3
30010100	300T10100	10	10	45	100	3
30010150	300T10150	10	10	60	150	3
300.110	300T.110	11	11	27	75	3
300.120	300T.120	12	12	27	75	3
30012100	300T12100	12	12	45	100	3
30012150	300T12150	12	12	75	150	3
300.130	300T.130	13	13	27	75	3
300.140	300T.140	14	14	30	85	3
30014100	300T14100	14	14	45	100	3
30014150	300T14150	14	14	65	150	3
30014150.1	300T14150.1	14	14	75	150	3
300.150	300T.150	15	15	30	85	3
30015100	300T15100	15	15	45	100	3
300.160	300T.160	16	16	30	85	3
30016100	300T16100	16	16	45	100	3
30016150	300T16150	16	16	65	150	3
30016150.1	300T16150.1	16	16	75	150	3
300.180	300T.180	18	18	40	100	3
30018150	300T18150	18	18	50	150	3
30018150.1	300T18150.1	18	18	65	150	3
30018150.2	300T18150.2	18	18	75	150	3
300.200	300T.200	20	20	40	100	3
30020150	300T20150	20	20	55	150	3
30020150.1	300T20150.1	20	20	65	150	3
30020150.2	300T20150.2	20	20	75	150	3
300.220	300T.220	22	22	40	100	3
300.250	300T.250	25	25	40	100	3
30025150	300T25150	25	25	65	150	3
30025150.1	300T25150.1	25	25	75	150	3

→ Help 195-196-198

*d1 ≤ ø 6 h9
d1 ≤ ø25 f7



Fresa testa sferica in metallo duro integrale

Solid carbide ball nose end mill

VHM - Radiusfräser - Fraise carbure à bout hémisphérique

Фреза концевая твердосплавная полусферическая - Sk kulová fréza

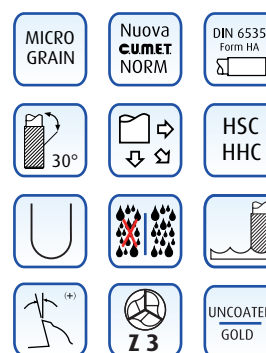
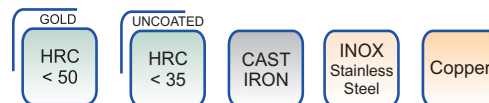


CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
300R.010	300RT.010	1	3	2.5	40	3
300R.015	300RT.015	1.5	3	4	40	3
300R.020	300RT.020	2	3	5	40	3
300R.025	300RT.025	2.5	3	7	40	3
300R.030	300RT.030	3	3	12	40	3
300RL.030	300RLT.030	3	3	30	60	3
300RL.030.1	300RLT.030.1	3	3	30	75	3
300R.035	300RT.035	3.5	3.5	12	40	3
300R.040	300RT.040	4	4	16	50	3
300RL.040	300RLT.040	4	4	30	60	3
300RL.040.1	300RLT.040.1	4	4	30	75	3
300R.045	300RT.045	4.5	4.5	16	50	3
300R.050	300RT.050	5	5	20	50	3
300RL.050	300RLT.050	5	5	35	70	3
300RL.050.1	300RLT.050.1	5	5	40	100	3
300R.055	300RT.055	5.5	5.5	20	50	3
300R.060	300RT.060	6	6	20	50	3
300RL.060	300RLT.060	6	6	40	100	3
300RL.060.1	300RLT.060.1	6	6	50	150	3
300R.070	300RT.070	7	7	22	60	3
300R.080	300RT.080	8	8	22	60	3
300RL.080	300RLT.080	8	8	40	100	3
300RL.080.1	300RLT.080.1	8	8	50	150	3
300R.090	300RT.090	9	9	22	70	3
300R.100	300RT.100	10	10	25	70	3
300RL.100	300RLT.100	10	10	45	100	3
300RL.100.1	300RLT.100.1	10	10	60	150	3
300R.110	300RT.110	11	11	27	75	3
300R.120	300RT.120	12	12	27	75	3
300RL.120	300RLT.120	12	12	45	100	3
300RL.120.1	300RLT.120.1	12	12	75	150	3
300R.130	300RT.130	13	13	27	75	3
300R.140	300RT.140	14	14	30	85	3
300RL.140	300RLT.140	14	14	45	100	3
300RL.140.1	300RLT.140.1	14	14	65	150	3
300RL.140.2	300RLT.140.2	14	14	75	150	3
300R.150	300RT.150	15	15	30	85	3
300RL.150	300RLT.150	15	15	45	100	3
300R.160	300RT.160	16	16	30	85	3
300RL.160	300RLT.160	16	16	45	100	3
300RL.160.1	300RLT.160.1	16	16	65	150	3
300RL.160.2	300RLT.160.2	16	16	75	150	3
300R.180	300RT.180	18	18	40	100	3
300RL.180	300RLT.180	18	18	50	150	3
300RL.180.1	300RLT.180.1	18	18	65	150	3
300RL.180.2	300RLT.180.2	18	18	75	150	3
300R.200	300RT.200	20	20	40	100	3
300RL.200	300RLT.200	20	20	55	150	3
300RL.200.1	300RLT.200.1	20	20	65	150	3
300RL.200.2	300RLT.200.2	20	20	75	150	3
300R.250	300RT.250	25	25	40	100	3
300RL.250	300RLT.250	25	25	55	150	3
300RL.250.1	300RLT.250.1	25	25	75	150	3

→ Help 161-200

*d1 ≤ ø 6 h9

d1 ≤ ø25 f7

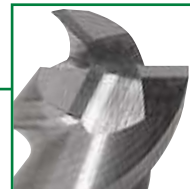


Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

VHM - Schafffräser - Fraise carbure à bout plat

Фреза концевая твердосплавная с плоским торцом - Sk rohová fréza

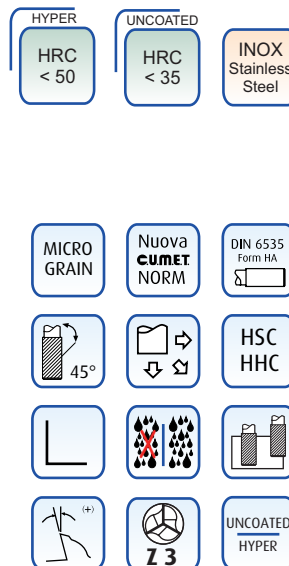


CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
450.030	450T.030	3	3	10	40	3
45003060	450T03060	3	3	30	60	3
450.035	450T.035	3.5	3.5	10	40	3
450.040	450T.040	4	4	12	50	3
45004060	450T04060	4	4	30	60	3
450.045	450T.045	4.5	4.5	12	50	3
450.050	450T.050	5	5	12	50	3
45005070	450T05070	5	5	35	70	3
450.060	450T.060	6	6	16	50	3
45006100	450T06100	6	6	40	100	3
450.070	450T.070	7	7	16	60	3
450.080	450T.080	8	8	20	60	3
45008100	450T08100	8	8	40	100	3
450.090	450T.090	9	9	20	70	3
450.100	450T.100	10	10	22	70	3
45010100	450T10100	10	10	45	100	3
450.110	450T.110	11	11	22	70	3
45011100	450T11100	11	11	45	100	3
450.120	450T.120	12	12	27	75	3
45012100	450T12100	12	12	45	100	3
450.140	450T.140	14	14	27	85	3
45014100	450T14100	14	14	45	100	3
450.150	450T.150	15	15	30	85	3
450.160	450T.160	16	16	32	85	3
45016100	450T16100	16	16	45	100	3
45016150	450T16150	16	16	65	150	3
450.180	450T.180	18	18	38	100	3
450.200	450T.200	20	20	38	100	3
45020150	450T20150	20	20	65	150	3
45020150.1	450T20150.1	20	20	75	150	3

→ Help 195-196

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7

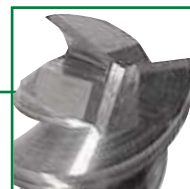


Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

VHM - Schafffräser - Fraise carbure à bout plat

Фреза концевая твердосплавная с плоским торцом - Sk rohová fréza

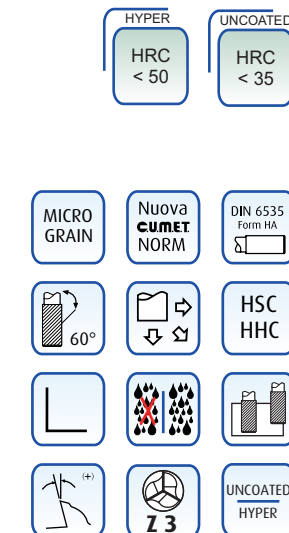


CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
500.030	500T.030	3	3	10	40	3
500.040	500T.040	4	4	12	50	3
50004060	500T04060	4	4	30	60	3
500.050	500T.050	5	5	12	50	3
500.060	500T.060	6	6	16	50	3
50006100	500T06100	6	6	40	100	3
500.080	500T.080	8	8	20	60	3
50008100	500T08100	8	8	40	100	3
500.100	500T.100	10	10	22	70	3
50010100	500T10100	10	10	45	100	3
500.120	500T.120	12	12	27	75	3
50012100	500T12100	12	12	45	100	3
500.150	500T.150	15	15	30	85	3
500.160	500T.160	16	16	30	85	3
50016100	500T16100	16	16	45	100	3
50016150	500T16150	16	16	65	150	3
500.180	500T.180	18	18	38	100	3
500.200	500T.200	20	20	38	100	3

→ Help 195-196

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



Fresa testa piana in metallo duro integrale

Solid carbide flat nose end mill

VHM - Schaftfräser - Fraise carbure à bout plat

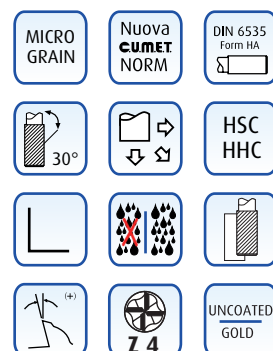
Фреза концевая твердосплавная с плоским торцом - Sk rohová fréza



CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
400.010G1	400T.010G1	1	1	5	38	4
400.010	400T.010	1	3	2.5	40	4
400.015G15	400T.015G15	1.5	1.5	5	38	4
400.015	400T.015	1.5	3	4	40	4
400.020G2	400T.020G2	2	2	8	38	4
400.020	400T.020	2	3	5	40	4
400.025G25	400T.025G25	2.5	2.5	8	38	4
400.025	400T.025	2.5	3	7	40	4
400.030	400T.030	3	3	12	40	4
40003060	400T03060	3	3	30	60	4
40003075	400T03075	3	3	30	75	4
400.035	400T.035	3.5	3.5	12	40	4
400.040	400T.040	4	4	16	50	4
40004060	400T04060	4	4	30	60	4
40004075	400T04075	4	4	30	75	4
400.045	400T.045	4.5	4.5	16	50	4
400.050	400T.050	5	5	20	50	4
40005070	400T05070	5	5	35	70	4
40005100	400T05100	5	5	40	100	4
400.055	400T.055	5.5	5.5	20	50	4
400.060	400T.060	6	6	20	50	4
40006100	400T06100	6	6	40	100	4
40006150	400T06150	6	6	50	150	4
400.070	400T.070	7	7	22	60	4
400.080	400T.080	8	8	22	60	4
40008100	400T08100	8	8	40	100	4
40008150	400T08150	8	8	50	150	4
400.090	400T.090	9	9	22	70	4
400.100	400T.100	10	10	25	70	4
40010100	400T10100	10	10	45	100	4
40010150	400T10150	10	10	60	150	4
400.110	400T.110	11	11	27	75	4
400.120	400T.120	12	12	27	75	4
40012100	400T12100	12	12	45	100	4
40012150	400T12150	12	12	75	150	4
400.130	400T.130	13	13	27	75	4
400.140	400T.140	14	14	30	85	4
40014100	400T14100	14	14	45	100	4
40014150	400T14150	14	14	65	150	4
40014150.1	400T14150.1	14	14	75	150	4
400.150	400T.150	15	15	30	85	4
40015100	400T15100	15	15	45	100	4
400.160	400T.160	16	16	30	85	4
40016100	400T16100	16	16	45	100	4
40016150	400T16150	16	16	65	150	4
40016150.1	400T16150.1	16	16	75	150	4
400.180	400T.180	18	18	40	100	4
40018150	400T18150	18	18	50	150	4
40018150.1	400T18150.1	18	18	65	150	4
40018150.2	400T18150.2	18	18	75	150	4
400.200	400T.200	20	20	40	100	4
40020150	400T20150	20	20	55	150	4
40020150.1	400T20150.1	20	20	65	150	4
40020150.2	400T20150.2	20	20	75	150	4
400.220	400T.220	22	22	40	100	4
400.250	400T.250	25	25	40	100	4
40025150	400T25150	25	25	55	150	4
40025150.1	400T25150.1	25	25	75	150	4

→ Help 197-198

*d1 ≤ ø 6 h9
d1 ≤ ø32 f7



Fresa testa torica in metallo duro integrale

Solid carbide corner radius end mill

VHM - Schaftfräser - Fraise carbure avec rayond'angle

Фреза концевая твердосплавная с угловым радиусом для тяжелого фрезерования

Sk fréza s rohovým rádiusem pro těžký řez

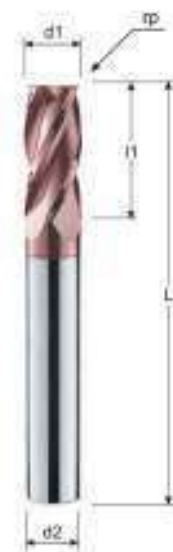


CODE	d1 mm	d2 mm	rp mm	l1 mm	L mm
400T03100R03	3	3	0.3	12	100
400T04100R05	4	4	0.5	16	100
400T05100R05	5	5	0.5	20	100
400T06100R05	6	6	0.5	20	100
400T06100R1	6	6	1	20	100
400T06150R05	6	6	0.5	30	150
400T06150R1	6	6	1	30	150
400T08100R05	8	8	0.5	40	100
400T08100R1	8	8	1	40	100
400T08150R05	8	8	0.5	50	150
400T08150R1	8	8	1	50	150
400T10100R05	10	10	0.5	45	100
400T10100R1	10	10	1	45	100
400T10150R05	10	10	0.5	60	150
400T10150R1	10	10	1	60	150
400T12100R05	12	12	0.5	45	100
400T12100R1	12	12	1	45	100
400T15150R05	12	12	0.5	65	150
400T15150R1	12	12	1	65	150

→ 197

*d1 ≤ ø 6 h9

d1 ≤ ø20 f7



HRC
< 55

CAST
IRON

SUB
MICRO
GRAIN

Nuova
CUMET
NORM

DIN 6535
Form HA

30°

HSC
HHC

rp

Z 4

GOLD

rp
± 0.01

Z 4

GOLD

Fresa testa sferica in metallo duro integrale

Solid carbide ball nose end mill

VHM - Radiusfräser - Fraise carbure à bout hémisphérique

Фреза концевая твердосплавная полусферическая - Sk kulová fréza

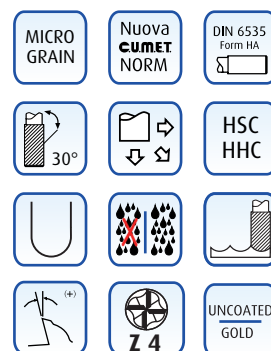
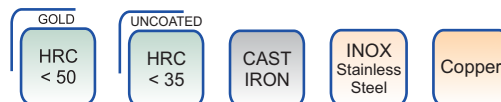


CODE UNCOATED	CODE HYPER	*d1 mm	d2h6 mm	l1 mm	L mm	Z no.
400R.010G1	400RT.010G1	1	1	5	38	4
400R.010	400RT.010	1	3	2.5	40	4
400R.015G15	400RT.015G15	1.5	1.5	5	38	4
400R.015	400RT.015	1.5	3	4	40	4
400R.020G2	400RT.020G2	2	2	8	38	4
400R.020	400RT.020	2	3	5	40	4
400R.025G25	400RT.025G25	2.5	2.5	8	38	4
400R.025	400RT.025	2.5	3	7	40	4
400R.030	400RT.030	3	3	12	40	4
400RL.030	400RLT.030	3	3	30	60	4
400RL.030.1	400RLT.030.1	3	3	30	75	4
400R.040	400RT.040	4	4	16	50	4
400RL.040	400RLT.040	4	4	30	60	4
400RL.040.1	400RLT.040.1	4	4	30	75	4
400R.045	400RT.045	4.5	4.5	16	50	4
400R.050	400RT.050	5	5	20	50	4
400RL.050	400RLT.050	5	5	35	70	4
400RL.050.1	400RLT.050.1	5	5	40	100	4
400R.055	400RT.055	5.5	5.5	20	50	4
400R.060	400RT.060	6	6	20	50	4
400RL.060	400RLT.060	6	6	40	100	4
400RL.060.1	400RLT.060.1	6	6	50	150	4
400R.070	400RT.070	7	7	22	60	4
400R.080	400RT.080	8	8	22	60	4
400RL.080	400RLT.080	8	8	40	100	4
400RL.080.1	400RLT.080.1	8	8	50	150	4
400R.090	400RT.090	9	9	22	70	4
400RL.100	400RLT.100	10	10	25	70	4
400RL.100.1	400RLT.100.1	10	10	45	100	4
400R.110	400RT.110	11	11	27	75	4
400R.120	400RT.120	12	12	27	75	4
400RL.120	400RLT.120	12	12	45	100	4
400RL.120.1	400RLT.120.1	12	12	75	150	4
400R.130	400RT.130	13	13	27	75	4
400R.140	400RT.140	14	14	30	85	4
400RL.140	400RLT.140	14	14	45	100	4
400RL.140.1	400RLT.140.1	14	14	65	150	4
400RL.140.2	400RLT.140.2	14	14	75	150	4
400R.150	400RT.150	15	15	30	85	4
400RL.150	400RLT.150	15	15	45	100	4
400R.160	400RT.160	16	16	30	85	4
400RL.160	400RLT.160	16	16	45	100	4
400RL.160.1	400RLT.160.1	16	16	65	150	4
400RL.160.2	400RLT.160.2	16	16	75	150	4
400R.180	400RT.180	18	18	40	100	4
400RL.180	400RLT.180	18	18	50	150	4
400RL.180.1	400RLT.180.1	18	18	65	150	4
400RL.180.2	400RLT.180.2	18	18	75	150	4
400R.200	400RT.200	20	20	40	100	4
400RL.200	400RLT.200	20	20	55	150	4
400RL.200.1	400RLT.200.1	20	20	65	150	4
400RL.200.2	400RLT.200.2	20	20	75	150	4
400R.250	400RT.250	25	25	40	100	4
400RL.250	400RLT.250	25	25	55	150	4
400RL.250.1	400RLT.250.1	25	25	75	150	4

→ Help 161-200

*d1 ≤ ø 6 h9

d1 ≤ ø25 f7



Fresa conica testa piana in metallo duro integrale

Solid carbide flat nose die tapered end mill

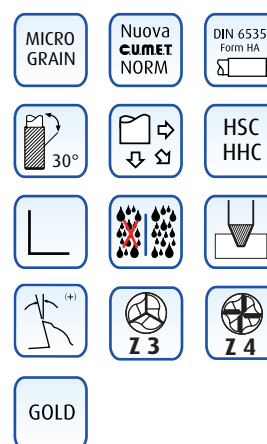
VHM - Schaftfräser Konisch - Fraise carbure conique à bout plat

Фреза концевая твердосплавная коническая - Sk rohová fréza se zuženou stopkou



CODE	d1h8 mm	d2h6 mm	l1 mm	L mm	Z no.	α°
300C.025.05	2.5	4	20	60	3	1/2°
300C.030.05	3	4	20	60	3	
300C.040.05	4	5	20	60	3	
300C.060.05	6	8	30	75	4	
300C.080.05	8	10	30	70	4	
300C.100.05	10	12	30	75	4	
300C.120.05	12	14	30	85	4	
300C.120.05.1	12	14	50	100	4	1°
300C.025.1	2.5	4	20	60	3	
300C.030.1	3	4	20	60	3	
300C.040.1	4	5	20	60	3	
300C.050.1	5	6	30	75	3	
300C.060.1	6	8	30	75	3	
300C.060.1L	6	8	57	120	3	
300C.080.1	8	10	30	70	4	1-1/2°
300C.080.1L	8	10	57	120	4	
300C.100.1	10	12	30	75	4	
300C.120.1	12	14	50	100	4	
300C.025.15	2.5	4	20	60	3	
300C.030.15	3	4	20	60	3	
300C.040.15	4	5	20	60	3	2°
300C.050.15	5	8	30	75	3	
300C.060.15	6	8	30	75	3	
300C.080.15	8	10	30	70	4	
300C.100.15	10	12	30	75	4	
300C.120.15	12	16	50	100	4	
300C.025.2	2.5	4	20	60	3	3°
300C.060.2	6	10	57	120	3	
300C.060.2L	6	12	85	150	3	
300C.070.2	7	10	40	100	3	
300C.080.2	8	10	28	100	3	
300C.080.2L	8	12	57	150	4	
300C.080.2L1	8	14	85	200	4	5°
300C.100.2	10	14	57	200	4	
300C.025.3	2.5	6	20	60	3	
300C.030.3	3	6	25	60	3	
300C.030.3L	3	8	40	75	3	
300C.040.3	4	8	30	75	3	
300C.060.3	6	10	30	70	3	5°
300C.060.3L	6	12	50	100	3	
300C.060.3L1	6	12	57	150	4	
300C.080.3	8	12	30	75	4	
300C.100.3L	10	16	50	100	4	
300C.025.5	2.5	6	20	60	3	
300C.030.5	3	10	30	70	3	5°
300C.030.5L	3	10	40	100	3	
300C.035.5	3.5	12	50	100	3	
300C.040.5	4	8	22	60	3	
300C.040.5L	4	10	30	70	3	
300C.050.5	5	12	40	100	3	
300C.060.5	6	12	30	75	3	5°
300C.060.5L	6	16	50	100	3	
300C.060.5L1	6	16	57	200	4	
300C.080.5	8	18	50	100	4	
300C.100.5	10	16	30	100	4	
300C.100.5L	10	20	50	100	4	
300C.120.5	12	18	30	100	4	

→ Help 197-198



Fresa conica testa sferica in metallo duro integrale

Solid carbide ball nose die tapered end mill

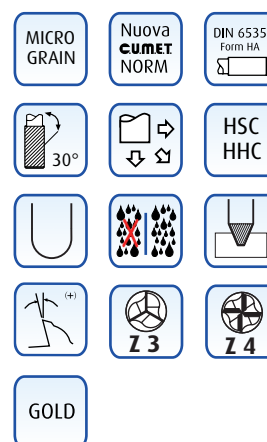
VHM - Radiusfräser Konisch - Fraise carbure conique à bout hémisphérique

Фреза концевая твердосплавная полусферическая коническая - Sk kulová fréza se zuženou stopkou



CODE	d1h8 mm	d2h6 mm	l1 mm	L mm	Z no.	α°
300CR.030.05	3	4	20	60	3	1/2°
300CR.040.05	4	5	20	60	3	
300CR.050.05	5	6	30	75	3	
300CR.060.05	6	8	30	75	4	
300CR.080.05	8	10	30	70	4	
300CR.100.05	10	12	30	75	4	
300CR.120.05.1	12	14	50	100	4	1°
300CR.030.1	3	4	20	60	3	
300CR.040.1	4	5	20	60	3	
300CR.050.1	5	6	30	75	3	
300CR.060.1	6	8	30	75	3	
300CR.060.1L	6	8	57	120	3	
300CR.080.1	8	10	30	70	4	
300CR.080.1L	8	10	57	120	4	
300CR.100.1	10	12	30	75	4	1-1/2°
300CR.120.1	12	14	50	100	4	
300CR.160.1	16	18	55	100	4	
300CR.025.15	2.5	4	20	60	3	
300CR.030.15	3	4	20	60	3	
300CR.040.15	4	5	20	60	3	
300CR.050.15	5	8	30	75	3	2°
300CR.060.15	6	8	30	75	3	
300CR.080.15	8	10	30	70	4	
300CR.100.15	10	12	30	75	4	
300CR.120.15	12	16	50	100	4	
300CR.060.2	6	10	57	120	3	3°
300CR.060.2L	6	12	85	150	3	
300CR.070.2	7	10	40	100	3	
300CR.080.2	8	10	28	100	4	
300CR.080.2L	8	12	57	150	4	
300CR.080.2L1	8	14	85	200	4	
300CR.100.2	10	14	57	200	4	5°
300CR.025.3	2.5	6	20	65	3	
300CR.030.3	3	6	25	65	3	
300CR.030.3L	3	8	40	75	3	
300CR.040.3	4	8	30	75	3	
300CR.050.3	5	10	40	70	3	
300CR.060.3	6	10	30	70	3	
300CR.060.3L	6	12	50	100	3	
300CR.060.3L1	6	12	57	150	4	
300CR.080.3	8	12	30	75	4	
300CR.080.3L	8	14	50	100	4	
300CR.080.3L1	8	14	57	200	4	
300CR.100.3	10	14	30	85	4	
300CR.100.3L	10	16	50	100	4	
300CR.100.3L1	10	16	57	200	4	
300CR.120.3	12	18	50	100	4	
300CR.025.5	2.5	6	20	60	3	5°
300CR.030.5	3	10	30	70	3	
300CR.030.5L	3	10	40	100	3	
300CR.035.5	3.5	12	50	100	3	
300CR.040.5	4	8	22	60	3	
300CR.040.5L	4	10	30	70	3	
300CR.050.5	5	12	40	100	3	
300CR.060.5	6	12	30	75	3	
300CR.080.5	8	18	50	100	4	
300CR.100.5	10	16	30	100	4	
300CR.100.5L	10	20	50	100	4	
300CR.120.5	12	20	40	100	4	

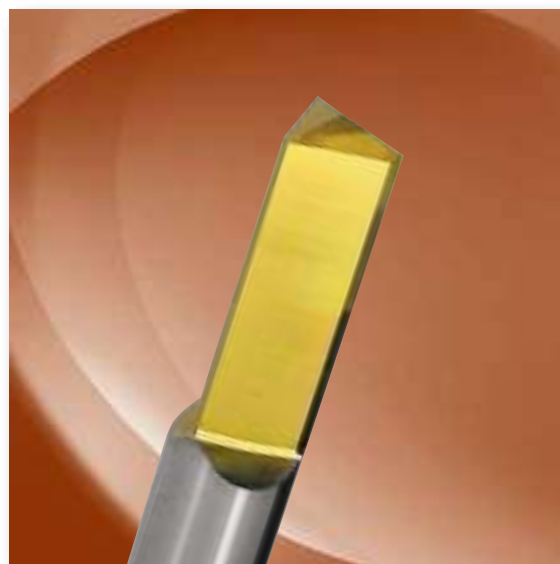
→ Help 161-200



Punte alto rendimento

High performance drills

Hochleistungsböhrer
Forets à haut performance
Сверла высокопроизводительные
Vysocce výkonné vrtáky



Punta ad alte prestazioni in metallo duro integrale

Solid carbide high performance twist drill

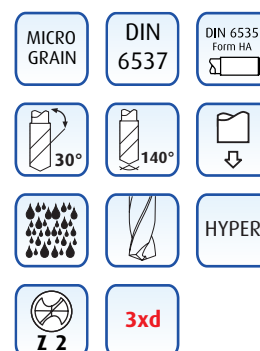
VHM - Hochleistungsböhrer - Foret carbure à haut performance

Сверло спиральное твердосплавное высокопроизводительное - Sk vysoce výkonný vrták



CODE	d1h7 mm	d2h6 mm	l1 mm	L mm
122T.030	3.0	6	20	60
122T.031	3.1			
122T.032	3.2			
122T.033	3.3			
122T.034	3.4			
122T.035	3.5			
122T.036	3.6			
122T.037	3.7	6	24	66
122T.038	3.8			
122T.039	3.9			
122T.040	4.0			
122T.041	4.1			
122T.042	4.2			
122T.043	4.3			
122T.044	4.4	6	28	66
122T.045	4.5			
122T.046	4.6			
122T.047	4.7			
122T.048	4.8			
122T.049	4.9			
122T.050	5.0	8	34	79
122T.051	5.1			
122T.052	5.2			
122T.053	5.3			
122T.054	5.4			
122T.055	5.5			
122T.056	5.6	8	41	79
122T.057	5.7			
122T.058	5.8			
122T.059	5.9			
122T.060	6.0			
122T.061	6.1			
122T.062	6.2	10	45	89
122T.063	6.3			
122T.064	6.4			
122T.065	6.5			
122T.066	6.6			
122T.067	6.7			
122T.068	6.8	10	45	89
122T.069	6.9			
122T.070	7.0			
122T.071	7.1			
122T.072	7.2			
122T.073	7.3			
122T.074	7.4	10	45	89
122T.075	7.5			
122T.076	7.6			
122T.077	7.7			
122T.078	7.8			
122T.079	7.9			
122T.080	8.0	10	45	89
122T.081	8.1			
122T.082	8.2			
122T.083	8.3			
122T.084	8.4			
122T.085	8.5			

CODE	d1h7 mm	d2h6 mm	l1 mm	L mm
122T.086	8.6	10	45	89
122T.087	8.7			
122T.088	8.8			
122T.089	8.9			
122T.090	9.0			
122T.091	9.1			
122T.092	9.2			
122T.093	9.3	12	55	102
122T.094	9.4			
122T.095	9.5			
122T.096	9.6			
122T.097	9.7			
122T.098	9.8			
122T.099	9.9			
122T.100	10.0	14	60	107
122T.101	10.1			
122T.102	10.2			
122T.103	10.3			
122T.104	10.4			
122T.105	10.5			
122T.106	10.6			
122T.107	10.7	16	65	115
122T.108	10.8			
122T.109	10.9			
122T.110	11.0			
122T.111	11.1			
122T.112	11.2			
122T.113	11.3	18	73	123
122T.114	11.4			
122T.115	11.5			
122T.116	11.6			
122T.117	11.7			
122T.118	11.8			
122T.119	11.9	20	79	131
122T.120	12.0			
122T.122	12.2			
122T.123	12.3			
122T.125	12.5			
122T.128	12.8			
122T.130	13.0	20	79	131
122T.135	13.5			
122T.138	13.8			
122T.140	14.0			
122T.145	14.5			
122T.150	15.0			
122T.155	15.5	20	79	131
122T.160	16.0			
122T.165	16.5			
122T.170	17.0			
122T.175	17.5			
122T.180	18.0			
122T.185	18.5	20	79	131
122T.190	19.0			
122T.195	19.5			
122T.200	20.0			



→ Help 203

Punta ad alte prestazioni in metallo duro integrale

Solid carbide high performance twist drill

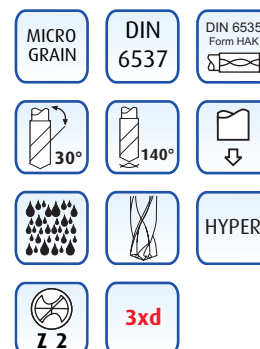
VHM - Hochleistungsbohrer - Foret carbure helicoidal avec canaux de réfrigération

Сверло спиральное твердосплавное с подачей СОЖ - Sk vysoce výkonný vrták



CODE	d1h7 mm	d2h6 mm	l1 mm	L mm
122F.030	3.0	6	20	60
122F.031	3.1			
122F.032	3.2			
122F.033	3.3			
122F.034	3.4			
122F.035	3.5			
122F.036	3.6			
122F.037	3.7	6	24	66
122F.038	3.8			
122F.039	3.9			
122F.040	4.0			
122F.041	4.1			
122F.042	4.2			
122F.043	4.3			
122F.044	4.4			
122F.045	4.5			
122F.046	4.6			
122F.047	4.7			
122F.048	4.8	6	28	66
122F.049	4.9			
122F.050	5.0			
122F.051	5.1			
122F.052	5.2			
122F.053	5.3			
122F.054	5.4			
122F.055	5.5			
122F.056	5.6			
122F.057	5.7			
122F.058	5.8			
122F.059	5.9	8	34	75
122F.060	6.0			
122F.061	6.1			
122F.062	6.2			
122F.063	6.3			
122F.064	6.4			
122F.065	6.5			
122F.066	6.6			
122F.067	6.7			
122F.068	6.8			
122F.069	6.9			
122F.070	7.0	8	41	79
122F.071	7.1			
122F.072	7.2			
122F.073	7.3			
122F.074	7.4			
122F.075	7.5			
122F.076	7.6			
122F.077	7.7			
122F.078	7.8			
122F.079	7.9			
122F.080	8.0			

CODE	d1h7 mm	d2h6 mm	l1 mm	L mm
122F.081	8.1	10	45	89
122F.082	8.2			
122F.083	8.3			
122F.084	8.4			
122F.085	8.5			
122F.086	8.6			
122F.087	8.7			
122F.088	8.8			
122F.089	8.9			
122F.090	9.0			
122F.091	9.1			
122F.092	9.2			
122F.093	9.3	12	55	102
122F.094	9.4			
122F.095	9.5			
122F.096	9.6			
122F.097	9.7			
122F.098	9.8			
122F.100	10.0			
122F.101	10.1			
122F.102	10.2			
122F.103	10.3			
122F.104	10.4	14	60	107
122F.105	10.5			
122F.106	10.6			
122F.107	10.7			
122F.108	10.8			
122F.109	10.9			
122F.110	11.0			
122F.111	11.1			
122F.112	11.2			
122F.113	11.3			
122F.114	11.4	16	65	115
122F.115	11.5			
122F.116	11.6			
122F.117	11.7			
122F.118	11.8			
122F.120	12.0			
122F.122	12.2			
122F.123	12.3			
122F.125	12.5			
122F.128	12.8	18	73	123
122F.130	13.0			
122F.135	13.5			
122F.138	13.8			
122F.140	14.0			
122F.145	14.5			
122F.150	15.0			
122F.155	15.5			
122F.160	16.0			
122F.165	16.5	20	79	131
122F.170	17.0			
122F.175	17.5			
122F.180	18.0			
122F.185	18.5			
122F.190	19.0			
122F.195	19.5			
122F.200	20.0			



→ Help 204

Punta ad alte prestazioni in metallo duro integrale

Solid carbide high performance twist drill

VHM - Hochleistungsböhrer - Foret carbure à haut performance

Сверло спиральное твердосплавное высокопроизводительное - Sk vysoce výkonný vrták



CODE	d1h7 mm	d2h6 mm	l1 mm	L mm
122TL.005	0.5	3	10	50
122TL.006	0.6			
122TL.007	0.7			
122TL.008	0.8			
122TL.009	0.9			
122TL.010	1.0	3	12	55
122TL.011	1.1			
122TL.012	1.2			
122TL.013	1.3			
122TL.014	1.4			
122TL.015	1.5	3	16	55
122TL.016	1.6			
122TL.017	1.7			
122TL.018	1.8			
122TL.019	1.9			
122TL.020	2.0	3	21	57
122TL.021	2.1			
122TL.022	2.2			
122TL.023	2.3			
122TL.024	2.4			
122TL.025	2.5	6	28	66
122TL.026	2.6			
122TL.027	2.7			
122TL.028	2.8			
122TL.029	2.9			
122TL.030	3.0	6	36	74
122TL.031	3.1			
122TL.032	3.2			
122TL.033	3.3			
122TL.034	3.4			
122TL.035	3.5	6	44	82
122TL.036	3.6			
122TL.037	3.7			
122TL.038	3.8			
122TL.039	3.9			
122TL.040	4.0	8	53	91
122TL.041	4.1			
122TL.042	4.2			
122TL.043	4.3			
122TL.044	4.4			
122TL.045	4.5	8	53	91
122TL.046	4.6			
122TL.047	4.7			
122TL.048	4.8			
122TL.049	4.9			
122TL.050	5.0	10	61	103
122TL.051	5.1			
122TL.052	5.2			
122TL.053	5.3			
122TL.054	5.4			
122TL.055	5.5	12	71	111
122TL.056	5.6			
122TL.057	5.7			
122TL.058	5.8			
122TL.059	5.9			
122TL.060	6.0	14	77	124
122TL.061	6.1			
122TL.062	6.2			
122TL.063	6.3			
122TL.064	6.4			
122TL.065	6.5	16	83	133
122TL.066	6.6			
122TL.067	6.7			
122TL.068	6.8			
122TL.069	6.9			
122TL.070	7.0	18	93	143
122TL.071	7.1			
122TL.072	7.2			
122TL.073	7.3			
122TL.074	7.4			
122TL.075	7.5	20	101	153
122TL.076	7.6			
122TL.077	7.7			
122TL.078	7.8			
122TL.079	7.9			
122TL.080	8.0	20	101	153
122TL.081	8.1			
122TL.082	8.2			
122TL.083	8.3			
122TL.084	8.4			
122TL.085	8.5	20	101	153
122TL.086	8.6			
122TL.087	8.7			
122TL.088	8.8			
122TL.089	8.9			
122TL.090	9.0	20	101	153
122TL.091	9.1			
122TL.092	9.2			
122TL.093	9.3			
122TL.094	9.4			
122TL.095	9.5	20	101	153
122TL.096	9.6			
122TL.097	9.7			
122TL.098	9.8			
122TL.099	9.9			
122TL.100	10.0	20	101	153
122TL.101	10.1			
122TL.102	10.2			
122TL.103	10.3			
122TL.104	10.4			
122TL.105	10.5	20	101	153
122TL.106	10.6			
122TL.107	10.7			
122TL.108	10.8			
122TL.109	10.9			
122TL.110	11.0	20	101	153
122TL.111	11.1			
122TL.112	11.2			
122TL.113	11.3			
122TL.114	11.4			
122TL.115	11.5	20	101	153
122TL.116	11.6			
122TL.117	11.7			
122TL.118	11.8			
122TL.119	11.9			
122TL.120	12.0	20	101	153
122TL.121	12.1			
122TL.122	12.2			
122TL.123	12.3			
122TL.124	12.4			
122TL.125	12.5	20	101	153
122TL.126	12.6			
122TL.127	12.7			
122TL.128	12.8			
122TL.129	12.9			
122TL.130	13.0	20	101	153
122TL.131	13.1			
122TL.132	13.2			
122TL.133	13.3			
122TL.134	13.4			
122TL.135	13.5	20	101	153
122TL.136	13.6			
122TL.137	13.7			
122TL.138	13.8			
122TL.139	13.9			
122TL.140	14.0	20	101	153
122TL.141	14.1			
122TL.142	14.2			
122TL.143	14.3			
122TL.144	14.4			
122TL.145	14.5	20	101	153
122TL.146	14.6			
122TL.147	14.7			
122TL.148	14.8			
122TL.149	14.9			
122TL.150	15.0	20	101	153
122TL.151	15.1			
122TL.152	15.2			
122TL.153	15.3			
122TL.154	15.4			
122TL.155	15.5	20	101	153
122TL.156	15.6			
122TL.157	15.7			
122TL.158	15.8			
122TL.159	15.9			
122TL.160	16.0	20	101	153
122TL.161	16.1			
122TL.162	16.2			
122TL.163	16.3			
122TL.164	16.4			
122TL.165	16.5	20	101	153
122TL.166	16.6			
122TL.167	16.7			
122TL.168	16.8			
122TL.169	16.9			
122TL.170	17.0	20	101	153
122TL.171	17.1			
122TL.172	17.2			
122TL.173	17.3			
122TL.174	17.4			
122TL.175	17.5	20	101	153
122TL.176	17.6			
122TL.177	17.7			
122TL.178	17.8			
122TL.179	17.9			
122TL.180	18.0	20	101	153
122TL.181	18.1			
122TL.182	18.2			
122TL.183	18.3			
122TL.184	18.4			
122TL.185	18.5	20	101	153
122TL.186	18.6			
122TL.187	18.7			
122TL.188	18.8			
122TL.189	18.9			
122TL.190	19.0	20	101	153
122TL.191	19.1			
122TL.192	19.2			
122TL.193	19.3			
122TL.194	19.4			
122TL.195	19.5	20	101	153
122TL.196	19.6			
122TL.197	19.7			
122TL.198	19.8			
122TL.199	19.9			
122TL.200	20.0	20	101	153
122TL.201	20.1			
122TL.202	20.2			
122TL.203	20.3			
122TL.204	20.4			

CODE	d1h7 mm	d2h6 mm	l1 mm	L mm
122TL.071	7.1	8	53	91
122TL.072	7.2			
122TL.073	7.3			
122TL.074	7.4			
122TL.075	7.5			
122TL.076	7.6	8	53	91
122TL.077	7.7			
122TL.078	7.8			
122TL.079	7.9			
122TL.080	8.0			
122TL.081	8.1	10	61	103
122TL.082	8.2			
122TL.083	8.3			

Punta ad alte prestazioni in metallo duro integrale

Solid carbide high performance twist drill

VHM - Hochleistungsböhrer - Foret carbure à haut performance

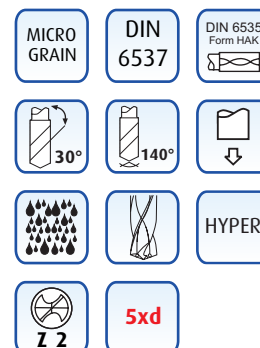
Сверло спиральное твердосплавное высокопроизводительное - Sk vysoce výkonný vrták



CODE	d1h7 mm	d2h6 mm	l1 mm	L mm
122FL.010	1.0	3	10	55
122FL.011	1.1	3	12	55
122FL.012	1.2			
122FL.013	1.3			
122FL.014	1.4			
122FL.015	1.5	3	16	55
122FL.016	1.6			
122FL.017	1.7			
122FL.018	1.8			
122FL.019	1.9	3	21	57
122FL.020	2.0			
122FL.021	2.1			
122FL.022	2.2			
122FL.023	2.3			
122FL.024	2.4			
122FL.025	2.5			
122FL.026	2.6			
122FL.027	2.7	6	28	66
122FL.028	2.8			
122FL.029	2.9			
122FL.030	3.0			
122FL.031	3.1			
122FL.032	3.2			
122FL.033	3.3			
122FL.034	3.4			
122FL.035	3.5	6	36	74
122FL.036	3.6			
122FL.037	3.7			
122FL.038	3.8			
122FL.039	3.9			
122FL.040	4.0			
122FL.041	4.1			
122FL.042	4.2			
122FL.043	4.3	6	44	81
122FL.044	4.4			
122FL.045	4.5			
122FL.046	4.6			
122FL.047	4.7			
122FL.048	4.8			
122FL.049	4.9			
122FL.050	5.0			
122FL.051	5.1	6	53	91
122FL.052	5.2			
122FL.053	5.3			
122FL.054	5.4			
122FL.055	5.5			
122FL.056	5.6			
122FL.057	5.7			
122FL.058	5.8			
122FL.059	5.9	8	53	91
122FL.060	6.0			
122FL.061	6.1			
122FL.062	6.2			
122FL.063	6.3			
122FL.064	6.4			
122FL.065	6.5			
122FL.066	6.6			
122FL.067	6.7	8	53	91
122FL.068	6.8			
122FL.069	6.9			
122FL.070	7.0			
122FL.071	7.1			
122FL.072	7.2			
122FL.073	7.3			

CODE	d1h7 mm	d2h6 mm	l1 mm	L mm
122FL.074	7.4	8	53	91
122FL.075	7.5			
122FL.076	7.6			
122FL.077	7.7			
122FL.078	7.8	10	60	103
122FL.079	7.9			
122FL.080	8.0			
122FL.081	8.1			
122FL.082	8.2			
122FL.083	8.3			
122FL.084	8.4			
122FL.085	8.5			
122FL.086	8.6	12	70	118
122FL.087	8.7			
122FL.088	8.8			
122FL.089	8.9			
122FL.090	9.0			
122FL.091	9.1			
122FL.092	9.2			
122FL.093	9.3			
122FL.094	9.4	14	77	124
122FL.095	9.5			
122FL.096	9.6			
122FL.097	9.7			
122FL.098	9.8			
122FL.099	9.9			
122FL.100	10.0			
122FL.101	10.1	16	83	133
122FL.102	10.2			
122FL.103	10.3			
122FL.104	10.4			
122FL.105	10.5			
122FL.106	10.6			
122FL.107	10.7			
122FL.108	10.8			
122FL.109	10.9	18	93	143
122FL.110	11.0			
122FL.111	11.1			
122FL.112	11.2			
122FL.113	11.3			
122FL.114	11.4			
122FL.115	11.5			
122FL.116	11.6			
122FL.117	11.7	20	101	153
122FL.118	11.8			
122FL.119	11.9			
122FL.120	12.0			
122FL.121	12.1			
122FL.122	12.2			
122FL.123	12.3			
122FL.124	12.4			
122FL.125	12.5	20	101	153
122FL.126	12.6			
122FL.127	12.7			
122FL.128	12.8			
122FL.129	12.9			
122FL.130	13.0			
122FL.131	13.1			
122FL.132	13.2			
122FL.133	13.3	20	101	153
122FL.134	13.4			
122FL.135	13.5			
122FL.136	13.6			
122FL.137	13.7			
122FL.138	13.8			
122FL.139	13.9			
122FL.140	14.0			
122FL.141	14.1	20	101	153
122FL.142	14.2			
122FL.143	14.3			
122FL.144	14.4			
122FL.145	14.5			
122FL.146	14.6			
122FL.147	14.7			
122FL.148	14.8			
122FL.149	14.9	20	101	153
122FL.150	15.0			
122FL.151	15.1			
122FL.152	15.2			
122FL.153	15.3			
122FL.154	15.4			
122FL.155	15.5			
122FL.156	15.6			
122FL.157	15.7	20	101	153
122FL.158	15.8			
122FL.159	15.9			
122FL.160	16.0			
122FL.161	16.1			
122FL.162	16.2			
122FL.163	16.3			
122FL.164	16.4			
122FL.165	16.5	20	101	153
122FL.166	16.6			
122FL.167	16.7			
122FL.168	16.8			
122FL.169	16.9			
122FL.170	17.0			
122FL.171	17.1			
122FL.172	17.2			
122FL.173	17.3	20	101	153
122FL.174	17.4			
122FL.175	17.5			
122FL.176	17.6			
122FL.177	17.7			
122FL.178	17.8			
122FL.179	17.9			
122FL.180	18.0			
122FL.200	20	20	101	153

→ Help 204



Punta ad alte prestazioni in metallo duro integrale

Solid carbide high performance twist drill

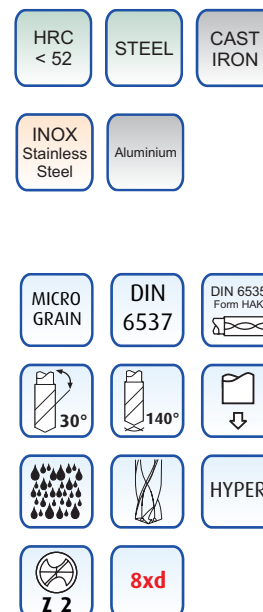
VHM - Hochleistungsbohrer - Foret carbure à haut performance

Сверло спиральное твердосплавное высокопроизводительное - Sk vysoce výkonný vrták



CODE	d1h7 mm	d2h6 mm	l1 mm	L mm	CODE	d1h7 mm	d2h6 mm	l1 mm	L mm
122FALX.035	3.5	6	34	72	122FALX.092	9.2	10	95	142
122FALX.037	3.7				122FALX.095	9.5			
122FALX.038	3.8				122FALX.098	9.8			
122FALX.040	4.0	6	43	81	122FALX.100	10.0			
122FALX.042	4.2				122FALX.102	10.2	12	114	160
122FALX.045	4.5				122FALX.103	10.3			
122FALX.048	4.8	6	57	95	122FALX.105	10.5			
122FALX.050	5.0				122FALX.107	10.7			
122FALX.051	5.1				122FALX.108	10.8			
122FALX.052	5.2				122FALX.110	11.0	14	130	175
122FALX.055	5.5				122FALX.115	11.5			
122FALX.058	5.8				122FALX.118	11.8			
122FALX.060	6.0				122FALX.120	12.0			
122FALX.061	6.1	8	76	114	122FALX.122	12.2			
122FALX.062	6.2				122FALX.123	12.3	16	150	200
122FALX.063	6.3				122FALX.125	12.5			
122FALX.065	6.5				122FALX.128	12.8			
122FALX.067	6.7				122FALX.130	13.0			
122FALX.068	6.8	10	95	142	122FALX.135	13.5			
122FALX.070	7.0				122FALX.140	14.0	18	170	220
122FALX.075	7.5				122FALX.145	14.5			
122FALX.078	7.8				122FALX.150	15.0			
122FALX.080	8.0				122FALX.155	15.5			
122FALX.085	8.5	10	95	142	122FALX.160	16.0	20	190	240
122FALX.088	8.8				122FALX.180	18.0			
122FALX.090	9.0				122FALX.200	20.0			

→ Help 204



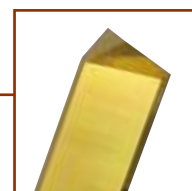
Fresa rompimaschio in metallo duro integrale

Solid carbide tap destroying end mill

VHM Gewindeausbohrwerkzeug - Fraise carbure pour briser les tarauds

Фреза концевая твердосплавная для фрезерования резьбовых проемов

Sk fréza pro obrábění zalomených závitníků



CODE	THREAD	d1e9 mm	d2 mm	l1 mm	L mm	Z no.
145.033	M4	3.3	6	15	50	3
145.042	M5	4.2	6	15	50	3
145.050	M6	5.0	6	15	50	3
145.068	M8	6.8	8	20	60	3
145.085	M10	8.5	10	25	70	3
145.102	M12	10.2	12	30	75	3
145.120	M14	12.0	12	30	75	3
145.140	M16	14.0	14	40	100	3
145.155	M18	15.5	16	40	100	3
145.175	M20	17.5	18	50	100	3

VC = 40 m/min

Fz = 0.01mm/Revolution

Set fresa rompimaschio - Destroyng set end mills

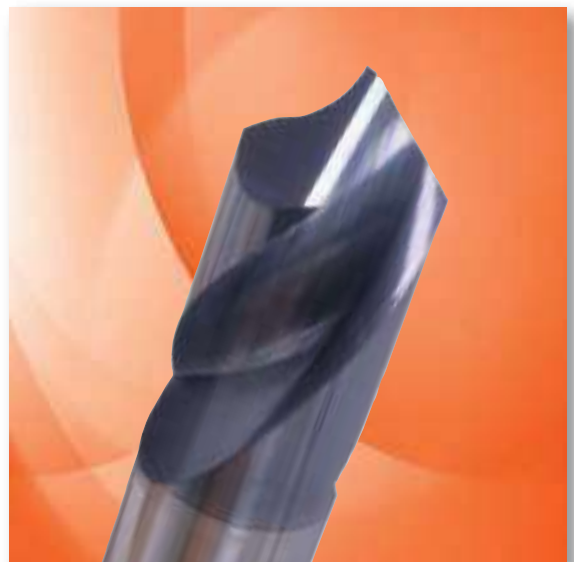
CODE	COMPOSTO DA COMPOSED OF	Q.TY
145/SET	Ø3.3/4.2/5/6.8/8.5/10.2/12	1 EACH



Punte convenzionali

Conventional drills

Universal Spiralböhrrer
Foret universel
Сверла стандартные
Konvenční vrtáky



Punta elicoidale autocentrante in metallo duro integrale

Solid carbide autocentering twist drill

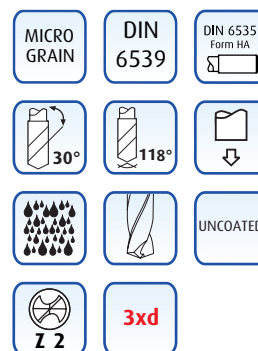
VHM - Spiralbohrer Selbstzentrierend - Foret carbure hélicoidale autocentrage

Сверло спиральное твердосплавное автоцентрирующееся - Sk centrovací vrták



CODE	d1h6 mm	d2h6 mm	l1 mm	L mm
120.004	0.4	0.4	6	26
120.005	0.5	0.5	6	26
120.006	0.6	0.6	6	26
120.007	0.7	0.7	6	26
120.008	0.8	0.8	6	26
120.009	0.9	0.9	6	26
120.010	1.0	1.0	6	26
120.011	1.1	1.1	7	28
120.012	1.2	1.2	8	30
120.013	1.3	1.3	8	30
120.014	1.4	1.4	9	32
120.015	1.5	1.5	9	32
120.016	1.6	1.6	10	34
120.017	1.7	1.7	10	34
120.018	1.8	1.8	11	36
120.019	1.9	1.9	11	36
120.020	2.0	2.0	12	38
120.021	2.1	2.1	12	38
120.022	2.2	2.2	13	40
120.023	2.3	2.3	13	40
120.024	2.4	2.4	14	43
120.025	2.5	2.5	14	43
120.026	2.6	2.6	14	43
120.027	2.7	2.7	16	46
120.028	2.8	2.8	16	46
120.029	2.9	2.9	16	46
120.030	3.0	3.0	16	46
120.031	3.1	3.1	18	49
120.032	3.2	3.2	18	49
120.033	3.3	3.3	18	49
120.034	3.4	3.4	20	52
120.035	3.5	3.5	20	52
120.036	3.6	3.6	20	52
120.037	3.7	3.7	20	52
120.038	3.8	3.8	22	55
120.039	3.9	3.9	22	55
120.040	4.0	4.0	22	55
120.041	4.1	4.1	22	55
120.042	4.2	4.2	22	55
120.043	4.3	4.3	24	58
120.044	4.4	4.4	24	58
120.045	4.5	4.5	24	58
120.046	4.6	4.6	24	58
120.047	4.7	4.7	24	58
120.048	4.8	4.8	26	62
120.049	4.9	4.9	26	62
120.050	5.0	5.0	26	62
120.051	5.1	5.1	26	62
120.052	5.2	5.2	26	62
120.053	5.3	5.3	26	62
120.054	5.4	5.4	28	66
120.055	5.5	5.5	28	66
120.056	5.6	5.6	28	66
120.057	5.7	5.7	28	66
120.058	5.8	5.8	28	66
120.059	5.9	5.9	28	66
120.060	6.0	6.0	28	66
120.061	6.1	6.1	31	70
120.062	6.2	6.2	31	70
120.063	6.3	6.3	31	70
120.064	6.4	6.4	31	70
120.065	6.5	6.5	31	70

CODE	d1h6 mm	d2h6 mm	l1 mm	L mm
120.066	6.6	6.6	31	70
120.067	6.7	6.7	31	70
120.068	6.8	6.8	34	74
120.069	6.9	6.9	34	74
120.070	7.0	7.0	34	74
120.071	7.1	7.1	34	74
120.072	7.2	7.2	34	74
120.073	7.3	7.3	34	74
120.074	7.4	7.4	34	74
120.075	7.5	7.5	34	74
120.076	7.6	7.6	37	79
120.077	7.7	7.7	37	79
120.078	7.8	7.8	37	79
120.079	7.9	7.9	37	79
120.080	8.0	8.0	37	79
120.081	8.1	8.1	37	79
120.082	8.2	8.2	37	79
120.083	8.3	8.3	37	79
120.084	8.4	8.4	37	79
120.085	8.5	8.5	37	79
120.086	8.6	8.6	40	84
120.087	8.7	8.7	40	84
120.088	8.8	8.8	40	84
120.089	8.9	8.9	40	84
120.090	9.0	9.0	40	84
120.091	9.1	9.1	40	84
120.092	9.2	9.2	40	84
120.093	9.3	9.3	40	84
120.094	9.4	9.4	40	84
120.095	9.5	9.5	40	84
120.096	9.6	9.6	43	89
120.097	9.7	9.7	43	89
120.098	9.8	9.8	43	89
120.099	9.9	9.9	43	89
120.100	10.0	10.0	43	89
120.102	10.2	10.2	43	89
120.105	10.5	10.5	43	89
120.107	10.7	10.7	43	89
120.108	10.8	10.8	47	95
120.110	11.0	11.0	47	95
120.112	11.2	11.2	47	95
120.114	11.4	11.4	47	95
120.115	11.5	11.5	47	95
120.117	11.7	11.7	47	95
120.118	11.8	11.8	47	95
120.120	12.0	12.0	51	102
120.125	12.5	12.5	51	102
120.130	13.0	13.0	51	107
120.135	13.5	13.5	54	107
120.140	14.0	14.0	54	107
120.145	14.5	14.5	56	111
120.150	15.0	15.0	56	111
120.155	15.5	15.5	58	115
120.160	16.0	16.0	58	115
120.165	16.5	16.5	60	119
120.170	17.0	17.0	60	119
120.180	18.0	18.0	62	123
120.185	18.5	18.5	64	127
120.190	19.0	19.0	64	127
120.195	19.5	19.5	66	131
120.200	20.0	20.0	66	131



→ Help 203

Punta elicoidale autocentrante in metallo duro integrale

Solid carbide autocentering twist drill

VHM - Spiralbohrer Selbstzentrierend - Foret carbure hélicoidale autocentrage

Сверло спиральное твердосплавное автоцентрирующееся - Sk centrovací vrták



CODE	d1h6 mm	d2h6 mm	l1 mm	L mm
130.004	0.4	0.4	6	26
130.005	0.5	0.5	6	26
130.006	0.6	0.6	6	26
130.007	0.7	0.7	9	28
130.008	0.8	0.8	10	30
130.009	0.9	0.9	11	32
130.010	1.0	1.0	12	34
130.011	1.1	1.1	14	36
130.012	1.2	1.2	16	38
130.013	1.3	1.3	16	38
130.014	1.4	1.4	18	40
130.015	1.5	1.5	18	40
130.016	1.6	1.6	20	43
130.017	1.7	1.7	20	43
130.018	1.8	1.8	22	46
130.019	1.9	1.9	22	46
130.020	2.0	2.0	24	49
130.021	2.1	2.1	24	49
130.022	2.2	2.2	27	53
130.023	2.3	2.3	27	53
130.024	2.4	2.4	30	57
130.025	2.5	2.5	30	57
130.026	2.6	2.6	30	57
130.027	2.7	2.7	33	61
130.028	2.8	2.8	33	61
130.029	2.9	2.9	33	61
130.030	3.0	3.0	33	61
130.031	3.1	3.1	36	65
130.032	3.2	3.2	36	65
130.033	3.3	3.3	36	65
130.034	3.4	3.4	39	70
130.035	3.5	3.5	39	70
130.036	3.6	3.6	39	70
130.037	3.7	3.7	39	70
130.038	3.8	3.8	43	75
130.039	3.9	3.9	43	75
130.040	4.0	4.0	43	75
130.041	4.1	4.1	43	75
130.042	4.2	4.2	43	75
130.043	4.3	4.3	47	80
130.044	4.4	4.4	47	80
130.045	4.5	4.5	47	80
130.046	4.6	4.6	47	80
130.047	4.7	4.7	47	80
130.048	4.8	4.8	52	86
130.049	4.9	4.9	52	86
130.050	5.0	5.0	52	86
130.051	5.1	5.1	52	86
130.052	5.2	5.2	52	86
130.053	5.3	5.3	52	86
130.054	5.4	5.4	57	93
130.055	5.5	5.5	57	93
130.056	5.6	5.6	57	93
130.057	5.7	5.7	57	93
130.058	5.8	5.8	57	93
130.059	5.9	5.9	57	93
130.060	6.0	6.0	57	93
130.061	6.1	6.1	63	101
130.062	6.2	6.2	63	101
130.063	6.3	6.3	63	101
130.064	6.4	6.4	63	101

CODE	d1h6 mm	d2h6 mm	l1 mm	L mm
130.065	6.5	6.5	63	101
130.066	6.6	6.6	63	101
130.067	6.7	6.7	63	101
130.068	6.8	6.8	69	109
130.069	6.9	6.9	69	109
130.070	7.0	7.0	69	109
130.071	7.1	7.1	69	109
130.072	7.2	7.2	69	109
130.073	7.3	7.3	69	109
130.074	7.4	7.4	69	109
130.075	7.5	7.5	69	109
130.076	7.6	7.6	75	117
130.077	7.7	7.7	75	117
130.078	7.8	7.8	75	117
130.079	7.9	7.9	75	117
130.080	8.0	8.0	75	117
130.081	8.1	8.1	75	117
130.082	8.2	8.2	75	117
130.083	8.3	8.3	75	117
130.084	8.4	8.4	75	117
130.085	8.5	8.5	75	117
130.086	8.6	8.6	81	125
130.087	8.7	8.7	81	125
130.088	8.8	8.8	81	125
130.089	8.9	8.9	81	125
130.090	9.0	9.0	81	125
130.091	9.1	9.1	81	125
130.092	9.2	9.2	81	125
130.093	9.3	9.3	81	125
130.094	9.4	9.4	81	125
130.095	9.5	9.5	81	125
130.096	9.6	9.6	87	133
130.097	9.7	9.7	87	133
130.098	9.8	9.8	87	133
130.099	9.9	9.9	87	133
130.100	10.0	10.0	87	133
130.102	10.2	10.2	87	133
130.105	10.5	10.5	87	133
130.107	10.7	10.7	94	142
130.108	10.8	10.8	94	142
130.109	10.9	10.9	94	142
130.110	11.0	11.0	94	142
130.112	11.2	11.2	94	142
130.115	11.5	11.5	94	142
130.120	12.0	12.0	101	151
130.121	12.1	12.1	101	151
130.122	12.2	12.2	101	151
130.125	12.5	12.5	101	151
130.129	12.9	12.9	101	151
130.130	13.0	13.0	101	151
130.131	13.1	13.1	101	151
130.135	13.5	13.5	108	160
130.140	14.0	14.0	108	160
130.142	14.2	14.2	114	169
130.145	14.5	14.5	114	169
130.150	15.0	15.0	114	169
130.155	15.5	15.5	120	178
130.160	16.0	16.0	120	178
130.180	18.0	18.0	130	191
130.200	20.0	20.0	140	205



→ Help 203

Punta a centrare 90° per C.N. in metallo duro integrale

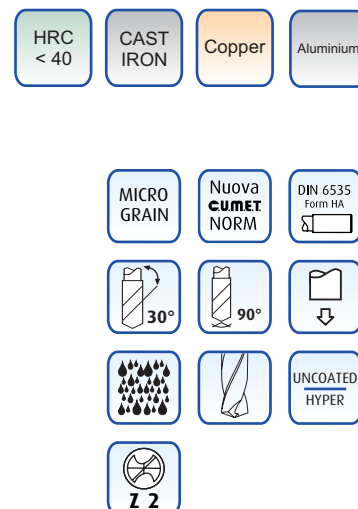
Solid carbide N.C. center drill 90°

VHM - N.C. Anböhler - Foret carbure à centrer N.C.

Сверло центровочное твердосплавное - Sk nc centrovací vrták



CODE UNCOATED	CODE HYPER	d1h6 mm	d2h6 mm	l1 mm	l2 mm	L MM	Z no.
190.030	190T.030	3	3	10	-	40	2
190.040	190T.040	4	4	12	-	50	2
-	190T.040L	4	6	10	12	121	2
190.050	190T.050	5	5	15	-	50	2
-	190T.050L	5	6	13	15	130	2
190.060	190T.060	6	6	15	-	50	2
-	190T.080L	6	6	15	-	139	2
190.080	190T.080	8	8	20	-	60	2
-	190T.180L	8	8	17	-	164	2
190.100	190T.100	10	10	25	-	70	2
-	190T.100L	10	10	20	-	183	2
190.120	190T.120	12	12	25	-	75	2
-	190T.120L	12	12	25	-	204	2
190.140	190T.140	14	14	25	-	75	2
190.160	190T.160	16	16	30	-	75	2
-	190T.160L	16	16	25	-	228	2
190.200	190T.200	20	20	30	-	100	2



Punta a centrare 140° per C.N. in metallo duro integrale

Solid carbide N.C. center drill 140°

VHM - N.C. Anböhler - Foret carbure à centrer N.C.

Сверло центровочное твердосплавное - Sk nc centrovací vrták



CODE	d1 mm	d2h6 mm	l1 mm	l2 mm	L mm	Z no.
190T.041	4	6	10	12	121	2
190T.051	5	6	13	15	130	2
190T.061	6	6	15	-	139	2
190T.081	8	8	20	-	164	2
190T.101	10	10	25	-	183	2
190T.121	12	12	25	-	204	2
190T.161	16	16	30	-	230	2



Punta a centrare 120° per C.N. in metallo duro integrale

Solid carbide N.C. center drill 120°

VHM - N.C. Anböhler - Foret carbure à centrer N.C.

Сверло центровочное твердосплавное - Sk nc centrovací vrták



CODE UNCOATED	CODE HYPER	d1h6 mm	d2h6 mm	l1 mm	L mm	Z no.
190.030.1	190T.030.1	3.0	3.0	10	40	2
190.040.1	190T.040.1	4.0	4.0	12	50	2
190.050.1	190T.050.1	5.0	5.0	15	50	2
190.060.1	190T.060.1	6.0	6.0	15	50	2
190.080.1	190T.080.1	8.0	8.0	20	60	2
190.100.1	190T.100.1	10.0	10.0	25	70	2
190.120.1	190T.120.1	12.0	12.0	25	75	2
190.140.1	190T.140.1	14.0	14.0	25	75	2
190.160.1	190T.160.1	16.0	16.0	30	75	2
190.200.1	190T.200.1	20.0	20.0	30	100	2



Punta a centrare in metallo duro integrale

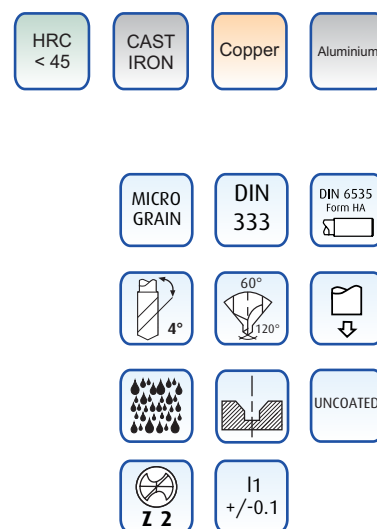
Solid carbide center drill

VHM - Zentrierbohrer - Foret carbure à centrer

Сверло центровочное твердосплавное - Sk nc centrovací vrták



CODE	d1h12 mm	d2h6 mm	l1* mm	L mm	Z no.
140.008	0.8	3.15	1.10	40	2
140.010	1.0	3.15	1.45	40	2
140.010.1	1.0	4.0	1.45	40	2
140.0125	1.25	3.15	1.75	40	2
140.015	1.5	5.0	2.10	40	2
140.016	1.6	4.0	2.10	40	2
140.016.1	1.6	5.0	2.10	40	2
140.020	2.0	5.0	2.70	40	2
140.020.1	2.0	6.0	2.70	45	2
140.020.2	2.0	6.3	2.70	45	2
140.025	2.5	6.3	3.35	45	2
140.025.1	2.5	8.0	3.35	50	2
140.030	3.0	8.0	4.15	50	2
140.030.1	3.0	10.0	4.15	56	2
140.0315	3.15	8.0	4.15	50	2
140.0315.1	3.15	10.0	4.15	56	2
140.040	4.0	10.0	5.30	56	2

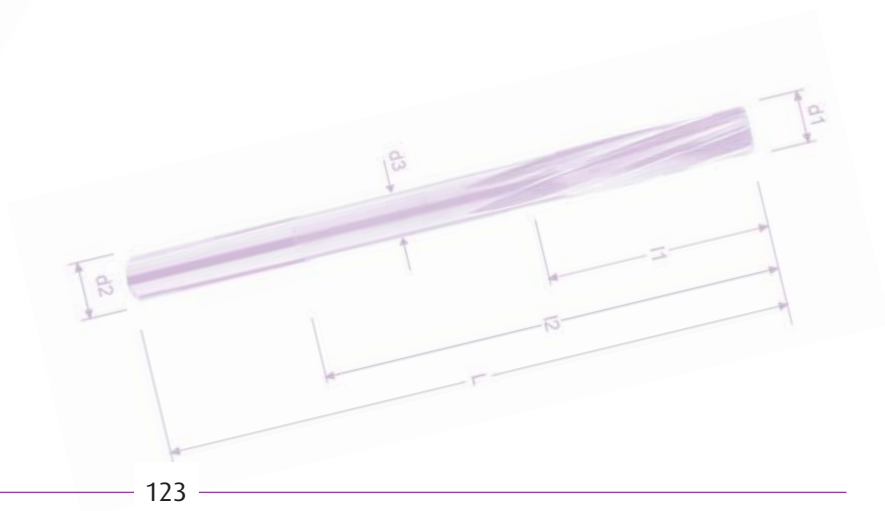
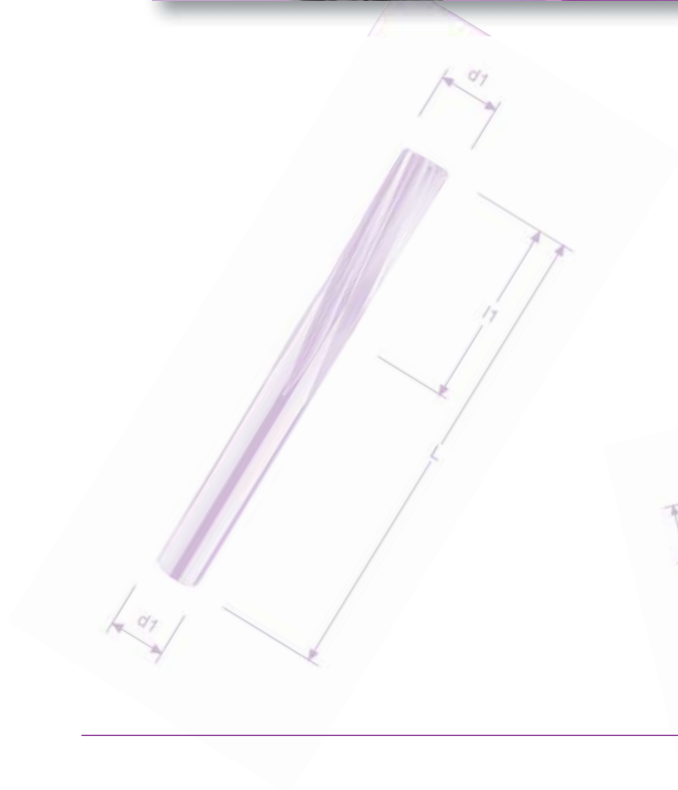


→ Help 203

Alesatori

Reamers

Reibahlen
Alesoir
Развертки
Výstružníky



Alesatore a divisione irregolare in metallo duro integrale

Solid carbide reamer with unequal division

VHM - Reibähle ungleiche teilung - Alesoir à division irrégulière en carbure
Развертка твердосплавная - Sk výstružník s nerovnoměrnou šroubovicí



CODE	d1H7 mm	d2H7 mm	l1 mm	l2 mm	L mm	d3 mm	Z no.
910.010	1.0	1.0	5	-	40	-	4
910.015	1.5	1.5	11	-	40	-	4
910.020	2.0	2.0	11	31	50	1.9	4
910.025	2.5	2.5	14	37	57	2.4	4
910.030	3.0	3.0	15	41	60	2.9	4
910.035	3.5	3.5	18	48	70	3.4	4
910.040	4.0	4.0	19	53	75	3.9	4
910.045	4.5	4.5	21	58	80	4.4	4
910.050	5.0	5.0	23	61	93	4.9	6
910.055	5.5	5.5	26	63	93	5.4	6
910.060	6.0	6.0	26	63	93	5.9	6
910.065	6.5	6.5	28	65	100	6.4	6
910.070	7.0	7.0	31	74	109	6.9	6
910.075	7.5	7.5	31	74	109	7.4	6
910.080	8.0	8.0	33	82	117	7.9	6
910.085	8.5	8.5	33	82	117	8.4	6
910.090	9.0	9.0	36	85	125	8.9	6
910.095	9.5	9.5	36	85	125	9.4	6
910.100	10.0	10.0	38	87	135	9.9	6
910.105	10.5	10.5	38	93	135	10.4	6
910.110	11.0	11.0	41	102	140	10.9	6
910.115	11.5	11.5	41	102	140	11.4	6
910.120	12.0	12.0	44	106	150	11.9	6
910.125	12.5	12.5	44	106	150	12.4	6
910.130	13.0	13.0	44	106	150	12.9	6
910.135	13.5	13.5	47	115	160	13.4	8
910.140	14.0	14.0	47	115	160	13.9	8
910.145	14.5	14.5	50	117	160	14.4	8
910.150	15.0	15.0	50	117	160	14.9	8
910.155	15.5	15.5	50	120	160	15.4	8
910.160	16.0	16.0	50	120	160	15.9	8

→ Help 193



HRC < 40

CAST IRON

Ti-Alloy

Inconell

INOX Stainless Steel

NE NON FERROUS

MICRO GRAIN

DIN 212

DIN 6535 Form HA

45°

L R 7°

LEFT HELIX RIGHT CUT

OIL AIR

Z 4

Z 6

Z 8

Ø1 - Ø4,5

Ø5 - Ø13

Ø13,5 - Ø16

UNCOATED

Alesatore a divisione irregolare in metallo duro integrale

Solid carbide reamer with unequal division

VHM - Reibähle ungleiche teilung - Alesoir à division irrégulière en carbure
Развертка твердосплавная - Sk výstružník s nerovnoměrnou šroubovicí



CODE	FROM d1H7 mm	TO d1H7 mm	l1 mm	L mm	Z no.
910T...	1.01	1.29	9	40	3
	1.30	1.49	10	40	3
	1.51	1.99	13	40	4
	2.01	2.49	13	40	4
	2.51	2.99	16	60	4
	3.01	3.49	19	60	4
	3.51	3.99	19	60	4
	4.01	4.49	19	60	4
	4.51	4.99	22	70	4
	5.01	5.49	22	70	4
	5.51	5.99	25	75	4
	6.01	6.49	25	75	4
	6.51	6.99	25	75	6
	7.01	7.49	25	75	6
	7.51	7.99	28	75	6
	8.01	8.49	28	75	6
	8.51	8.99	35	100	6
	9.01	9.49	35	100	6
	9.51	9.99	35	100	6
	10.01	10.49	35	100	6
	10.51	10.99	35	100	6
	11.01	11.49	35	100	6
	11.51	11.99	35	100	6
	12.01	12.49	35	100	6
	12.51	12.99	35	100	6

→ Help 193



HRC < 40

CAST IRON

Ti-Alloy

Inconell

INOX Stainless Steel

NE NON FERROUS

MICRO GRAIN

Nuova CUMET NORM

DIN 6535 Form HA

45°

L R 7°

LEFT HELIX RIGHT CUT

OIL AIR

Z 3

Z 4

Z 6

Ø1,01 - Ø1,49

Ø1,51 - Ø6,49

Ø6,51 - Ø12,99

UNCOATED

Alesatore a divisione irregolare in metallo duro integrale

Solid carbide reamer with unequal division

VHM - Reibähle ungleiche teilung - Alesoir à division irrégulière en carbure
Развертка твердосплавная - Sk výstružník s nerovnoměrnou šroubovící



CODE	d1H7 mm	d2H7 mm	l1 mm	L mm	Z no.
900T.010	1.0	1.0	9	40	3
900T.015	1.5	1.5	10	40	4
900T.020	2.0	2.0	13	50	4
900T.025	2.5	2.5	13	50	4
900T.030	3.0	3.0	16	60	4
900T.035	3.5	3.5	19	60	4
900T.040	4.0	4.0	19	60	4
900T.045	4.5	4.5	22	70	4
900T.050	5.0	5.0	25	70	4
900T.055	5.5	5.5	25	75	4
900T.060	6.0	6.0	25	75	4
900T.065	6.5	6.5	25	75	4
900T.070	7.0	7.0	25	75	6
900T.075	7.5	7.5	25	75	6
900T.080	8.0	8.0	28	75	6
900T.085	8.5	8.5	28	75	6
900T.090	9.0	9.0	35	100	6
900T.095	9.5	9.5	35	100	6
900T.100	10.0	10.0	35	100	6
900T.105	10.5	10.5	35	100	6
900T.110	11.0	11.0	35	100	6
900T.115	11.5	11.5	35	100	6
900T.120	12.0	12.0	35	100	6
900T.125	12.5	12.5	35	100	6
900T.130	13.0	13.0	35	100	6

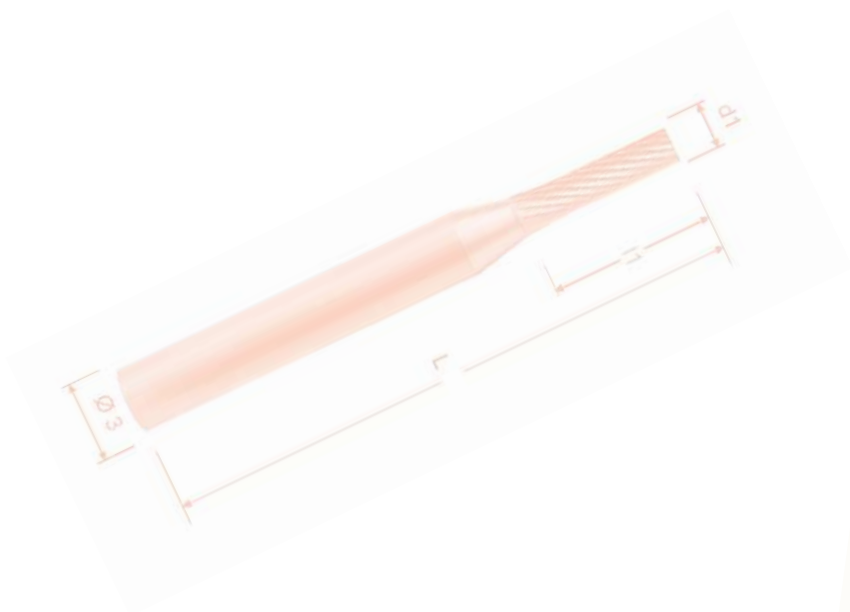
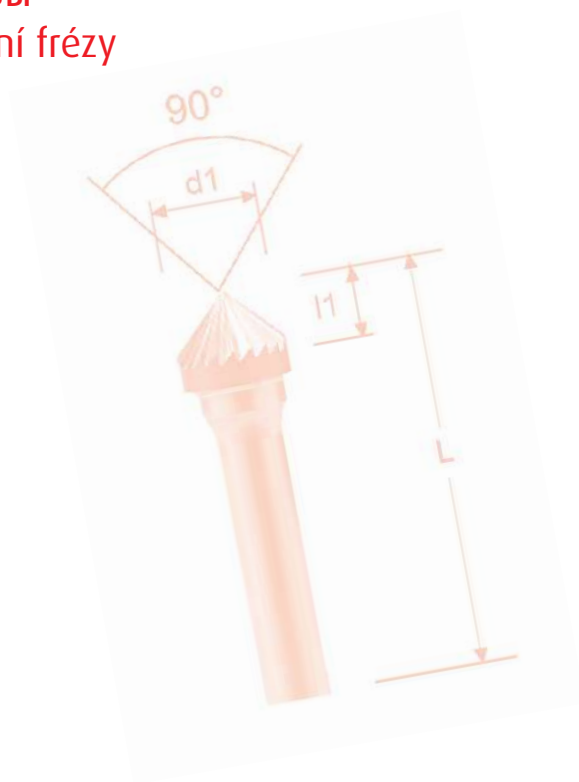
→ Help 193



HRC < 40	CAST IRON	Ti-Alloy
Inconell	INOX Stainless Steel	NE NON FERROUS
MICRO GRAIN	NUOVA CUMET NORM	DIN 6535 Form HA
45°	L R 7°	LEFT HELIX RIGHT CUT
Oil Air		
Z 3 01	Z 4 01,5 - 06,5	Z 6 07 - 013
UNCOATED		

Lime rotative Rotary files

Rotierfräser
Fraises limes rotatives
Бор-фрезы
Technické rotační frézy

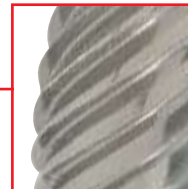


Scelta della dentatura

Choice of the cut

Verzahnungen - Choise de la denture

Тип резк



01



Dentatura speciale per leghe leggere: RAME - ALLUMINIO - BRONZO

Special toothing for light alloy: COPPER - BRONZE - ALUMINIUM

Spezielle Verzahnung für Leichtmetallgierungen: KUPFER - BRONZE - ALUMINIUM

Denture spéciale pour alliages légers: CUIVRE - BRONZE - ALUMINIUM

Для легких сплавов: меди, бронзы, алюминия

Speciální ostří pro měkké slitiny: MĚĎ, BRONZ, HLINÍK

03



Dentatura standard per una buona finitura su: ACCIAIO FUSO - ACCIAIO TEMPERATO - GHISA

Standard toothing, giving a good finishing on: STAINLESS STEEL - HARDENED STEEL - CAST IRON

Standardverzahnung für eine gute Oberfläche bei Gubstahl - Gubeisen Gehärteten Stahl und Allgemeinen Einsatz

Denture normale qui donne un bon finissage sur: ACIER FONDU - ACIER TEMPRE' - FONTE

Стандартная заточка: для нержавеющей стали, закаленной стали, чугуна

Standartní ostří pro dobré dokončení na: NEREZ, KALENÁ OCEL, LITINA

04



Dentatura diamante per elevato rendimento sia in sgrossatura che in finitura su: ACCIAI MOLTO DURI, CORDONI DI SALDATURA - GHISA. Inoltre questo particolare taglio, polverizza il truciolo, evitando danni all'operatore

Diamond cut giving an extra efficiency both in roughing and in finishing, on very hard steel, weld seams and cast iron. More over this particularly cut crumbles the chips, thus avoiding damages to the operator

Diamantverzahnung für eine gesteigerte Zerspanung aus dem vollen und zur Nacharbeit unter anderem für Schweißnähte, gehärteten und verguteten Stahl und Guss

Denture diamant qui donne un très bon rendement soit en dégrossage soit en finissage sur: ACIERS TRES DUR-CORDONS SOUDURES - MOULAGE DE FONTE. En outre, ce type particulier de taille donne des copeaux très court, en évitant des dommages à l'opérateur

Алмазная заточка эффективна при черновой и чистовой обработке высокопрочных сталей, сварочных швов и чугуна. Алмазная заточка образует порошкообразную стружку и обеспечивает безопасность работы оператора

Diamantové ostří uvádí větší účinnost v hrubování i dokončovacích operacích pro velmi tvrdé materiály, návary a litinu. Tento utvařec dělí materiál na velmi jemné špony, čímž se zabrání ucpání v řezu

05



Dentatura romptruciolo per Acciai non temperati, colati, acciai dolci, saldature

Chip breaker cutting for: Unhardened steel, cast steel, weld seams

Spanbrecherverzahnung für ungehärtete Stähle und Stahlguss Schweißnähte

Denture brise-copeaux pour aciers non trempés, améliorés et coulés, cordons de soudures

Заточка для обработки незакаленной стали, сталей, сварных швов

Utvařec pro: nekalené oceli, ocelolitiny a sváry

06



Dentatura universale alternata per materiali duri e teneri

Alternate, universal cutting, soft and hard material

Universelle Wechselverzahnung, für weiche und harte Materialien

Denture alternée, universelle, pour matériaux durs et tendres

Двойная универсальная заточка для твердых и мягких материалов

Universální alternativa pro měkké i tvrdé materiály

Lima rotativa "micro" in metallo duro integrale, gambo Ø 3 mm

Solid carbide "micro" rotary file, shank Ø 3 mm

VHM - "Micro" Rotierfräser, Schaft Ø 3 mm - Limes carbure "micro", queue Ø 3 mm

Мини бор-фрезы твердосплавные хвостовик Ø 3 mm

Sk mikro rotační technická fréza se stopkou Ø 3 mm



CODE	d1 mm	l1 mm	L mm	
AM010003	1.0	4	38	
AM015003	1.5	4	38	
AM020003	2.0	4	38	

CODE	d1 mm	l1 mm	L mm	
CM010003	1.0	4	38	
CM015003	1.5	4	38	
CM020003	2.0	4	38	

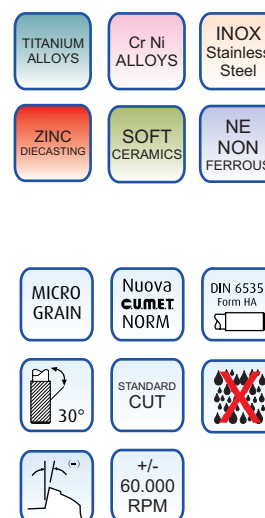
CODE	d1 mm	l1 mm	L mm	
DM010003	1.0	1.0	38	
DM015003	1.5	1.5	38	
DM020003	2.0	2.0	38	

CODE	d1 mm	l1 mm	L mm	
EM015003	1.5	4	38	

CODE	d1 mm	l1 mm	L mm	
FM015003	1.5	4	38	

CODE	d1 mm	l1 mm	L mm	
GM015003	1.5	4	38	

CODE	d1 mm	l1 mm	L mm	
MM015003	1.5	4	38	



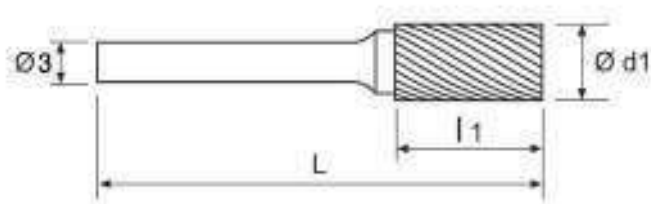
Lima rotativa in miniatura in metallo duro integrale gambo 3 mm

Solid carbide miniature rotary file shank Ø 3 mm

VHM - mini Rotierfräser Schaft Ø 3 mm - Limes rotatives en miniature en carbure monobloc queue Ø 3 mm

Мини бор-фрезы твердосплавные хвостовик Ø 3 mm

Sk mini rotační technická fréza se stopkou Ø 3 mm



SHAPE	CODE	USA STYLE	d1 mm	l1 mm	L mm
	A0150	SA-41M	1.5	6	38
	A0200	SA-42M	2.0	12	38
	A0250	-	2.5	12	38
	A0300	SA-43M	3.0	14	38
	B0150	SB-41M	1.5	6	38
	B0200	-	2.0	12	38
	B0250	SB-42M	2.5	12	38
	B0300	SB-43M	3.0	14	38
	C0200	-	2.0	12	38
	C0250	SC-41M	2.5	12	38
	C0300	SC-42M	3.0	14	38
	D0150	-	1.5	1.3	38
	D0200	-	2.0	1.7	38
	D0250	SD-41M	2.5	2.3	38
	D0300	SD-42M	3.0	2.6	38

SHAPE	CODE	USA STYLE	d1 mm	l1 mm	L mm
	E0300	SE-41M	3	6	38
	F0300	SF-42M	3	14	38
	G0300	SG-44M	3	12.7	38
	H0300	SH-41M	3	6,3	38
	L0300	SL-42M	3	12.7	38
	M0310	SM-42M	3	10	38
	M0315	SM-43M	3	15	38
	M0318	-	3	18	38
	N0300	SN-42M	3	3	38
	J0300	SJ-42M	3	60°	38
	K0300	SK-42M	3	90°	38

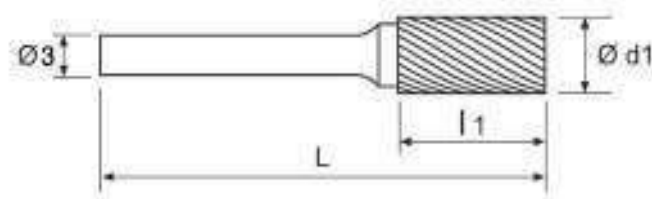
Lima rotativa in metallo duro integrale gambo in acciaio Ø 3 mm

Solid carbide rotary file steel shank Ø 3 mm

VHM - Rotierfräser Stahl shaft Ø 3 mm - Limes rotatives en carbure monobloc queue en acier Ø 3 mm

Бор-фрезы твердосплавные хвостовик Ø 3 mm

sk rotační technická fréza s ocelovou stopkou Ø 3 mm

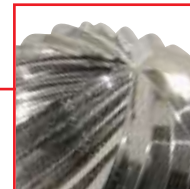


SHAPE	CODE	USA STYLE	d1 mm	l1 mm	L mm
	AS1040	SA-52M	4	12.0	50
	AS1050	SA-53M	5	12.0	50
	AS1060	SA-51M	6	12.7	50
	BS2040	-	4	12.0	50
	BS2050	-	5	12.0	50
	BS2060	-	6	12.7	50
	CS3040	SC-52M	4	12.0	50
	CS3050	SC-53M	5	12.0	50
	CS3060	SC-51M	6	12.0	50
	DS4040	SD-52M	4	3.4	50
	DS4050	SD-53M	5	4.7	50
	DS4060	SD-51M	6	5.0	44
	ES5050	SE-53M	5	7.1	50
	ES5060	SE-51M	6	9.5	47
	FS6050	SF-53M	5	12.0	50
	FS6060	SF-51M	6	12.0	50
	GS7050	SG-53M	5	12.0	50
	GS7060	SG-51M	6	12.0	50
	LS9050	SL-53M	5	12.0	50
	LS9060	-	6	15.0	47
	MS8050	SM-53M	5	12.0	50
	MS8060	SM-51M	6	12.0	54
	NS1150	SN-53M	5	6.3	50
	NS1160	SN-51M	6	6.0	44

Lima rotativa in metallo duro integrale gambo Ø 6 mm

Solid carbide rotary file shank Ø 6 mm

VHM - Rotierfräser Schaft Ø 6 mm - Limes rotatives en carbure monobloc queue Ø 6 mm
Бор-фрезы твердосплавные хвостовик Ø 6 mm - Sk rotační technická fréza stopka Ø 6 mm



Forma cilindrica - Cylinder shape - Zylinder Form - Forme cylindrique
Цилиндрическая форма - Válcový tvar

CODE	USA STYLE	d1 mm	l1 mm	L mm
A0312	SA-12M	3	12.7	50
A0412	SA-13M	4	16	50
A0516	SA-14M	5	16	50
A0616	SA-1M	6	16	50
A0612L	SA-1ML6	6	16	162
A0820	SA-2M	8	20	64
A1020	SA-3M	10	20	64
A1020L	SA-3ML6	10	20	169
A1125	SA-4M	11	25	70
A1225	SA-5M	12	25	70
A1225L	SA-5ML6	12	25	175
A1625	SA-6M	16	25	70
A2025	SA-7M	20	25	70
A2525	SA-9M	25	25	70



Forma cilindrica con taglio in testa - Cylinder shape end cut - Zylinder Form - Forme cylindrique
Цилиндрическая форма - Válcový tvar konce

CODE	USA STYLE	d1 mm	l1 mm	L mm
B0312	SB-12M	3	12.7	50
B0412	SB-13M	4	16	50
B0516	SB-14M	5	16	50
B0616	SB-1M	6	16	50
B0616L	SB-1ML6	6	16	162
B0820	SB-2M	8	20	64
B1020	SB-3M	10	20	64
B1125	SB-4M	11	25	70
B1225	SB-5M	12	25	70
B1625	SB-6M	16	25	70
B2025	SB-7M	20	25	70
B2525	SB-9M	25	25	70



Cilindro sferica - Cylinder with radius end - Kugelzylinder - Forme cylindrique bout arrondi
Цилиндрическая форма с радиусным торцом - Válcový tvar s rádiusovým zakončením

CODE	USA STYLE	d1 mm	l1 mm	L mm
C0312	SC-12M	3	16	50
C0412	SC-13M	4	16	50
C0516	SC-14M	5	16	50
C0616	SC-1M	6	16	50
C0612L	SC-1ML6	6	16	162
C0820	SC-2M	8	20	64
C1020	SC-3M	10	20	64
C1020L	SC-3ML6	10	20	169
C1125	SC-4M	11	25	70
C1225	SC-5M	12	25	70
C1225L	SC-5ML6	12	25	175
C1625	SC-6M	16	25	70
C2025	SC-7M	20	25	70
C2525	SC-9M	25	25	70



Lima rotativa in metallo duro integrale gambo Ø 6 mm

Solid carbide rotary file shank Ø 6 mm

VHM - Rotierfräser Schaft Ø 6 mm - Limes rotatives en carbure monobloc queue Ø 6 mm

Бор-фрезы твердосплавные хвостовик Ø 6 mm - Sk rotační technická fréza se stopkou Ø 6 mm



Forma sferica - Ball shape - Kugel Form - Forme ronde
Сферическая форма - Kulový tvar

CODE	USA STYLE	d1 mm	l1 mm	L mm
D0303	SD-11M	3	2.5	50
D0404	-	4	3.4	50
D0505	SD-14M	5	4.0	50
D0606	SD-1M	6	5.0	50
D0606L	SD-1ML6	6	5.0	155
D0808	SD- 2M	8	7.0	51
D1010	SD-3M	10	8.0	53
D1010L	SD-3ML6	10	8.0	158
D1111	SD-4M	11	9.5	54
D1212	SD-5M	12	11.0	56
D1212L	SD-5ML6	12	11.0	161
D1616	SD-6M	16	14.0	60
D2020	SD-7M	20	16.0	60
D2525	SD-9M	25	21.0	66



Forma ovale - Oval shape - Tropfen Form - Forme ovale
Овальная форма - Ovalný tvar

CODE	USA STYLE	d1 mm	l1 mm	L mm
E0610	SE-1M	6	10	50
E0610L	SE-1ML 6	6	10	160
E0813	-	8	13	58
E1016	SE-3M	10	16	60
E1016L	SE-3ML6	10	16	166
E1222	SE-5M	12	22	66
E1222L	SE-5ML6	12	22	172
E1625	SE-6M	16	25	70
E2025	SE-7M	20	25	70



Forma ogiva punta arrotondata - Tree shape radius end - Rundkegelform - Forme ogive bout arrondi
Конусная форма с полусферическим торцом - Konstrukční rádiusový tvar

CODE	USA STYLE	d1 mm	l1 mm	L mm
F0312	SF-11M	3	12	56
F0616	SF-1M	6	16	50
F0616L	SF-1ML6	6	16	163
F0820	-	8	20	65
F1020	SF-3M	10	20	65
F1020L	SF-3ML6	10	20	169
F1125	SF-4M	11	25	70
F1225	SF-5M	12	25	70
F1225L	SF-5ML6	12	25	175
F1625	SF-6M	16	25	70
F2025	SF-7M	20	25	70



Lima rotativa in metallo duro integrale gambo Ø 6 mm

Solid carbide rotary file shank Ø 6 mm

VHM - Rotierfräser Schaft Ø 6 mm - Limes rotatives en carbure monobloc queue Ø 6 mm

Бор-фрезы твердосплавные хвостовик Ø 6 mm - Sk rotační technická frézy se stopkou Ø 6 mm



Forma ogiva a punta - Tree shape pointed end - Spitzbogen - Forme ogive bout pointed
Конусная форма с острым торцом - Špičatý tvar

CODE	USA STYLE	d1 mm	l1 mm	L mm
G0616	SG-1M	6	16	50
G0616L	SG-1ML6	6	16	163
G0820	SG-2M	8	20	65
G1020	SG-3M	10	20	65
G1020L	SG-3ML6	10	20	163
G1219	SG-13M	12	19	65
G1225	SG-5M	12	25	70
G1225L	SG-5ML6	12	25	175
G1625	SG-6M	16	25	70
G2025	SG-7M	20	25	70



Forma a fiamma - Flame shape - Flammen Form - Forme flamme
Свечеобразная форма - Oválny tvar plamen

CODE	USA STYLE	d1 mm	l1 mm	L mm
H0820	SH-2M	8	19	63
H0820L	SH-2ML6	8	19	169
H1232	SH-5M	12	32	77
H1232L	SH-5ML6	12	32	182
H1632	SH-6M	16	36	80
H2041	SH-7M	20	41	85
H06120		6	12	50



Forma conica 90° - 90° cone shape - 90° spitzkegel Form - Forme conique 90°
Коническая форма с углом 90° - Kuželový tvar 90°

CODE	USA STYLE	d1 mm	l1 mm	L mm
K0603	SK-1M	6	3	50
K0804	-	8	4	51
K1005	SK-3M	10	5	52
K1206	SK-5M	12	6	53
K1608	SK-6M	16	8	57
K2010	SK-7M	20	10	58
K2513	SK-9M	25	13	60



Lima rotativa in metallo duro integrale gambo Ø 6 mm

Solid carbide rotary file shank Ø 6 mm

VHM - Rotierfräser Schaft Ø 6 mm - Limes rotatives en carbure monobloc queue Ø 6 mm

Бор-фрезы твердосплавные хвостовик Ø 6 mm - Sk rotační technická fréza se stopkou Ø 6 mm



Forma conica 60° - 60° cone shape - 60° spitzkegel Form - Forme conique 60°
Коническая форма с углом 60° - Kuželový tvar 60°

CODE	USA STYLE	d1 mm	l1 mm	L mm
J0605	SJ-1M	6	5	50
J1006	SJ-3M	10	9	55
J1211	SJ-5M	12	11	58
J1612	SJ-6M	16	14.5	61
J2016	SJ-7M	20	16	65
J2519	SJ-9M	25	24.5	68



Forma conica con punta arrotondata (14°) - 14° taper radius end - 14° rundkegel Form - Forme conique bout arrondi (14°)
Коническая форма с радиусом 14° - Kuželový tvar s rádiusem na konci 14°

CODE	USA STYLE	d1 mm	l1 mm	L mm
L0616	SL-1M	6	16	50
L0616L	SL-1ML6	6	16	166
L0822	SL-2M	8	22	67
L1027	SL-3M	10	27	72
L1027L	SL-3ML6	10	27	177
L1230	SL-4M	12	30	73
L1230L	SL-4ML6	12	30	178
L1633	SL-5M	16	33	75
L2040	SL-7M	20	40	83



Forma conica - Cone shape - Spitzkegel Form - Forme conique
Коническая форма - Kuželový tvar

CODE	USA STYLE	d1 mm	l1 mm	L mm
M0612	SM-1M	6	12	50
M0615	-	6	15	50
M0619	SM-2M	6	19	50
M0625	SM-3M	6	25	50
M1016	SM-4M	10	16	61
M1225	SM-5M	12	25	67
M1625	SM-6M	16	25	70

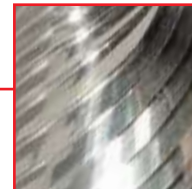


Lima rotativa in metallo duro integrale gambo Ø 6 mm

Solid carbide rotary file shank Ø 6 mm

VHM - Rotierfräser Schaft Ø 6 mm - Limes rotatives en carbure monobloc queue Ø 6 mm

Бор-фрезы твердосплавные хвостовик Ø 6 мм - Sk rotační technická fréza se stopkou Ø 6 mm



Forma cono rovescio - Inverted cone shape - Winkel Form - Forme conique renversee
Развернутая конусная форма - Tvar opačného kužele

CODE	USA STYLE	d1 mm	l1 mm	L mm
N0606	SN-1M	6	8	50
N1010	SN-2M	10	10	53
N1212	SN-4M	12	12	57
N1616	SN-6M	16	19	63
N2020	SN-7M	20	16	60



Assortimento di n° 20 lime rotative gambo Ø 3 mm

Set of n° 20 rotary files shank Ø 3 mm

Ausstellregale mit n° 20 Rotierfräser Shaft Ø 3 mm - Jeux avec n° 20 limes rotatives queue Ø 3 mm

Набор бор-фрез в количестве 20 шт., хвостовик Ø 3 мм - Sada 20ks technických fréz stopka Ø 3 mm



CODE
Standard cut 03

XMD203-3

CODE
Double cut 06

XMD203-6

CODE
Diamond cut 04

XMD203-4

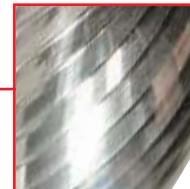


Set completo di n°6 lime rotative gambo Ø 6 mm

Set of n°6 rotary files shank Ø 6 mm

Set mit n°6 Rotierfräser Shaft Ø 6 mm - Set avec 6 limes rotatives queue Ø 6 mm

Набор бор-фрез в количестве 6 шт., хвостовик Ø 6 mm - Sada 6ks technických fréz stopka Ø 6 mm



CODE

XMD206.3 CUT 3 - Standard cut 03

XMD206.4 CUT 4 - Diamond cut 04

XMD206.6 CUT 6 - Double cut 06

Composto da Composed of

B10200	C10200	D10100
E10160	F10200	G10200



Smerigliatrice pneumatica 58.000 giri

Pneumatic grinder machine 58.000 rpm

Pneumatik Schleifmaschine 58.000 rpm - Pneumatique machine à roder 58.000 tours

ПНЕВМАТИЧЕСКАЯ ШЛИФОВАЛЬНАЯ МАШИНКА 58.000 об/мин - Vzduchová bruska 58000 otáček/min

CODE

PV10-54



Pinza sostituibile - Chuck is replaceable - Со сменной державкой

Smerigliatrice pneumatica 60.000 giri

Pneumatic grinder machine 60.000 rpm

Pneumatik Schleifmaschine 60.000 rpm - Pneumatique machine à roder 60.000 tours

ПНЕВМАТИЧЕСКАЯ ШЛИФОВАЛЬНАЯ МАШИНКА 60.000 об/мин - Vzduchová bruska 60000 otáček/min

CODE

GP-260



Pinza fissa - Chuck is fixed - С фиксированной державкой

Smerigliatrice pneumatica 80.000 giri

Pneumatic grinder machine 80.000 rpm

Pneumatik Schleifmaschine 80.000 rpm - Pneumatique machine à roder 80.000 tours

ПНЕВМАТИЧЕСКАЯ ШЛИФОВАЛЬНАЯ МАШИНКА 80.000 об/мин - Vzduchová bruska 80000 otáček/min

CODE

GP-380



Pinza sostituibile - Chuck is replaceable - Со сменной державкой - Vyměnitelné sklíčidlo

Dati tecnici - Specification - Specifikace

CODE	Free speed 90 Psi (rpm)	Air consumption	Air pressure recommend	Ø Hose (ID) (mm)	Dimensions Ø D x L (mm)	Weight (g)	Chuck Ø (mm)
PV10-54	58.000	170LT/1'	6.2 BAR	6.35	16.0X137	140	2.35 - 3.0
GP-260	60.000	170LT/1'	6.2 BAR	6.35	17.5X142	160	3.0
GP-380	80.000	170LT/1'	6.2 BAR	6.35	17.5X142	180	2.35 - 3 - 3.17

Seghe circolari

Slitting Saws

Kreissagen
Scies circulaires
Фрезы отрезные
Prořezávací pilky

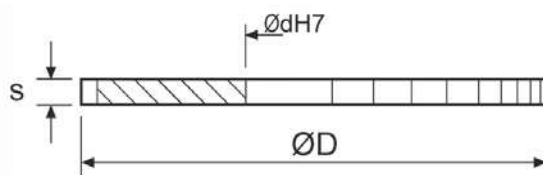


Sega circolare in metallo duro integrale

Solid carbide slitting saw

VHM - Kreissägeblätter - Fraise carbure scie

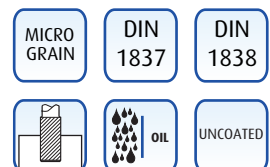
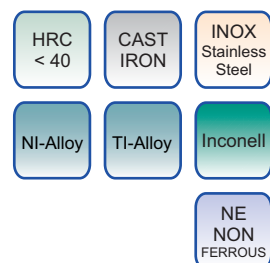
Фрезы отрезные твердосплавные- Sk prořezávací pilky



CODE	Dxd						
SC-SCF S+0,01mm	15x5 Z no.	20x5 Z no.	25x8 Z no.	30x8 Z no.	40x10 Z no.	50x13 Z no.	63x16 Z no.
0.10	-/64	-/80	-/80	-/100	-/128	-/-	-
0.15	-/64	-/80	-/80	-/100	-/128	-/-	-
0.20	20/64	20/80	20/80	30/100	40/128	-/128	-/160
0.25	20/64	20/64	20/80	30/100	40/100	-/128	-/128
0.30	20/64	20/64	20/80	30/80	40/100	-/128	-/128
0.35	-/64	-/64	-/64	-/80	-/100	-/100	-/128
0.40	20/64	20/64	20/64	30/80	40/100	48/100	64/128
0.50	20/48	20/48	20/64	30/80	40/80	48/100	64/128
0.60	20/48	20/48	20/64	30/64	40/80	48/100	48/100
0.70	20/48	20/48	20/48	30/64	40/80	40/80	48/100
0.80	20/40	20/40	20/48	24/64	32/80	40/80	48/100
0.90	20/40	20/40	20/48	24/64	32/64	40/80	48/100
1.00	20/40	20/40	20/48	24/64	32/64	40/80	48/100
1.10	-/40	-/40	-/48	-/48	-/64	-/80	-/80
1.20	20/40	20/40	20/48	24/48	32/64	40/80	40/80
1.30	-/40	-/40	-/40	-/48	-/64	-/64	-/80
1.40	-/40	-/40	-/40	-/48	-/64	-/64	-/80
1.50	20/40	20/40	20/40	24/48	32/64	32/64	40/80
1.60	20/40	20/40	20/40	24/48	32/64	32/64	40/80
1.70	-/40	-/32	-/40	-/48	-/48	-/64	-/80
1.80	20/40	20/32	20/40	24/48	24/64	32/64	40/80
1.90	-/40	-/32	-/40	-/48	-/48	-/64	-/80
2.00	20/40	20/32	20/40	24/48	24/48	32/64	40/80
2.50	20/40	20/32	20/40	24/40	24/48	32/64	32/64
3.00	20/40	20/32	20/32	24/40	24/48	24/48	32/64
3.50	-/24	-/24	-/32	-/40	-/40	-/48	-/64
4.00	20/24	20/24	20/32	24/40	20/40	24/48	32/64
5.00	20/24	20/24	20/32	24/32	20/40	24/48	24/48
6.00	20/24	20/24	20/24	24/32	20/40	20/40	24/48

SC = DIN 1838 taglio grosso / coarse cut

SCF = DIN 1837 taglio fine / fine cut

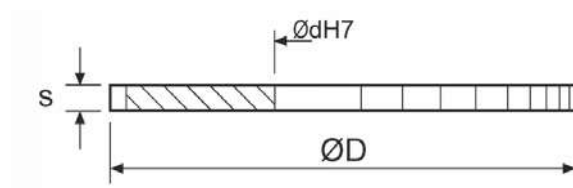


Sega circolare in metallo duro integrale

Solid carbide slitting saw

VHM - Kreissägeblätter - Fraise carbure scie

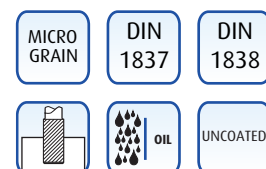
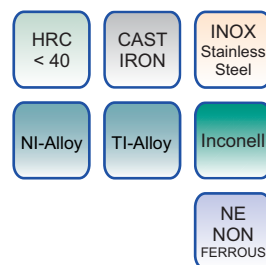
Фрезы отрезные твердосплавные - Sk prořezávací pilky



CODE	Dxd			
SC - SCF S+0,01mm	80x22 Z no.	100x22 Z no.	125x22 Z no.	160x32 Z no.
0.10	-	-	-	-
0.15	-	-	-	-
0.20	-	-	-	-
0.25	-	-	-	-
0.30	-/160	-	-	-
0.35	-/160	-	-	-
0.40	-/160	-	-	-
0.50	-/128	-/160	-	-
0.60	64/128	80/160	-/160	-
0.70	64/128	64/128	-/160	-
0.80	64/128	64/128	80/160	-
0.90	48/100	64/128	80/160	-
1.00	48/100	64/128	80/160	80/160
1.10	-/100	-/128	-/128	-
1.20	48/100	64/128	64/128	80/160
1.30	-/100	-/100	-/128	-
1.40	-/100	-/100	-/128	-
1.50	48/100	48/100	64/128	80/160
1.60	48/100	48/100	64/128	-/160
1.70	-/80	-/100	-/128	-
1.80	40/80	48/100	64/128	-/128
1.90	-/80	-/100	-/128	-
2.00	40/80	48/100	64/128	80/128
2.50	40/80	48/100	48/100	80/128
3.00	40/80	40/80	48/100	64/128
3.50	-/64	-/80	-/100	-
4.00	32/64	40/80	48/100	-/100
5.00	32/64	40/80	40/100	-
6.00	32/64	32/64	40/100	-

SC = DIN 1838 taglio grosso / coarse cut

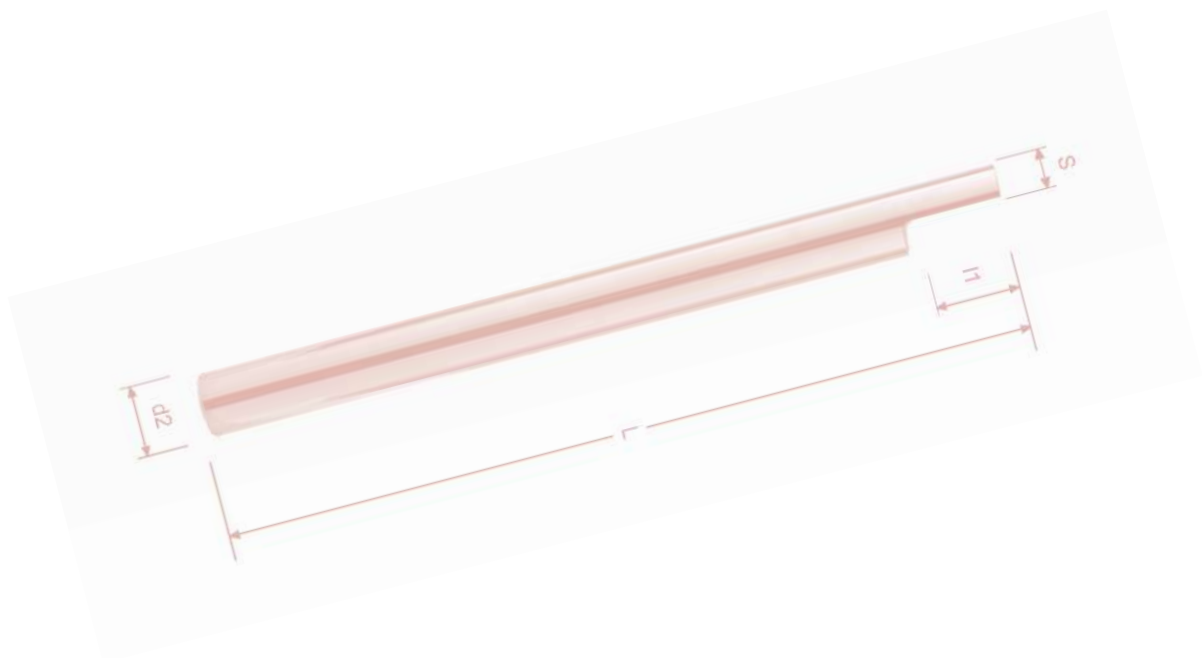
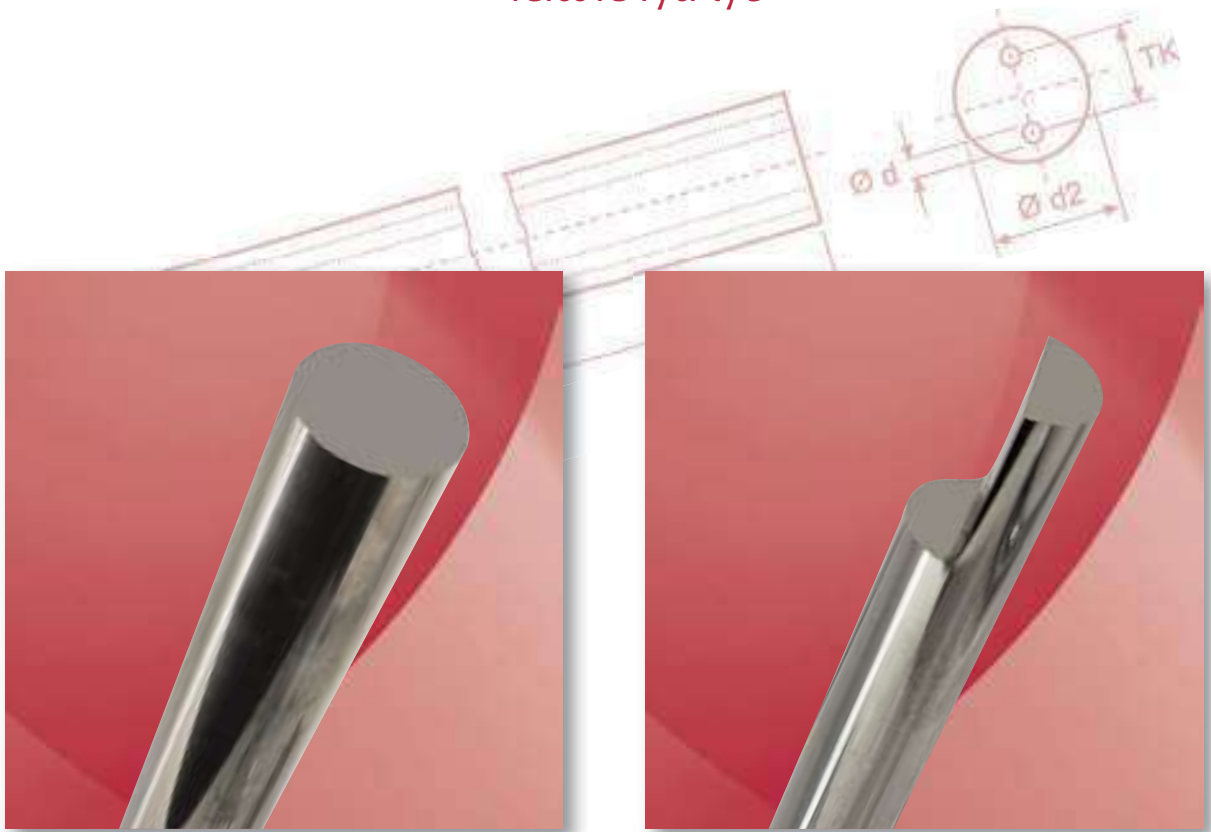
SCF = DIN 1837 taglio fine / fine cut



Cilindretti e bulini

Cylindrical rods-engraving tools

Rundstasse - Gravierstichel
Bareaux / Rond - Fraises à graver
Стержни твердосплавные, гравировальный инструмент
Válcová rycí tyč



Bulino in metallo duro integrale

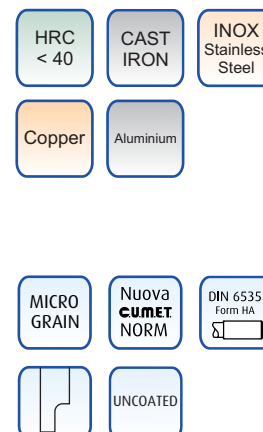
Solid carbide engraving tool

VHM - Gravierstichel - Fraise carbure à graver

Гравировальный инструмент твердосплавный - Sk polotovar roubík



CODE	d2h6 mm	l1 mm	L mm	S ^{+00,5} +0 mm
VBE020040	2	3.0	40	1
VBE020100	2	3.0	100	1
VBE030050	3	4.5	50	1.5
VBE030100	3	4.5	100	1.5
VBE040060	4	6.0	60	2
VBE040100	4	6.0	100	2
VBE050060	5	7.5	60	2.5
VBE050100	5	7.5	100	2.5
VBE060070	6	9.0	70	3
VBE060100	6	9.0	100	3
VBE060150	6	9.0	150	3
VBE080100	8	12.0	100	4
VBE080150	8	12.0	150	4
VBE100080	10	15.0	80	5
VBE100100	10	15.0	100	5
VBE100150	10	15.0	150	5
VBE120100	12	18.0	100	6
VBE120150	12	18.0	150	6
VBE140085	14	21.0	85	7
VBE140100	14	21.0	100	7
VBE140150	14	21.0	150	7
VBE140200	14	21.0	200	7
VBE160100	16	24.0	100	8
VBE160150	16	24.0	150	8
VBE160200	16	24.0	200	8
VBE180100	18	27.0	100	9
VBE180150	18	27.0	150	9
VBE180200	18	27.0	200	9
VBE200100	20	30.0	100	10
VBE200150	20	30.0	150	10
VBE200200	20	30.0	200	10

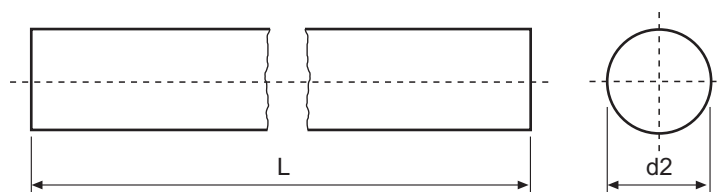


Cilindretto in metallo duro integrale

Solid carbide cylindrical rod

VHM - Rundstäbe - Barreaux carbure

Стержень твердосплавный цилиндрический - Sk válcová tyč



CODE UNGROUND (+0.3mm)	CODE GROUND (h6)	d2 mm	L mm
CGRE010x100	VCE010100	1	100
CGRE020x100	VCE020100	2	100
CGRE030x100	VCE030100	3	100
CGRE040x100	VCE040100	4	100
CGRE050x100	VCE050100	5	100
CGRE060x100	VCE060100	6	100
CGRE070x100	VCE070100	7	100
CGRE080x100	VCE080100	8	100
CGRE090x100	VCE090100	9	100
CGRE100x100	VCE100100	10	100
CGRE110x100	VCE110100	11	100
CGRE120x100	VCE120100	12	100
CGRE130x100	VCE130100	13	100
CGRE140x100	VCE140100	14	100
CGRE150x100	VCE150100	15	100
CGRE160x100	VCE160100	16	100
CGRE170x100	VCE170100	17	100
CGRE180x100	VCE180100	18	100
CGRE190x100	VCE190100	19	100
CGRE200x100	VCE200100	20	100
CGRE220x100	VCE220100	22	100
CGRE240x100	VCE240100	24	100
CGRE250x100	VCE250100	25	100
CGRE260x100	VCE260100	26	100
CGRE280x100	VCE280100	28	100
CGRE300x100	VCE300100	30	100
CGRE320x100	VCE320100	32	100

CODE UNGROUND (+0.3mm)	CODE GROUND (h6)	d2 mm	L mm
CGRE010x310	VCE010310	1.0	310
CGRE015x310	VCE015310	1.5	310
CGRE020x310	VCE020310	2.0	310
CGRE025x310	VCE025310	2.5	310
CGRE030x310	VCE030310	3.0	310
CGRE035x310	VCE035310	3.5	310
CGRE040x310	VCE040310	4.0	310
CGRE045x310	VCE045310	4.5	310
CGRE050x310	VCE050310	5.0	310
CGRE055x310	VCE055310	5.5	310
CGRE060x310	VCE060310	6.0	310
CGRE065x310	VCE065310	6.5	310
CGRE070x310	VCE070310	7.0	310
CGRE075x310	VCE075310	7.5	310
CGRE080x310	VCE080310	8.0	310
CGRE085x310	VCE085310	8.5	310
CGRE090x310	VCE090310	9.0	310
CGRE100x310	VCE100310	10.0	310
CGRE105x310	VCE105310	10.5	310
CGRE110x310	VCE110310	11.0	310
CGRE115x310	VCE115310	11.5	310
CGRE120x310	VCE120310	12.0	310
CGRE125x310	VCE125310	12.5	310
CGRE130x310	VCE130310	13.0	310
CGRE135x310	VCE135310	13.5	310
CGRE140x310	VCE140310	14.0	310
CGRE145x310	VCE145310	14.5	310
CGRE150x310	VCE150310	15.0	310
CGRE155x310	VCE155310	15.5	310
CGRE160x310	VCE160310	16.0	310
CGRE165x310	VCE165310	16.5	310
CGRE170x310	VCE170310	17.0	310
CGRE175x310	VCE175310	17.5	310
CGRE180x310	VCE180310	18.0	310
CGRE185x310	VCE185310	18.5	310
CGRE190x310	VCE190310	19.0	310
CGRE200x310	VCE200310	20.0	310
CGRE220x310	VCE220310	22.0	310
CGRE240x310	VCE240310	24.0	310
CGRE250x310	VCE250310	25.0	310
CGRE260x310	VCE260310	26.0	310
CGRE280x310	VCE280310	28.0	310
CGRE300x310	VCE300310	30.0	310
CGRE320x310	VCE320310	32.0	310

MICRO
GRAIN

6%
CO

10%
CO

Nuova
CUMET
NORM

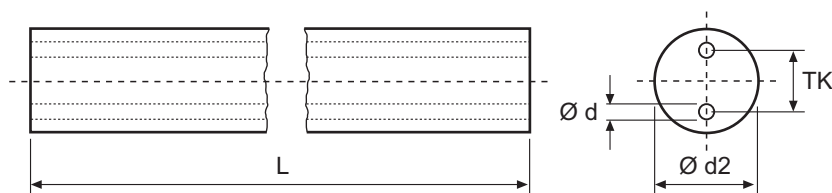


Cilindretto in metallo duro integrale con due fori paralleli

Solid carbide cylindrical rod with 2 parallel holes

VHM - Rundstäbe mit 2 Geraden Kühlkanälen - Barreaux carbure avec 2 trous d'huile droits

Стержень твердосплавный цилиндрический с подачей СОЖ - Sk válcová tyč se 2 paralelními otvory



CODE UNGROUND (+0.3mm)	CODE GROUND (h6)	d2 mm	L mm	TK mm	d mm
CG3FD2050330I2.0	VC3FD2050330I2.0	5	330	2.0	0.9
CG3FD2060330I1.1	VC3FD2060330I1.1	6	330	1.1	0.5
CG3FD2060330I1.7	VC3FD2060330I1.7	6	330	1.7	0.8
CG3FD2060330I2.0	VC3FD2060330I2.0	6	330	2.0	0.9
CG3FD2060330I2.3	VC3FD2060330I2.3	6	330	2.3	0.9
CG3FD2060330I2.4	VC3FD2060330I2.4	6	330	2.4	1.2
CG3FD2060330I3.0	VC3FD2060330I3.0	6	330	3.0	0.9
CG3FD2080330I1.7	VC3FD2080330I1.7	8	330	1.7	0.8
CG3FD2080330I2.0	VC3FD2080330I2.0	8	330	2.0	0.9
CG3FD2080330I2.6	VC3FD2080330I2.6	8	330	2.6	1.2
CG3FD2080330I3.0	VC3FD2080330I3.0	8	330	3.0	1.2
CG3FD2080330I3.5	VC3FD2080330I3.5	8	330	3.5	1.5
CG3FD2080330I4.0	VC3FD2080330I4.0	8	330	4.0	0.9
CG3FD2100330I2.6	VC3FD2100330I2.6	10	330	2.6	1.2
CG3FD2100330I3.5	VC3FD2100330I3.5	10	330	3.5	1.5
CG3FD2100330I4.0	VC3FD2100330I4.0	10	330	4.0	1.5
CG3FD2100330I5.0	VC3FD2100330I5.0	10	330	5.0	1.2
CG3FD2110330I3.5	VC3FD2110330I3.5	11	330	3.5	1.5
CG3FD2120330I3.5	VC3FD2120330I3.5	12	330	3.5	1.5
CG3FD2120330I4.0	VC3FD2120330I4.0	12	330	4.0	1.5
CG3FD2120330I5.0	VC3FD2120330I5.0	12	330	5.0	2.0
CG3FD2120330I6.2	VC3FD2120330I6.2	12	330	6.2	1.5
CG3FD2140330I2.6	VC3FD2140330I2.6	14	330	2.6	0.9
CG3FD2140330I3.5	VC3FD2140330I3.5	14	330	3.5	1.5
CG3FD2140330I5.0	VC3FD2140330I5.0	14	330	5.0	2.0
CG3FD2140330I7.0	VC3FD2140330I7.0	14	330	7.0	1.5
CG3FD2160330I3.5	VC3FD2160330I3.5	16	330	3.5	1.5
CG3FD2160330I5.0	VC3FD2160330I5.0	16	330	5.0	2.0
CG3FD2160330I6.2	VC3FD2160330I6.2	16	330	6.2	2.0
CG3FD2160330I8.0	VC3FD2160330I8.0	16	330	8.0	2.0
CG3FD2180330I5.0	VC3FD2180330I5.0	18	330	5.0	2.0
CG3FD2180330I6.2	VC3FD2180330I6.2	18	330	6.2	2.0
CG3FD2180330I7.0	VC3FD2180330I7.0	18	330	7.0	2.5
CG3FD2180330I9.0	VC3FD2180330I9.0	18	330	9.0	2.0
CG3FD2200330I3.5	VC3FD2200330I3.5	20	330	3.5	1.5
CG3FD2200330I6.2	VC3FD2200330I6.2	20	330	6.2	2.0
CG3FD2200330I7.0	VC3FD2200330I7.0	20	330	7.0	2.5
CG3FD2200330I100	VC3FD2200330I100	20	330	10.0	2.5
CG3FD2220330I7.0	VC3FD2220330I7.0	22	330	7.0	2.0
CG3FD2220330I110	VC3FD2220330I110	22	330	11.0	2.5
CG3FD2240330I6.2	VC3FD2240330I6.2	24	330	6.2	2.0
CG3FD2240330I7.0	VC3FD2240330I7.0	24	330	7.0	2.5
CG3FD2240330I120	VC3FD2240330I120	24	330	12.0	3.0
CG3FD2250330I8.0	VC3FD2250330I8.0	25	330	8.0	2.5
CG3FD2250330I120	VC3FD2250330I120	25	330	12.0	3.0
CG3FD2260330I120	VC3FD2260330I120	26	330	12.0	3.0
CG3FD2260330I130	VC3FD2260330I130	26	330	13.0	3.0
CG3FD2280330I100	VC3FD2280330I100	28	330	10.0	2.0
CG3FD2280330I130	VC3FD2280330I130	28	330	13.0	3.0
CG3FD2300330I130	VC3FD2300330I130	30	330	13.0	3.0
CG3FD2320330I130	VC3FD2320330I130	32	330	13.0	3.0

Nuova
CUMET
NORM

MICRO
GRAIN

6%
CO

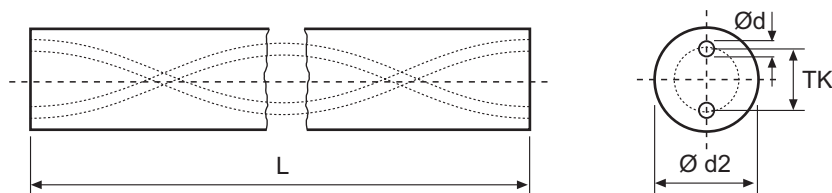


Cilindretto in metallo duro integrale con due fori elicoidali

Solid carbide rod with 2 twisted coolant holes

VHM - Rundstäbe mit 2 Verdrehten Kühlkanälen - Barreaux carbure avec 2 trous hélicoïdaux

Стержень твердосплавный цилиндрический с подачей СОЖ - Sk válcová tyč se 2 chladicími otvory ve spirále



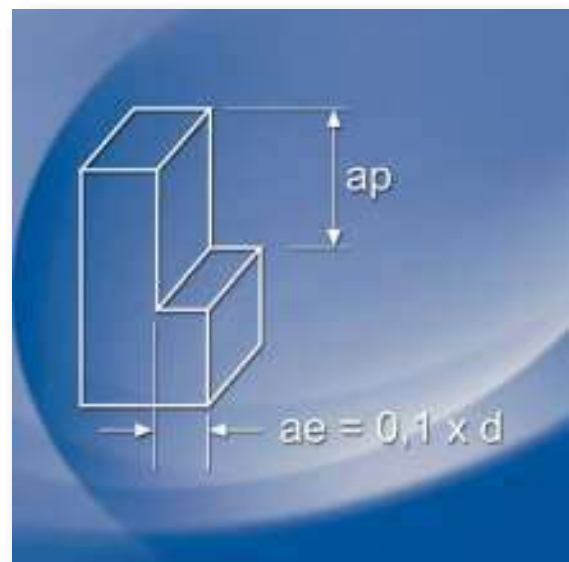
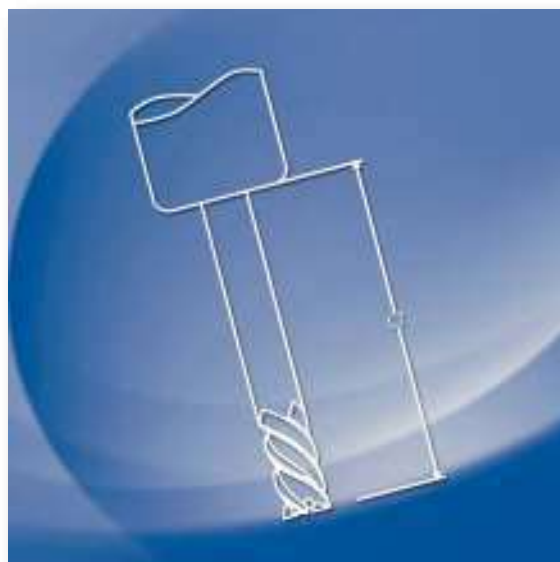
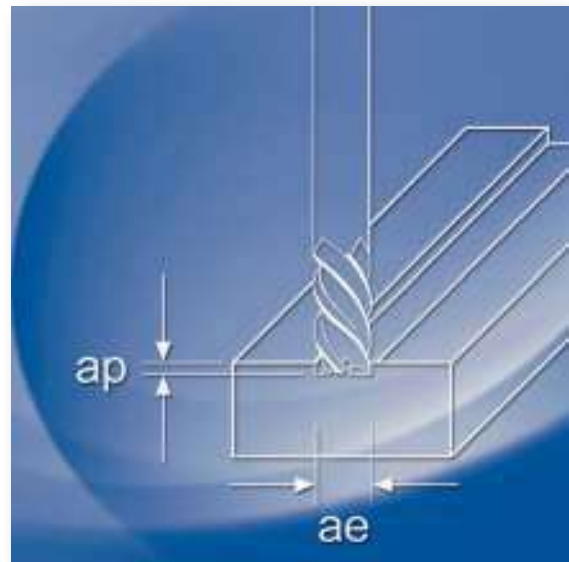
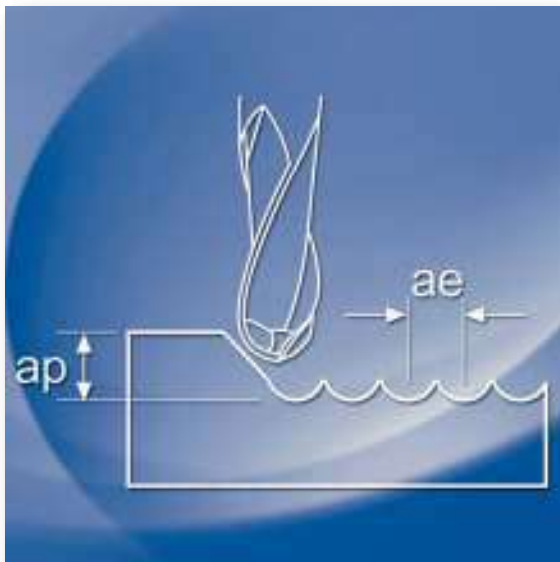
CODE UNGROUND (+0.3mm)	CODE GROUND (h6)	d2 mm	L mm	TK mm	d mm	α°
CG3FE2030330I1.5	VC3FE2030330I1.5	3	330	1.5	0.4	30°
CG3FE2060330I1.9	VC3FE2060330I1.9	6	330	1.9	0.6	30°
CG3FE2060330I2.2	VC3FE2060330I2.2	6	330	2.2	0.8	30°
CG3FE2060330I2.6	VC3FE2060330I2.6	6	330	2.6	0.7	30°
CG3FE2080330I2.7	VC3FE2080330I2.7	8	330	2,7	0,7	30°
CG3FE2080330I3.5	VC3FE2080330I3.5	8	330	3,5	0,9	30°
CG3FE2080330I4.0	VC3FE2080330I4.0	8	330	4,0	1,0	30°
CG3FE2100330I2.7	VC3FE2100330I2.7	10	330	2,7	0,8	30°
CG3FE2100330I3.5	VC3FE2100330I3.5	10	330	3,5	0,8	30°
CG3FE2100330I4.8	VC3FE2100330I4.8	10	330	4.8	1.4	30°
CG3FE2120330I4.2	VC3FE2120330I4.2	12	330	4,2	0,9	30°
CG3FE2120330I5.4	VC3FE2120330I5.4	12	330	5.4	1.5	30°
CG3FE2120330I5.9	VC3FE2120330I5.9	12	330	5.9	1.7	30°
CG3FE2130330I6.5	VC3FE2130330I6.5	13	330	6.5	1.8	30°
CG3FE2140330I4.7	VC3FE2140330I4.7	14	330	4,7	1,0	30°
CG3FE2140330I7.1	VC3FE2140330I7.1	14	330	7.1	1.75	30°
CG3FE2140330I7.2	VC3FE2140330I7.2	14	330	7.1	2,0	30°
CG3FE2150330I7.7	VC3FE2150330I7.7	15	330	7.7	1.75	30°
CG3FE2160330I5.5	VC3FE2160330I5.5	16	330	5,5	1,2	30°
CG3FE2160330I8.3	VC3FE2160330I8.3	16	330	8.3	1.75	30°
CG3FE2160330I8.6	VC3FE2160330I8.6	16	330	8.6	2.5	30°
CG3FE2180330I9.5	VC3FE2180330I9.5	18	330	9.5	2,0	30°
CG3FE2180330I9.7	VC3FE2180330I9.7	18	330	9.7	2.8	30°
CG3FE2190330I101	VC3FE2190330I101	19	330	10.1	2.5	30°
CG3FE2200330I7.1	VC3FE2200330I7.1	20	330	7,1	1,5	30°
CG3FE2200330I104	VC3FE2200330I104	20	330	10.4	2.8	30°
CG3FE2200330I107	VC3FE2200330I107	20	330	10.7	3.2	30°



Velocità di taglio

Cutting speed

Richtwerte
Paramètres
Режимы обработки
Řezná rychlost



Formule

Formulas

Formel - Formules

Формулы

Fz (mm) = Avanzamento per Dente
Feed per tooth
Vorschub pro Zain
Avance par dent
Подача на зуб
Posuv na zub

N (1/min) = Velocità di rotazione
Rotation number
Drehzahl
Frequence de rotation
Частота вращения шпинделя
Otáčky

Vc (m/min) = Velocità di taglio
Cutting speed
Schnittgeschwindigkeit
Vitesse de coupe
Скорость резания
Řezná rychlost

Vf (mm/min) = Velocità di avanzamento
Feed Speed
Vorschubgeschwindigkeit
Vitesse d'avance
Скорость подачи
Rychlost posuvu

Q (cm³/min) = Volume truciolo asportato
Quantity of removed chip
Swarf Volumen
Coupeau volume
Количество снимаемой стружки
Množství odebraného materiálu

$$Fz = \frac{Vf}{Z \times N} \text{ mm}$$

$$N = \frac{Vc \times 1000}{\pi \times \varnothing} \text{ 1/min.}$$

$$Vf = Z \times N \times fz \text{ mm/min.}$$

$$Vc = \frac{\pi \times \varnothing \times N}{1000} \text{ m/min.}$$

$$Q = \frac{a_e \times a_p \times V_f}{1000} \text{ cm}^3/\text{min.}$$

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: Y800 - Y804 - Y800M - Y803M Slot Milling

Material		AL Si<6% - АЛЮМИНИЙ				Copper - МЕДЬ				Plastic - АЛЮМИНИЙ			
Ø	l2	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
0.5	2	90-600	0.009-0.012	1 x d	0.300 x d	60-400	0.007-0.009	1 x d	0.300 x d	60-600	0.009-0.017	1 x d	0.300 x d
	4	80-600	0.008-0.011	1 x d	0.180 x d	55-400	0.006-0.008	1 x d	0.180 x d	55-600	0.008-0.015	1 x d	0.180 x d
	6	70-600	0.007-0.010	1 x d	0.120 x d	50-400	0.004-0.007	1 x d	0.120 x d	50-600	0.008-0.013	1 x d	0.120 x d
0.6	2	90-600	0.014-0.016	1 x d	0.300 x d	70-400	0.014-0.016	1 x d	0.300 x d	70-600	0.018-0.024	1 x d	0.300 x d
	4	90-600	0.013-0.015	1 x d	0.180 x d	60-400	0.013-0.015	1 x d	0.180 x d	60-600	0.016-0.022	1 x d	0.180 x d
	6	90-600	0.013-0.015	1 x d	0.100 x d	60-400	0.013-0.015	1 x d	0.100 x d	60-600	0.016-0.022	1 x d	0.100 x d
0.8	4	90-600	0.014-0.016	1 x d	0.300 x d	70-400	0.014-0.016	1 x d	0.300 x d	90-600	0.018-0.024	1 x d	0.300 x d
	6	90-600	0.013-0.015	1 x d	0.175 x d	60-400	0.013-0.015	1 x d	0.175 x d	90-600	0.016-0.022	1 x d	0.175 x d
	8	90-600	0.013-0.015	1 x d	0.110 x d	60-400	0.013-0.015	1 x d	0.110 x d	90-600	0.016-0.022	1 x d	0.110 x d
1.0	6	150-600	0.018-0.024	1 x d	0.300 x d	100-400	0.018-0.024	1 x d	0.300 x d	100-600	0.020-0.035	1 x d	0.300 x d
	8	140-600	0.016-0.022	1 x d	0.170 x d	90-400	0.016-0.022	1 x d	0.170 x d	90-600	0.018-0.032	1 x d	0.170 x d
	12	130-600	0.016-0.020	1 x d	0.110 x d	80-400	0.014-0.018	1 x d	0.110 x d	80-600	0.018-0.028	1 x d	0.110 x d
1.5	6	190-600	0.018-0.025	1 x d	0.300 x d	120-400	0.018-0.024	1 x d	0.300 x d	120-600	0.020-0.035	1 x d	0.300 x d
	8	180-600	0.017-0.023	1 x d	0.170 x d	120-400	0.017-0.022	1 x d	0.170 x d	110-600	0.018-0.032	1 x d	0.170 x d
	10	170-600	0.017-0.023	1 x d	0.160 x d	110-400	0.016-0.020	1 x d	0.160 x d	100-600	0.018-0.028	1 x d	0.160 x d
2.0	6	190-600	0.025-0.035	1 x d	0.300 x d	120-400	0.020-0.030	1 x d	0.300 x d	120-600	0.020-0.035	1 x d	0.300 x d
	10	180-600	0.025-0.035	1 x d	0.200 x d	110-400	0.018-0.028	1 x d	0.200 x d	110-600	0.020-0.032	1 x d	0.200 x d
3.0	9	200-600	0.020-0.030	1 x d	0.300 x d	100-400	0.020-0.030	1 x d	0.300 x d	150-600	0.020-0.028	1 x d	0.300 x d
4.0	12	200-600	0.030-0.040	1 x d	0.300 x d	100-400	0.020-0.030	1 x d	0.300 x d	150-600	0.030-0.040	1 x d	0.300 x d
5.0	15	200-600	0.040-0.050	1 x d	0.500 x d	100-400	0.030-0.040	1 x d	0.500 x d	150-600	0.040-0.050	1 x d	0.500 x d
6.0	21	200-600	0.050-0.060	1 x d	0.500 x d	100-400	0.040-0.050	1 x d	0.500 x d	150-600	0.050-0.060	1 x d	0.500 x d
8.0	26	200-600	0.060-0.070	1 x d	0.500 x d	100-400	0.050-0.060	1 x d	0.500 x d	150-600	0.060-0.080	1 x d	0.500 x d
10.0	31	200-600	0.070-0.080	1 x d	0.500 x d	100-400	0.070-0.080	1 x d	0.500 x d	150-600	0.080-0.100	1 x d	0.500 x d
12.0	38	200-600	0.090-0.100	1 x d	0.500 x d	100-400	0.080-0.090	1 x d	0.500 x d	150-600	0.100-0.120	1 x d	0.500 x d
16.0	66	200-600	0.120-0.140	1 x d	0.500 x d	100-400	0.100-0.120	1 x d	0.500 x d	150-600	0.120-0.160	1 x d	0.500 x d
20.0	78	200-600	0.150-0.170	1 x d	0.500 x d	100-400	0.130-0.150	1 x d	0.500 x d	150-600	0.160-0.200	1 x d	0.500 x d

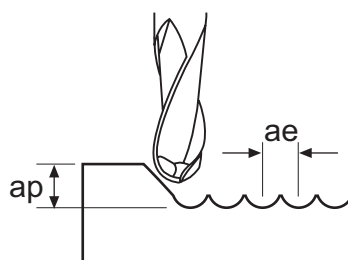
CODE: Y800 - Y804 - Y800M - Y803M Side Milling

Material		AL Si<6% - АЛЮМИНИЙ				Copper - МЕДЬ				Plastic - АЛЮМИНИЙ			
Ø	l2	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
0.5	2	90-700	0.012-0.016	0.2-0.5 x d	1 x d	60-250	0.009-0.012	0.2-0.5 x d	1 x d	60-250	0.009-0.017	0.2-0.5 x d	1 x d
	4	80-700	0.011-0.015	0.2-0.5 x d	1 x d	55-250	0.008-0.011	0.2-0.5 x d	1 x d	55-250	0.008-0.015	0.2-0.5 x d	1 x d
	6	70-700	0.009-0.013	0.2-0.5 x d	1 x d	50-250	0.005-0.009	0.2-0.5 x d	1 x d	50-250	0.008-0.013	0.2-0.5 x d	1 x d
0.6	2	90-700	0.019-0.021	0.2-0.5 x d	1 x d	70-250	0.018-0.020	0.2-0.5 x d	1 x d	70-250	0.018-0.024	0.2-0.5 x d	1 x d
	4	90-700	0.017-0.020	0.2-0.5 x d	1 x d	60-250	0.016-0.019	0.2-0.5 x d	1 x d	60-250	0.016-0.022	0.2-0.5 x d	1 x d
	6	90-700	0.017-0.020	0.2-0.5 x d	1 x d	60-250	0.016-0.019	0.2-0.5 x d	1 x d	60-250	0.016-0.022	0.2-0.5 x d	1 x d
0.8	4	90-700	0.019-0.021	0.2-0.5 x d	1 x d	70-250	0.018-0.020	0.2-0.5 x d	1 x d	70-250	0.018-0.024	0.2-0.5 x d	1 x d
	6	90-700	0.017-0.020	0.2-0.5 x d	1 x d	60-250	0.016-0.019	0.2-0.5 x d	1 x d	60-250	0.016-0.022	0.2-0.5 x d	1 x d
	8	90-700	0.017-0.020	0.2-0.5 x d	1 x d	60-250	0.016-0.019	0.2-0.5 x d	1 x d	60-250	0.016-0.022	0.2-0.5 x d	1 x d
1.0	6	150-700	0.024-0.032	0.2-0.5 x d	1 x d	100-250	0.023-0.030	0.2-0.5 x d	1 x d	100-250	0.020-0.035	0.2-0.5 x d	1 x d
	8	140-700	0.021-0.029	0.2-0.5 x d	1 x d	90-250	0.020-0.028	0.2-0.5 x d	1 x d	90-250	0.018-0.032	0.2-0.5 x d	1 x d
	12	130-700	0.021-0.027	0.2-0.5 x d	1 x d	80-250	0.018-0.023	0.2-0.5 x d	1 x d	80-250	0.018-0.028	0.2-0.5 x d	1 x d
1.5	6	190-700	0.024-0.033	0.2-0.5 x d	1 x d	120-250	0.023-0.030	0.2-0.5 x d	1 x d	120-250	0.020-0.035	0.2-0.5 x d	1 x d
	8	180-700	0.023-0.031	0.2-0.5 x d	1 x d	120-250	0.021-0.028	0.2-0.5 x d	1 x d	120-250	0.018-0.032	0.2-0.5 x d	1 x d
	10	170-700	0.023-0.031	0.2-0.5 x d	1 x d	110-250	0.020-0.025	0.2-0.5 x d	1 x d	110-250	0.018-0.028	0.2-0.5 x d	1 x d
2.0	6	190-700	0.033-0.047	0.2-0.5 x d	1 x d	120-250	0.025-0.038	0.2-0.5 x d	1 x d	120-250	0.020-0.035	0.2-0.5 x d	1 x d
	10	180-700	0.033-0.048	0.2-0.5 x d	1 x d	110-250	0.023-0.035	0.2-0.5 x d	1 x d	110-250	0.020-0.032	0.2-0.5 x d	1 x d
3.0	9	200-700	0.027-0.030	0.2-0.5 x d	1 x d	100-250	0.025-0.038	0.2-0.5 x d	1 x d	100-250	0.020-0.030	0.2-0.5 x d	1 x d
4.0	12	200-700	0.040-0.053	0.2-0.5 x d	1 x d	100-250	0.025-0.038	0.2-0.5 x d	1 x d	100-250	0.030-0.040	0.2-0.5 x d	1 x d
5.0	15	200-700	0.053-0.067	0.2-0.5 x d	1 x d	100-250	0.038-0.050	0.2-0.5 x d	1 x d	100-250	0.040-0.050	0.2-0.5 x d	1 x d
6.0	21	200-700	0.067-0.080	0.2-0.5 x d	1 x d	100-250	0.050-0.063	0.2-0.5 x d	1 x d	100-250	0.050-0.060	0.2-0.5 x d	1 x d
8.0	26	200-700	0.080-0.093	0.2-0.5 x d	1 x d	100-250	0.063-0.075	0.2-0.5 x d	1 x d	100-250	0.060-0.080	0.2-0.5 x d	1 x d
10.0	31	200-700	0.093-0.107	0.2-0.5 x d	1 x d	100-250	0.088-0.100	0.2-0.5 x d	1 x d	100-250	0.080-0.100	0.2-0.5 x d	1 x d
12.0	37	200-700	0.120-0.133	0.2-0.5 x d	1 x d	100-250	0.100-0.113	0.2-0.5 x d	1 x d	100-250	0.100-0.120	0.2-0.5 x d	1 x d
16.0	43	200-700	0.012-0.140	0.2-0.5 x d	1 x d	100-250	0.125-0.150	0.2-0.5 x d	1 x d	100-250	0.120-0.160	0.2-0.5 x d	1 x d
20.0	78	200-700	0.150-0.170	0.2-0.5 x d	1 x d	100-250	0.163-0.188	0.2-0.5 x d	1 x d	100-250	0.160-0.200	0.2-0.5 x d	1 x d

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řezná rychlost



CODE: Y800R High Speed Cutting

Material		AL Si<6% - АЛЮМИНИЙ				Copper - МЕДЬ				Plastic - АЛЮМИНИЙ			
Ø	l2	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
0.5	2	80-600	0.009-0.011	0.150-1.0 x d	0.200 x d	60-400	0.009-0.011	0.10-1.0 x d	0.200 x d	60-600	0.009-0.017	0.10-1.0 x d	0.200 x d
	4	80-600	0.008-0.010	0.150-1.0 x d	0.120 x d	55-400	0.008-0.010	0.10-1.0 x d	0.120 x d	55-600	0.008-0.015	0.10-1.0 x d	0.120 x d
	6	80-600	0.008-0.010	0.150-1.0 x d	0.060 x d	50-400	0.008-0.010	0.10-1.0 x d	0.060 x d	50-600	0.008-0.013	0.10-1.0 x d	0.060 x d
0.6	2	90-600	0.014-0.016	0.150-1.0 x d	0.200 x d	70-400	0.014-0.016	0.10-1.0 x d	0.200 x d	70-600	0.018-0.024	0.10-1.0 x d	0.200 x d
	4	90-600	0.013-0.015	0.150-1.0 x d	0.120 x d	60-400	0.013-0.015	0.10-1.0 x d	0.120 x d	60-600	0.016-0.022	0.10-1.0 x d	0.120 x d
	6	90-600	0.013-0.015	0.150-1.0 x d	0.060 x d	60-400	0.013-0.015	0.10-1.0 x d	0.060 x d	60-600	0.016-0.022	0.10-1.0 x d	0.060 x d
0.8	4	120-600	0.016-0.019	0.150-1.0 x d	0.200 x d	70-400	0.016-0.019	0.10-1.0 x d	0.200 x d	90-600	0.018-0.024	0.10-1.0 x d	0.200 x d
	6	120-600	0.015-0.017	0.150-1.0 x d	0.120 x d	60-400	0.015-0.017	0.10-1.0 x d	0.120 x d	90-600	0.016-0.022	0.10-1.0 x d	0.120 x d
	8	120-600	0.015-0.017	0.150-1.0 x d	0.060 x d	60-400	0.015-0.017	0.10-1.0 x d	0.060 x d	90-600	0.016-0.022	0.10-1.0 x d	0.060 x d
1.0	6	150-600	0.022-0.026	0.150-1.0 x d	0.200 x d	100-400	0.022-0.026	0.10-1.0 x d	0.200 x d	100-600	0.028-0.035	0.10-1.0 x d	0.200 x d
	8	150-600	0.020-0.024	0.150-1.0 x d	0.120 x d	90-400	0.020-0.024	0.10-1.0 x d	0.120 x d	90-600	0.026-0.032	0.10-1.0 x d	0.120 x d
	12	150-600	0.018-0.022	0.150-1.0 x d	0.060 x d	80-400	0.018-0.022	0.10-1.0 x d	0.060 x d	80-600	0.022-0.028	0.10-1.0 x d	0.060 x d
1.5	6	190-600	0.028-0.035	0.150-1.0 x d	0.200 x d	120-400	0.028-0.035	0.10-1.0 x d	0.200 x d	120-600	0.028-0.035	0.10-1.0 x d	0.200 x d
	8	190-600	0.026-0.032	0.150-1.0 x d	0.120 x d	120-400	0.026-0.032	0.10-1.0 x d	0.120 x d	110-600	0.026-0.032	0.10-1.0 x d	0.120 x d
	10	190-600	0.025-0.030	0.150-1.0 x d	0.060 x d	110-400	0.025-0.030	0.10-1.0 x d	0.060 x d	100-600	0.022-0.028	0.10-1.0 x d	0.060 x d
2.0	6	190-600	0.042-0.048	0.150-1.0 x d	0.200 x d	120-400	0.042-0.048	0.10-1.0 x d	0.200 x d	120-600	0.042-0.047	0.10-1.0 x d	0.200 x d
	10	190-600	0.032-0.038	0.150-1.0 x d	0.120 x d	110-400	0.032-0.038	0.10-1.0 x d	0.120 x d	110-600	0.038-0.043	0.10-1.0 x d	0.120 x d
3.0	9	200-600	0.030-0.070	0.150-1.0 x d	0.200 x d	100-400	0.040-0.080	0.10-1.0 x d	0.200 x d	150-600	0.040-0.060	0.10-1.0 x d	0.200 x d
4.0	12	200-600	0.050-0.100	0.150-1.0 x d	0.200 x d	100-400	0.050-0.100	0.10-1.0 x d	0.200 x d	150-600	0.050-0.100	0.10-1.0 x d	0.200 x d
6.0	21	200-600	0.050-0.100	0.150-1.0 x d	0.200 x d	100-400	0.080-0.120	0.10-1.0 x d	0.200 x d	150-600	0.080-0.120	0.10-1.0 x d	0.200 x d
8.0	26	200-600	0.060-0.120	0.150-1.0 x d	0.200 x d	100-400	0.100-0.120	0.10-1.0 x d	0.200 x d	150-600	0.100-0.120	0.10-1.0 x d	0.200 x d
10.0	31	200-600	0.070-0.130	0.150-1.0 x d	0.200 x d	100-400	0.100-0.140	0.10-1.0 x d	0.200 x d	150-600	0.100-0.140	0.10-1.0 x d	0.200 x d
12.0	37	200-600	0.070-0.140	0.150-1.0 x d	0.200 x d	100-400	0.100-0.150	0.10-1.0 x d	0.200 x d	150-600	0.100-0.150	0.10-1.0 x d	0.200 x d
16.0	66	200-600	0.090-0.160	0.150-1.0 x d	0.200 x d	100-400	0.120-0.160	0.10-1.0 x d	0.200 x d	150-600	0.120-0.160	0.10-1.0 x d	0.200 x d
20.0	78	200-600	0.160-0.200	0.150-1.0 x d	0.200 x d	100-400	0.160-0.200	0.10-1.0 x d	0.200 x d	150-600	0.160-0.200	0.10-1.0 x d	0.200 x d

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

205PM	Ø mm	l2 mm	ap mm	Steel HRC<25 СТАЛЬ		Stainless Steel HRC<25-35 НЕРЖАВЕЮЩАЯ СТАЛЬ		Heat Resistant Steel HRC<35-50 ЛЕГИРОВАННАЯ СТАЛЬ		Tempered Steel HRC<50-65 СТАЛЬ	
				Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
205PM001..	0.1	-1	0.02-0.07 x d	16	0.0050	16	0.0048	15	0.0036	13	0.0030
		2	0.02-0.07 x d	16	0.0046	15	0.0045	14	0.0036	12	0.0030
205PM0015..	0.15	-	0.02-0.07 x d	24	0.0050	24	0.0475	23	0.0036	20	0.0030
205PM002..	0.2	-1	0.02-0.07 x d	28	0.0071	25	0.0071	24	0.0053	21	0.0045
		2	0.02-0.07 x d	25	0.0065	23	0.0065	22	0.0053	19	0.0045
205PM003..	0.3	-1	0.02-0.07 x d	38	0.0071	34	0.0071	32	0.0053	28	0.0045
		2-3	0.02-0.07 x d	34	0.0065	31	0.0065	29	0.0053	25	0.0045
205PM004..	0.4	-1	0.02-0.07 x d	40	0.0110	36	0.0110	34	0.0082	30	0.0069
		2	0.02-0.07 x d	40	0.0110	36	0.0110	34	0.0074	30	0.0062
		3-4	0.02-0.07 x d	36	0.0101	33	0.0101	31	0.0074	27	0.0062
		5	0.02-0.07 x d	32	0.0088	29	0.0088	27	0.0060	24	0.0060
205PM005..	0.5	-2	0.02-0.07 x d	50	0.0110	45	0.0110	43	0.0820	38	0.0690
		3-4-5	0.02-0.07 x d	45	0.0101	41	0.0101	38	0.0082	34	0.0069
		6	0.02-0.07 x d	40	0.0088	36	0.0113	34	0.0060	30	0.0060
		8	0.02-0.07 x d	40	0.0076	36	0.0088	34	0.0057	30	0.0051
		10	0.02-0.07 x d	35	0.0060	32	0.0060	30	0.0052	26	0.0040
205PM006..	0.6	-2	0.02-0.07 x d	60	0.0158	54	0.0157	51	0.0117	45	0.0099
		3-4-5-6	0.02-0.07 x d	54	0.0144	49	0.0144	46	0.0117	41	0.0099
		8-10	0.02-0.07 x d	48	0.0126	43	0.0126	41	0.0085	36	0.0085
205PM007..	0.7	-2	0.02-0.07 x d	70	0.0158	63	0.0157	60	0.0117	53	0.0099
		4-6	0.02-0.07 x d	63	0.0144	57	0.0144	54	0.0117	42	0.0099
		8-10	0.02-0.07 x d	56	0.0126	51	0.0126	48	0.0085	42	0.0085
205PM008..	0.8	2-4	0.02-0.07 x d	80	0.0158	72	0.0157	68	0.0117	60	0.0099
		6-8	0.02-0.07 x d	72	0.0144	65	0.0144	61	0.0117	54	0.0099
		10	0.02-0.07 x d	64	0.0126	58	0.0126	55	0.0085	48	0.0085
205PM009..	0.9	-3-5-8	0.02-0.07 x d	81	0.0144	73	0.0144	69	0.0117	61	0.0099
		10	0.02-0.07 x d	72	0.0126	65	0.0126	61	0.0085	54	0.0085
205PM010..	1.0	2-3-4	0.02-0.07 x d	90	0.0235	81	0.0236	77	0.0191	68	0.0162
		5-6-8-10	0.02-0.07 x d	81	0.0216	73	0.0216	69	0.0175	61	0.0148
		12-14	0.02-0.07 x d	72	0.0189	65	0.0189	61	0.0128	54	0.0128
		16-18	0.02-0.07 x d	72	0.0162	65	0.0162	61	0.0122	54	0.0108
		20	0.02-0.07 x d	63	0.0131	57	0.0129	54	0.0096	48	0.0086
205PM011.025S4	1.1	-	0.02-0.07 x d	99	0.0235	90	0.0236	85	0.0191	75	0.0162
205PM012..	1.2	-3-4-5-6	0.02-0.07 x d	96	0.0236	87	0.0236	82	0.0176	72	0.0148
		8-10-12	0.02-0.07 x d	87	0.0216	78	0.0216	74	0.0175	65	0.0148
		14-16	0.02-0.07 x d	77	0.0216	69	0.0216	66	0.0175	58	0.0148
205PM013.04S4	1.3	-	0.02-0.07 x d	91	0.0236	82	0.0236	78	0.0175	69	0.0149
205PM014..	1.4	-4-5-6	0.02-0.07 x d	98	0.0236	89	0.0236	84	0.0175	74	0.0149
		8-10-12	0.02-0.07 x d	89	0.0216	80	0.0216	75	0.0175	66	0.0165
205PM015..	1.5	4-5-6	0.02-0.07 x d	106	0.0236	95	0.0236	90	0.0175	79	0.0149
		8-10-12-14	0.02-0.07 x d	95	0.0216	85	0.0216	81	0.0175	71	0.0148
		16-18-20	0.02-0.07 x d	84	0.0189	76	0.0189	72	0.0128	63	0.0128
205PM016..	1.6	-4-5-6-8	0.02-0.07 x d	104	0.0263	94	0.0263	89	0.0195	78	0.0165
		10-12-14-16	0.02-0.07 x d	94	0.0240	85	0.0240	80	0.0195	71	0.0165
		18-20	0.02-0.07 x d	84	0.0210	75	0.0210	71	0.0142	63	0.0143
205PM017.05S4	1.7	-	0.02-0.07 x d	111	0.0263	100	0.0263	94	0.0195	83	0.0165
205PM018.05S4	1.8	-	0.02-0.07 x d	118	0.0263	106	0.0263	100	0.0195	88	0.0165
205PM019.05S4	1.9	-	0.02-0.07 x d	100	0.0315	90	0.0315	85	0.0234	75	0.0198
205PM020..	2.0	4-6-8-10	0.02-0.07 x d	106	0.0315	95	0.0315	90	0.0234	79	0.0198
		12-14-16-18-20	0.02-0.07 x d	95	0.0288	85	0.0288	81	0.0234	71	0.0198
		22-25-30	0.02-0.07 x d	84	0.0252	76	0.0252	72	0.0171	63	0.0171
205PM025..	2.5	-10-12	0.02-0.07 x d	113	0.0394	102	0.0394	96	0.0292	85	0.0248
		14-16-20	0.02-0.07 x d	102	0.0360	92	0.0360	86	0.0292	76	0.0247
		25	0.02-0.07 x d	89	0.0286	81	0.0287	76	0.0232	67	0.0197
205PM030..	3.0	-6-8-10-12	0.02-0.07 x d	121	0.0394	109	0.0394	102	0.0292	90	0.0247
		14-16-18-20-25-30	0.02-0.07 x d	109	0.0360	98	0.0360	92	0.0293	81	0.0248
		35-40	0.02-0.07 x d	96	0.0360	87	0.0360	82	0.0292	72	0.0247
205PM040..	4.0	-8-10-12-14-16	0.02-0.07 x d	118	0.1000	106	0.0900	100	0.0850	89	0.0640
		18-20-25-30	0.02-0.07 x d	106	0.0900	96	0.0810	90	0.0765	80	0.0640
		35-40	0.02-0.07 x d	96	0.0900	86	0.0810	81	0.0765	72	0.0640
		45-50	0.02-0.07 x d	84	0.0716	76	0.0644	70	0.0619	63	0.0509

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: 200M - 205M

200M 205M	Ø mm	l ₂ mm	r _p mm	ap	Steel HRC<25 СТАЛЬ		Stainless Steel HRC<25-35 НЕРЖАВЕЮЩАЯ СТАЛЬ		Heat Resistant Steel HRC<35-50 ЛЕГИРОВАННАЯ СТАЛЬ		Tempered Steel HRC<50-70 СТАЛЬ	
					Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
205M005.03R005S4	0.5	-	0.05	0.02-0.07 x d	79	0.0090	79	0.0076	63	0.0058	47	0.0063
205M006.01R005S4	0.6	-	0.05	0.02-0.07 x d	94	0.0100	80	0.0088	64	0.0074	49	0.0075
205M007.012R005S4	0.7	-	0.05	0.02-0.07 x d	106	0.0104	79	0.0104	62	0.0093	44	0.0080
205M008.014R005S4	0.8	-	0.05	0.02-0.07 x d	113	0.0111	90	0.0104	70	0.0093	50	0.0080
205M009.015R005S4	0.9	-	0.05	0.02-0.07 x d	127	0.0111	102	0.0104	79	0.0093	57	0.0080
205M010..	1.0	-4	0.1-0.2-0.3	0.02-0.07 x d	102	0.0210	92	0.0210	86	0.0189	76	0.0168
		6	0.1-0.2-0.3	0.02-0.07 x d	82	0.0189	74	0.0189	70	0.0189	62	0.0168
		8	0.1-0.2	0.02-0.07 x d	73	0.0189	66	0.0189	62	0.0189	55	0.0168
		10	0.1-0.2-0.3	0.02-0.07 x d	64	0.0189	58	0.0189	54	0.0189	48	0.0168
		12	0.1	0.02-0.07 x d	57	0.0189	51	0.0189	48	0.0189	43	0.0168
		12	0.2-0.3	0.02-0.07 x d	57	0.0168	51	0.0168	48	0.0147	43	0.0147
205M015..	1.5	-	0.1-0.2 -0.3-0.5	0.02-0.07 x d	117	0.0227	106	0.0226	99	0.0207	88	0.0181
		6-8	0.1-0.2-0.3	0.02-0.07 x d	107	0.0226	96	0.0226	91	0.0226	80	0.0201
		10-12	0.1-0.2-0.3	0.02-0.07 x d	85	0.0227	77	0.0227	73	0.0226	64	0.0201
205M020..	2.0	-6	0.1-0.2 -0.3-0.5	0.02-0.07 x d	131	0.0393	118	0.0393	111	0.0393	98	0.0315
		8-10	0.1-0.2 -0.3-0.5	0.02-0.07 x d	119	0.0393	107	0.0393	101	0.0393	89	0.0315
205M025	2.5	12	0.1-0.2 -0.3-0.5	0.02-0.07 x d	96	0.0354	87	0.0354	82	0.0354	72	0.0314
		16	0.5	0.02-0.07 x d	85	0.0354	77	0.0354	73	0.0354	64	0.0315
		-	0.2-0.3-0.5	0.02-0.07 x d	136	0.0392	122	0.0391	116	0.0391	102	0.0313
205M030..	3.0	-10	0.1-0.2 -0.3-0.5-1	0.02-0.07 x d	136	0.0491	122	0.0492	115	0.0491	102	0.0393
		12-16	0.1-0.2 -0.3-0.5	0.02-0.07 x d	122	0.0491	110	0.0491	104	0.0491	92	0.0393
		20	0.2-0.3-0.5	0.02-0.07 x d	110	0.0491	99	0.0492	93	0.0491	82	0.0393
205M040..	4.0	-10-12 -16	0.1-0.2- 0.3-0.5-1	0.02-0.07 x d	131	0.0668	117	0.0677	111	0.0636	98	0.0561
		20	0.2-0.3-0.5	0.02-0.07 x d	110	0.0668	99	0.0677	93	0.0636	92	0.0561
		25	0.3-0.5	0.02-0.07 x d	100	0.0668	90	0.0677	85	0.0636	82	0.0561
205M05.10R1S6	5.0	-	0.5	0.02-0.07 x d	127	0.0676	115	0.0675	108	0.0638	96	0.0561
205M060..	6.0	-16-20 -25-30	0.1-0.2-0.3 -0.5-1-1.5-2	0.02-0.07 x d	136	0.0674	122	0.0673	115	0.0639	102	0.0565

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: 200RM - 205RM

200RM 205RM	Ø mm	l2 mm	ap mm	Steel HRC<25 СТАЛЬ		Stainless Steel HRC<25-35 НЕРЖАВЕЮЩАЯ СТАЛЬ		Heat Resistant Steel HRC<35-50 ЛЕГИРОВАННАЯ СТАЛЬ		Tempered Steel HRC<50-70 СТАЛЬ	
				Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
205RM001..	0.1	-	0.02-0.08 x d	13-16	0.002-0.0025	12-16	0.0018-0.0025	10-16	0.0015-0.0023	8-16	0.0010-0.0020
		1	0.02-0.08 x d	13-16	0.0014-0.0018	12-16	0.0013-0.0018	10-16	0.0010-0.0016	8-16	0.0007-0.0014
		2	0.02-0.08 x d	13-16	0.0009-0.0011	12-16	0.0008-0.0011	10-16	0.0006-0.0009	8-16	0.0004-0.0008
205RM015..	0.15	-	0.02-0.08 x d	19-24	0.0020-0.0025	17-24	0.0018-0.0025	15-24	0.0015-0.0023	12-24	0.0010-0.0020
205RM002..	0.2	-1	0.02-0.08 x d	25-31	0.0028-0.0035	22-31	0.0025-0.0035	20-31	0.0021-0.0033	15-29	0.0016-0.0030
		2	0.02-0.08 x d	25-31	0.0026-0.0032	22-31	0.0022-0.0031	19-21	0.0019-0.0029	13-25	0.0014-0.0027
205RM003..	0.3	-1	0.02-0.08 x d	38-47	0.0040-0.0050	34-47	0.0036-0.0050	30-47	0.0029-0.0045	22-42	0.0022-0.0043
		2-3	0.02-0.08 x d	38-47	0.0036-0.0045	33-46	0.0032-0.0045	28-43	0.0026-0.0041	20-38	0.0020-0.0038
205RM004..	0.4	-1-2	0.02-0.08 x d	48-60	0.0048-0.0060	39-54	0.0043-0.0060	33-51	0.0035-0.0055	23-45	0.0026-0.0050
		3-4	0.02-0.08 x d	43-54	0.0043-0.0054	35-49	0.0039-0.0054	29-46	0.0032-0.0050	21-41	0.0023-0.0045
		5	0.02-0.08 x d	38-48	0.0041-0.0051	31-43	0.0037-0.0051	26-41	0.0030-0.0047	19-36	0.0022-0.0043
		1-2	0.02-0.08 x d	50-63	0.0080-0.0100	41-57	0.0072-0.0100	34-53	0.0058-0.0090	24-47	0.0047-0.0090
205RM005..	0.5	3-4-5	0.02-0.08 x d	46-57	0.0072-0.0090	37-51	0.0065-0.0090	31-48	0.0052-0.0081	22-42	0.0042-0.0081
		6-8	0.02-0.08 x d	40-50	0.0068-0.0085	32-45	0.0061-0.0085	28-43	0.0049-0.0076	20-38	0.0040-0.0076
		10	0.02-0.08 x d	35-44	0.0059-0.0074	29-40	0.0055-0.0077	24-37	0.0042-0.0066	17-33	0.0033-0.0064
		-2-3	0.02-0.08 x d	60-75	0.0120-0.0150	49-68	0.0108-0.0150	41-64	0.0083-0.0130	30-57	0.0062-0.0120
205RM006..	0.6	4	0.02-0.08 x d	54-68	0.0114-0.0143	44-61	0.0102-0.0142	37-58	0.0079-0.0124	27-51	0.0059-0.0114
		5-6	0.02-0.08 x d	54-68	0.0108-0.0135	44-61	0.0097-0.0135	37-58	0.0075-0.0117	27-51	0.0056-0.0108
		8	0.02-0.08 x d	48-60	0.0102-0.0128	39-54	0.0091-0.0127	33-51	0.0070-0.0110	23-45	0.0053-0.0102
		10	0.02-0.08 x d	42-53	0.0102-0.0128	34-47	0.0092-0.0128	29-45	0.0071-0.0111	21-40	0.0053-0.0102
205RM007..	0.7	-2-3	0.02-0.08 x d	70-88	0.0120-0.0150	57-79	0.0108-0.0150	48-75	0.0083-0.0130	34-66	0.0062-0.0120
		4	0.02-0.08 x d	63-79	0.0114-0.0143	51-71	0.0102-0.0142	43-67	0.0079-0.0124	31-59	0.0059-0.0114
		5-6	0.02-0.08 x d	63-79	0.0108-0.0135	51-71	0.0097-0.0135	43-67	0.0075-0.0117	31-59	0.0056-0.0108
		8	0.02-0.08 x d	56-70	0.0102-0.0128	45-63	0.0091-0.0127	38-60	0.0070-0.0110	28-53	0.0053-0.0102
205RM008..	0.8	10	0.02-0.08 x d	50-62	0.0102-0.0128	40-55	0.0092-0.0128	33-52	0.0071-0.0111	24-46	0.0053-0.0102
		-2-3-4	0.02-0.08 x d	80-100	0.0144-0.0180	65-90	0.0130-0.0180	54-85	0.0102-0.0160	39-75	0.0078-0.0150
		5-6	0.02-0.08 x d	72-90	0.0130-0.0162	58-81	0.0117-0.0162	49-77	0.0092-0.0144	35-68	0.0070-0.0135
		8	0.02-0.08 x d	64-80	0.0130-0.0162	52-72	0.0117-0.0162	44-68	0.0092-0.0144	31-60	0.0070-0.0135
205RM009..	0.9	10	0.02-0.08 x d	64-80	0.0122-0.0153	52-72	0.0110-0.0153	44-68	0.0087-0.0136	31-60	0.0067-0.0128
		-3-4	0.02-0.08 x d	90-113	0.0144-0.0180	73-102	0.0130-0.0180	61-96	0.0102-0.0160	44-85	0.0078-0.0150
		5-6	0.02-0.08 x d	82-102	0.0130-0.0162	66-92	0.0117-0.0162	55-86	0.0092-0.0144	40-76	0.0070-0.0135
		8	0.02-0.08 x d	72-90	0.0130-0.0162	58-81	0.0117-0.0162	49-77	0.0092-0.0144	35-68	0.0070-0.0135
205RM010..	1.0	10	0.02-0.08 x d	72-90	0.0122-0.0153	58-81	0.0110-0.0153	49-77	0.0087-0.0136	35-68	0.0067-0.0128
		-2-3-4-5	0.02-0.08 x d	90-113	0.0200-0.0250	73-102	0.0180-0.0250	61-96	0.0144-0.0225	44-85	0.0109-0.0210
		6-8-10	0.02-0.08 x d	82-102	0.0180-0.0225	66-92	0.0162-0.0225	55-86	0.0129-0.0202	40-76	0.0098-0.0189
		12-14-16	0.02-0.08 x d	72-90	0.0170-0.0213	58-81	0.0153-0.0213	49-77	0.0122-0.0191	35-68	0.0093-0.0178
205RM011..	1.1	18	0.02-0.08 x d	63-79	0.0160-0.0200	51-71	0.0144-0.0200	43-67	0.0115-0.0180	31-59	0.0087-0.0168
		20	0.02-0.08 x d	54-68	0.0160-0.0200	44-61	0.0144-0.0200	37-58	0.0115-0.0180	27-51	0.0087-0.0168
		-	0.02-0.08 x d	99-124	0.0200-0.0250	81-112	0.0180-0.0250	68-106	0.0144-0.0225	48-93	0.0109-0.0210
		-3-4-5	0.02-0.08 x d	98-122	0.0228-0.0285	79-110	0.0205-0.0285	67-104	0.0163-0.0254	48-92	0.0128-0.0247
205RM012..	1.2	6-8-10	0.02-0.08 x d	87-109	0.0208-0.0260	71-98	0.0187-0.0260	59-92	0.0160-0.0250	42-81	0.0114-0.0220
		12-14-16	0.02-0.08 x d	87-109	0.0187-0.0234	71-98	0.0168-0.0234	59-92	0.0144-0.0225	42-81	0.0103-0.0198
		-	0.02-0.08 x d	106-132	0.0228-0.0285	86-119	0.0205-0.0285	72-112	0.0163-0.0254	51-99	0.0128-0.0247
205RM013..	1.3	-4-5	0.02-0.08 x d	102-127	0.0240-0.0300	80-111	0.0216-0.0300	68-106	0.0173-0.0270	46-88	0.0135-0.0260
		6-8	0.02-0.08 x d	89-111	0.0240-0.0300	72-100	0.0216-0.0300	60-94	0.0173-0.0270	43-83	0.0135-0.0260
		10-12	0.02-0.08 x d	89-111	0.0216-0.0270	72-100	0.0194-0.0270	60-94	0.0156-0.0243	43-83	0.0122-0.0234
		-4-5-6	0.02-0.08 x d	106-132	0.0264-0.0330	86-119	0.0238-0.0330	72-112	0.0192-0.0300	51-99	0.0140-0.0270
205RM015..	1.5	8-10-12	0.02-0.08 x d	95-119	0.0238-0.0297	77-107	0.0214-0.0297	65-101	0.0173-0.0270	46-89	0.0126-0.0243
		14-16-18-20	0.02-0.08 x d	85-106	0.0225-0.0281	68-95	0.0202-0.0281	58-90	0.0163-0.0255	41-79	0.0119-0.0229
		-4-5-6-8	0.02-0.08 x d	105-131	0.0280-0.0350	85-118	0.0252-0.0350	71-111	0.0198-0.0310	51-98	0.0156-0.0300
205RM016..	1.6	10-12-14-16	0.02-0.08 x d	94-118	0.0252-0.0315	76-106	0.0227-0.0315	64-100	0.0179-0.0279	46-88	0.0140-0.0270
		18-20	0.02-0.08 x d	83-104	0.0238-0.0298	68-94	0.0215-0.0298	57-89	0.0169-0.0264	41-78	0.0133-0.0255
		-	0.02-0.08 x d	111-139	0.0320-0.0400	90-125	0.0288-0.0400	76-118	0.0224-0.0350	54-104	0.0172-0.0330
205RM017..	1.7	-	0.02-0.08 x d	111-139	0.0320-0.0400	90-125	0.0288-0.0400	76-118	0.0224-0.0350	54-104	0.0172-0.0330
205RM018..	1.8	-	0.02-0.08 x d	118-147	0.0320-0.0400	95-132	0.0288-0.0400	80-125	0.0224-0.0350	57-110	0.0172-0.0330
205RM019..	1.9	-	0.02-0.08 x d	124-155	0.0320-0.0400	101-140	0.0288-0.0400	84-132	0.0224-0.0350	60-116	0.0172-0.0330
205RM020..	2.0	-4	0.02-0.08 x d	106-132	0.0400-0.0500	86-119	0.0360-0.0500	72-112	0.0288-0.0450	51-99	0.0224-0.0430
		6-8	0.02-0.08 x d	106-132	0.0360-0.0450	86-119	0.0324-0.0450	72-112	0.0256-0.0400	51-99	0.0198-0.0380
		10-12-14	0.02-0.08 x d	106-132	0.0320-0.0400	86-119	0.0288-0.0400	72-112	0.0207-0.0324	51-99	0.0177-0.0340
		16-18-20	0.02-0.08 x d	95-119	0.0288-0.0360	77-107	0.0259-0.0360	65-101	0.0207-0.0324	46-89	0.0159-0.0306
		22	0.02-0.08 x d	90-112	0.0272-0.0340	73-101	0.0245-0.0340	61-95	0.0196-0.0306	44-84	0.0150-0.0289
		25-30	0.02-0.08 x d	85-106	0.0272-0.0340	68-95	0.0245-0.0340	58-90	0.0196-0.0306	41-79	0.0150-0.0289
205RM022..	2.2	-	0.02-0.08 x d	116-145	0.0400-0.0500	94-131	0.0360-0.0500	79-123	0.0288-0.0450	57-109	0.0224-0.0430
205RM025..	2.5	-10	0.02-0.08 x d	121-151	0.0465-0.0581	98-136	0.0418-0.0581	80-125	0.0344-0.0537	57-110	0.0238-0.0457
		12-14-16	0.02-0.08 x d	106-133	0.0525-0.0656	86-120	0.0472-0.0656	70-110	0.0388-0.0606	50-97	0.0268-0.0516
		20-25	0.02-0.08 x d	101-126	0.0453-0.0566	81-113	0.0408-0.0566	67-104	0.0355-0.0523	47-91	0.0230-0.0442

Parametri di taglio

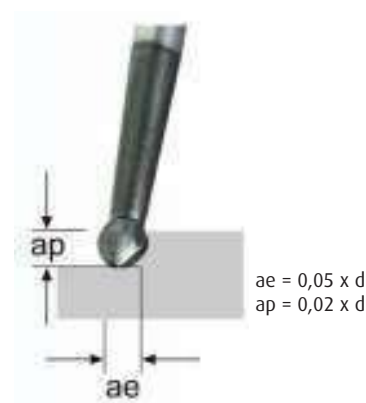
Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

200RM 205RM	Ø mm	l2 mm	ap mm	Steel HRC<25 СТАЛЬ		Stainless Steel HRC<25-35 НЕРЖАВЕЮЩАЯ СТАЛЬ		Heat Resistant Steel HRC<35-50 ЛЕГИРОВАННАЯ СТАЛЬ		Tempered Steel HRC<50-70 СТАЛЬ	
				Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
205RM030..	3.0	-6-8-10-12	0.02-0.08 x d	121-151	0.0600-0.0750	98-136	0.0540-0.0750	82-128	0.0429-0.0670	59-113	0.0328-0.0630
		14-16	0.02-0.08 x d	121-151	0.0540-0.0675	98-136	0.0486-0.0675	82-128	0.0386-0.0603	59-113	0.0295-0.0567
		18-20-25-30	0.02-0.08 x d	109-136	0.0540-0.0675	88-122	0.0486-0.0675	74-115	0.0386-0.0603	53-102	0.0295-0.0567
		35	0.02-0.08 x d	97-121	0.0510-0.0638	78-109	0.0459-0.0638	65-102	0.0364-0.0569	47-90	0.0278-0.0535
		40	0.02-0.08 x d	89-111	0.0486-0.0607	71-99	0.0434-0.0603	54-85	0.0338-0.0528	37-72	0.0256-0.0493
205RM040..	4.0	-	0.02-0.08 x d	115-144	0.08000-0.1000	94-130	0.0720-0.1000	79-123	0.0576-0.0900	56-108	0.0442-0.0850
		8-10-12-14 -16-18-20	0.02-0.08 x d	115-144	0.0800-0.1000	94-130	0.0720-0.1000	79-123	0.0576-0.0900	56-108	0.0442-0.0850
		25-30-35-40	0.02-0.08 x d	104-130	0.0720-0.0900	84-117	0.0648-0.0900	71-111	0.0518-0.0810	51-98	0.0398-0.0765
		45-50	0.02-0.08 x d	93-116	0.0680-0.0850	75-104	0.0612-0.0850	63-98	0.0490-0.0765	45-87	0.0375-0.0722

CODE: 200RB STANDARD CUTTING SPEED

MATERIAL	Aluminium Cast Iron Non Alloy Steels АЛЮМИНИЙ-ЧУГУН ЛЕГИРОВАННАЯ СТАЛЬ		Alloy Steels Heat Resistant Steel ЛЕГИРОВАННАЯ СТАЛЬ			
	< 170 HB		HRC 30 - HRC 40		< HRC 65	
HARDNESS	< 170 HB		HRC 30 - HRC 40		< HRC 65	
Ø	n	Vf	n	Vf	n	Vf
2 - 3	34000	2700	32000	2500	11500	900
4	25000	2200	24000	2100	8000	700
6	16800	1800	15800	1700	6000	600
8	13000	1700	11900	1500	4000	500
10	10000	1400	9800	1300	3600	500
12	8800	1300	7900	1200	2900	400



CODE: 400RB STANDARD CUTTING SPEED

MATERIAL	Aluminium Cast Iron Non Alloy Steels АЛЮМИНИЙ-ЧУГУН ЛЕГИРОВАННАЯ СТАЛЬ		Alloy Steels Heat Resistant Steel ЛЕГИРОВАННАЯ СТАЛЬ			
	< 170 HB		HRC 30 - HRC 40		< HRC 65	
HARDNESS	< 170 HB		HRC 30 - HRC 40		< HRC 65	
Ø	n	Vf	n	Vf	n	Vf
-	-	-	-	-	-	-
-	-	-	-	-	-	-
6	16800	3800	15900	3400	5800	1200
8	13000	3600	11800	2900	4400	1000
10	10000	2900	10000	2400	3300	900
12	8900	2700	7900	2400	3000	900

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

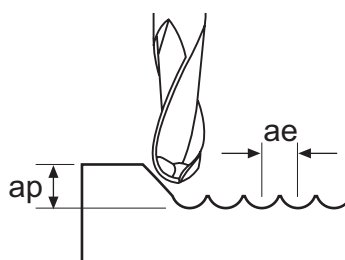
For finishing:

$a_e < 0,02 - 0,03 \times d$

$a_p < 0,8 \times d$

$V_c = 1,2 \times V_c$ (Parameter List)

$F_z = 0,7 \times V_c$ (Parameter List)



CODE: 200SR - 200SRT - 200R - 200RT - 200RLT - 300CR - 300R - 300RT - 300RLT - 400R - 400RT - 400RLT
ROUGHING - STANDARD CUTTING SPEED

MATERIAL	Steel											
HARDNESS	< 170 HB - СТАЛЬ				< 50 HRC - СТАЛЬ				< 60 HRC - СТАЛЬ			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	140	0.016	0.03 x d	0.03 x d	120	0.016	0.03 x d	0.03 x d	70	0.014	0.03 x d	0.03 x d
4	140	0.032	0.03 x d	0.03 x d	120	0.032	0.03 x d	0.03 x d	70	0.028	0.03 x d	0.03 x d
6	140	0.132	0.03 x d	0.03 x d	120	0.032	0.03 x d	0.03 x d	70	0.028	0.03 x d	0.03 x d
8	140	0.064	0.03 x d	0.03 x d	120	0.064	0.03 x d	0.03 x d	70	0.056	0.03 x d	0.03 x d
10	140	0.064	0.03 x d	0.03 x d	120	0.064	0.03 x d	0.03 x d	70	0.056	0.03 x d	0.03 x d
12 - 18	140	0.096	0.03 x d	0.03 x d	120	0.096	0.03 x d	0.03 x d	70	0.084	0.03 x d	0.03 x d
20 - 25	140	0.160	0.03 x d	0.03 x d	120	0.160	0.03 x d	0.03 x d	70	0.140	0.03 x d	0.03 x d

CODE: 200SR - 200SRT - 200R - 200RT - 200RL - 200RLT - 300CR - 300R - 300RT - 300RLT - 400R - 400RT - 400RLT

MATERIAL	Copper - МЕДЬ				Titanium - ТИТАН				Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ			
HARDNESS												
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	350	0.020	0.03 x d	0.03 x d	90	0.014	0.03 x d	0.03 x d	80	0.015	0.03 x d	0.03 x d
4	350	0.040	0.03 x d	0.03 x d	90	0.028	0.03 x d	0.03 x d	80	0.030	0.03 x d	0.03 x d
6	350	0.040	0.03 x d	0.03 x d	90	0.028	0.03 x d	0.03 x d	80	0.030	0.03 x d	0.03 x d
8	350	0.080	0.03 x d	0.03 x d	90	0.057	0.03 x d	0.03 x d	80	0.060	0.03 x d	0.03 x d
10	350	0.080	0.03 x d	0.03 x d	90	0.057	0.03 x d	0.03 x d	80	0.060	0.03 x d	0.03 x d
12 - 18	350	0.120	0.03 x d	0.03 x d	90	0.085	0.03 x d	0.03 x d	80	0.090	0.03 x d	0.03 x d
20 - 25	350	0.200	0.03 x d	0.03 x d	90	0.142	0.03 x d	0.03 x d	80	0.150	0.03 x d	0.03 x d

CODE: 200SR - 200SRT - 200R - 200RT - 200RL - 200RLT - 300CR - 300R - 300RT - 300RLT - 400R - 400RT - 400RLT

MATERIAL	Super Alloy - СУПЕР СПЛАВ				Cast Iron - ЧУГУН							
HARDNESS					Lamellair - ЛАМЕЛАР				Nodulaire - ЧУГУН			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	40	0.015	0.03 x d	0.03 x d	130	0.019	0.03 x d	0.03 x d	120	0.015	0.03 x d	0.03 x d
4	40	0.030	0.03 x d	0.03 x d	130	0.038	0.03 x d	0.03 x d	120	0.030	0.03 x d	0.03 x d
6	40	0.030	0.03 x d	0.03 x d	130	0.038	0.03 x d	0.03 x d	120	0.030	0.03 x d	0.03 x d
8	40	0.060	0.03 x d	0.03 x d	130	0.076	0.03 x d	0.03 x d	120	0.060	0.03 x d	0.03 x d
10	40	0.060	0.03 x d	0.03 x d	130	0.076	0.03 x d	0.03 x d	120	0.060	0.03 x d	0.03 x d
12 - 18	40	0.090	0.03 x d	0.03 x d	130	0.114	0.03 x d	0.03 x d	120	0.090	0.03 x d	0.03 x d
20 - 25	40	0.150	0.03 x d	0.03 x d	130	0.190	0.03 x d	0.03 x d	120	0.150	0.03 x d	0.03 x d

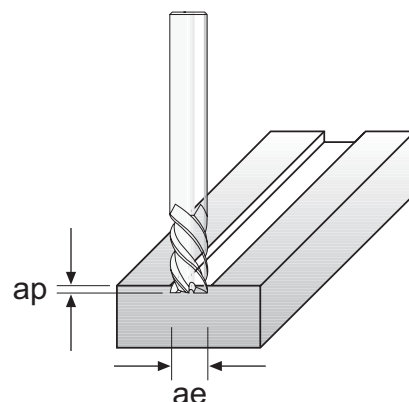
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

Code: Y200R ROUGHING - HIGH SPEED CUTTING

MATERIAL	Steel - СТАЛЬ							
HARDNESS	< 170 HB				< HRC 50			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	180	0.015	1 x d	0.096 x d	165	0.014	1 x d	0.046 x d
4	180	0.029	1 x d	0.096 x d	165	0.027	1 x d	0.046 x d
5	180	0.029	1 x d	0.096 x d	165	0.025	1 x d	0.046 x d
6	180	0.029	1 x d	0.096 x d	165	0.055	1 x d	0.046 x d
8	180	0.060	1 x d	0.096 x d	165	0.055	1 x d	0.046 x d
10	180	0.060	1 x d	0.096 x d	165	0.083	1 x d	0.046 x d
12 - 16	180	0.092	1 x d	0.096 x d	165	0.083	1 x d	0.046 x d



MATERIAL	Steel - СТАЛЬ							
HARDNESS	HRC 48-56				< HRC 65			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	160	0.014	1 x d	0.044 x d	75	0.010	1 x d	0.028 x d
4	160	0.027	1 x d	0.044 x d	75	0.020	1 x d	0.028 x d
5	160	0.027	1 x d	0.044 x d	75	0.020	1 x d	0.028 x d
6	160	0.027	1 x d	0.044 x d	75	0.020	1 x d	0.028 x d
8	160	0.055	1 x d	0.044 x d	75	0.043	1 x d	0.028 x d
10	160	0.055	1 x d	0.044 x d	75	0.043	1 x d	0.028 x d
12 - 16	160	0.083	1 x d	0.044 x d	75	0.065	1 x d	0.028 x d

MATERIAL	Cast Iron - ЧУГУН				Titanium - ТИТАН			
HARDNESS								
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	150	0.014	1 x d	0.042 x d	85	0.010	1 x d	0.030 x d
4	150	0.028	1 x d	0.042 x d	85	0.021	1 x d	0.030 x d
5	150	0.028	1 x d	0.042 x d	85	0.021	1 x d	0.030 x d
6	150	0.028	1 x d	0.042 x d	85	0.021	1 x d	0.030 x d
8	150	0.058	1 x d	0.042 x d	85	0.042	1 x d	0.030 x d
10	150	0.058	1 x d	0.042 x d	85	0.042	1 x d	0.030 x d
12 - 16	150	0.084	1 x d	0.042 x d	85	0.063	1 x d	0.030 x d

MATERIAL	Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ				Super Alloy - СУПЕР СПЛАВ			
HARDNESS								
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	85	0.011	1 x d	0.040 x d	25	0.009	1 x d	0.030 x d
4	85	0.022	1 x d	0.040 x d	25	0.018	1 x d	0.030 x d
5	85	0.022	1 x d	0.040 x d	25	0.018	1 x d	0.030 x d
6	85	0.022	1 x d	0.040 x d	25	0.018	1 x d	0.030 x d
8	85	0.044	1 x d	0.040 x d	25	0.034	1 x d	0.030 x d
10	85	0.044	1 x d	0.040 x d	25	0.034	1 x d	0.030 x d
12 - 16	85	0.065	1 x d	0.040 x d	25	0.054	1 x d	0.030 x d

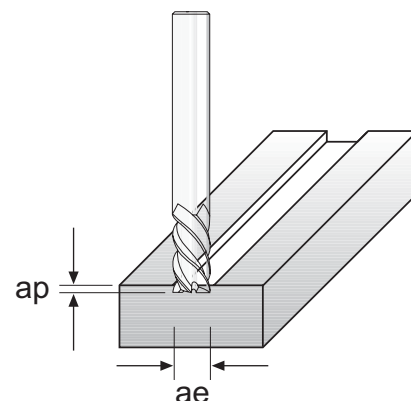
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: Y200R FINISHING - HIGH SPEED CUTTING

MATERIAL	Steel - СТАЛЬ							
HARDNESS	< 170 HB				< HRC 50			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	270	0.016	1 x d	0.032 x d	210	0.015	1 x d	0.020 x d
4	270	0.032	1 x d	0.032 x d	210	0.032	1 x d	0.020 x d
5	270	0.032	1 x d	0.032 x d	210	0.032	1 x d	0.020 x d
6	270	0.032	1 x d	0.032 x d	210	0.032	1 x d	0.020 x d
8	270	0.065	1 x d	0.032 x d	210	0.065	1 x d	0.020 x d
10	270	0.065	1 x d	0.032 x d	210	0.065	1 x d	0.020 x d
12 - 16	270	0.095	1 x d	0.032 x d	210	0.097	1 x d	0.020 x d



MATERIAL	Steel - СТАЛЬ							
HARDNESS	HRC 48-56				< HRC 65			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	160	0.014	1 x d	0.044 x d	85	0.012	1 x d	0.010 x d
4	160	0.014	1 x d	0.044 x d	85	0.012	1 x d	0.010 x d
5	160	0.027	1 x d	0.044 x d	85	0.023	1 x d	0.010 x d
6	160	0.027	1 x d	0.044 x d	85	0.023	1 x d	0.010 x d
8	160	0.027	1 x d	0.044 x d	85	0.049	1 x d	0.010 x d
10	160	0.055	1 x d	0.044 x d	85	0.049	1 x d	0.010 x d
12 - 16	160	0.055	1 x d	0.044 x d	85	0.075	1 x d	0.010 x d

MATERIAL	Cast Iron - ЧУГУН				Titanium - ТИТАН			
HARDNESS								
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	175	0.015	1 x d	0.020 x d	95	0.012	1 x d	0.010 x d
4	175	0.015	1 x d	0.020 x d	95	0.024	1 x d	0.010 x d
5	175	0.031	1 x d	0.020 x d	95	0.024	1 x d	0.010 x d
6	175	0.031	1 x d	0.020 x d	95	0.024	1 x d	0.010 x d
8	175	0.031	1 x d	0.020 x d	95	0.048	1 x d	0.010 x d
10	175	0.062	1 x d	0.020 x d	95	0.048	1 x d	0.010 x d
12 - 16	175	0.062	1 x d	0.020 x d	95	0.072	1 x d	0.010 x d

MATERIAL	Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ				Super Alloy - СУПЕР СПЛАВ			
HARDNESS								
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	110	0.013	1 x d	0.010 x d	30	0.011	1 x d	0.010 x d
4	110	0.025	1 x d	0.010 x d	30	0.021	1 x d	0.010 x d
5	110	0.025	1 x d	0.010 x d	30	0.021	1 x d	0.010 x d
6	110	0.025	1 x d	0.010 x d	30	0.021	1 x d	0.010 x d
8	110	0.051	1 x d	0.010 x d	30	0.039	1 x d	0.010 x d
10	110	0.051	1 x d	0.010 x d	30	0.039	1 x d	0.010 x d
12 - 16	110	0.075	1 x d	0.010 x d	30	0.063	1 x d	0.010 x d

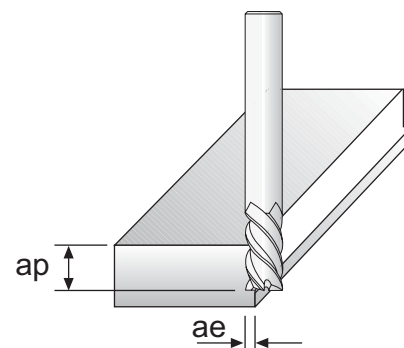
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: Y200R ROUGHING - HIGH SPEED CUTTING

MATERIAL	Steel - СТАЛЬ							
HARDNESS	< 170 HB				< HRC 50			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	310	0.024	0.046 x d	1.120 x d	285	0.022	0.035 x d	0.820 x d
4	310	0.048	0.046 x d	1.120 x d	285	0.044	0.035 x d	0.820 x d
5	310	0.048	0.046 x d	1.120 x d	285	0.044	0.035 x d	0.820 x d
6	310	0.048	0.046 x d	1.120 x d	285	0.044	0.035 x d	0.820 x d
8	310	0.097	0.046 x d	1.120 x d	285	0.089	0.035 x d	0.820 x d
10	310	0.097	0.046 x d	1.120 x d	285	0.089	0.035 x d	0.820 x d
12 - 16	310	0.145	0.046 x d	1.120 x d	285	0.134	0.035 x d	0.820 x d



MATERIAL	Steel - СТАЛЬ							
HARDNESS	HRC 48-56				< HRC 65			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	275	0.021	0.033 x d	0.820 x d	125	0.015	0.028 x d	0.750 x d
4	275	0.042	0.033 x d	0.820 x d	125	0.030	0.028 x d	0.750 x d
5	275	0.042	0.033 x d	0.820 x d	125	0.030	0.028 x d	0.750 x d
6	275	0.042	0.033 x d	0.820 x d	125	0.030	0.028 x d	0.750 x d
8	275	0.085	0.033 x d	0.820 x d	125	0.065	0.028 x d	0.750 x d
10	275	0.085	0.033 x d	0.820 x d	125	0.065	0.028 x d	0.750 x d
12 - 16	275	0.128	0.033 x d	0.820 x d	125	0.100	0.028 x d	0.750 x d

MATERIAL	Cast Iron - ЧУГУН				Titanium - ТИТАН			
HARDNESS								
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	250	0.021	0.021 x d	0.850 x d	140	0.017	0.020 x d	0.750 x d
4	250	0.043	0.021 x d	0.850 x d	140	0.035	0.020 x d	0.750 x d
5	250	0.043	0.021 x d	0.850 x d	140	0.035	0.020 x d	0.750 x d
6	250	0.043	0.021 x d	0.850 x d	140	0.035	0.020 x d	0.750 x d
8	250	0.088	0.021 x d	0.850 x d	140	0.070	0.020 x d	0.750 x d
10	250	0.088	0.021 x d	0.850 x d	140	0.070	0.020 x d	0.750 x d
12 - 16	250	0.129	0.021 x d	0.850 x d	140	0.104	0.020 x d	0.750 x d

MATERIAL	Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ				Super Alloy - СУПЕР СПЛАВ			
HARDNESS								
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	140	0.018	0.020 x d	0.830 x d	40	0.015	0.020 x d	0.520 x d
4	140	0.036	0.020 x d	0.830 x d	40	0.030	0.020 x d	0.520 x d
5	140	0.036	0.020 x d	0.830 x d	40	0.030	0.020 x d	0.520 x d
6	140	0.036	0.020 x d	0.830 x d	40	0.030	0.020 x d	0.520 x d
8	140	0.073	0.020 x d	0.830 x d	40	0.056	0.020 x d	0.520 x d
10	140	0.073	0.020 x d	0.830 x d	40	0.056	0.020 x d	0.520 x d
12 - 16	140	0.108	0.020 x d	0.830 x d	40	0.090	0.020 x d	0.520 x d

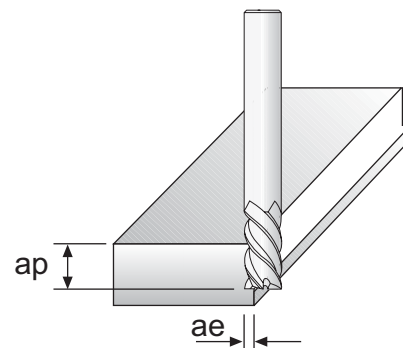
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: Y200R FINISHING - HIGH SPEED CUTTING

MATERIAL	Steel - СТАЛЬ							
HARDNESS	< 170 HB				< HRC 50			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	415	0.025	0.030 x d	0.850 x d	355	0.024	0.020 x d	0.650 x d
4	415	0.050	0.030 x d	0.850 x d	355	0.050	0.020 x d	0.650 x d
5	415	0.050	0.030 x d	0.850 x d	355	0.050	0.020 x d	0.650 x d
6	415	0.050	0.030 x d	0.850 x d	355	0.050	0.020 x d	0.650 x d
8	415	0.100	0.030 x d	0.850 x d	355	0.099	0.020 x d	0.650 x d
10	415	0.100	0.030 x d	0.850 x d	355	0.099	0.020 x d	0.650 x d
12 - 16	415	0.150	0.030 x d	0.850 x d	355	0.149	0.020 x d	0.650 x d



MATERIAL	Steel - СТАЛЬ							
HARDNESS	HRC 48-56				< HRC 65			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	340	0.022	0.020 x d	0.650 x d	140	0.018	0.010 x d	0.450 x d
4	340	0.045	0.020 x d	0.650 x d	140	0.035	0.010 x d	0.450 x d
5	340	0.045	0.020 x d	0.650 x d	140	0.035	0.010 x d	0.450 x d
6	340	0.045	0.020 x d	0.650 x d	140	0.035	0.010 x d	0.450 x d
8	340	0.090	0.020 x d	0.650 x d	140	0.075	0.010 x d	0.450 x d
10	340	0.090	0.020 x d	0.650 x d	140	0.075	0.010 x d	0.450 x d
12 - 16	340	0.135	0.020 x d	0.650 x d	140	0.115	0.010 x d	0.450 x d

MATERIAL	Cast Iron - ЧУГУН				Titanium - ТИТАН			
HARDNESS								
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	285	0.023	0.010 x d	0.640 x d	160	0.020	0.010 x d	0.430 x d
4	285	0.047	0.010 x d	0.640 x d	160	0.040	0.010 x d	0.430 x d
5	285	0.047	0.010 x d	0.640 x d	160	0.040	0.010 x d	0.430 x d
6	285	0.047	0.010 x d	0.640 x d	160	0.040	0.010 x d	0.430 x d
8	285	0.095	0.010 x d	0.640 x d	160	0.080	0.010 x d	0.430 x d
10	285	0.095	0.010 x d	0.640 x d	160	0.080	0.010 x d	0.430 x d
12 - 16	285	0.140	0.010 x d	0.640 x d	160	0.120	0.010 x d	0.430 x d

MATERIAL	Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ				Super Alloy - СУПЕР СПЛАВ			
HARDNESS								
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	180	0.021	0.010 x d	0.580 x d	60	0.018	0.010 x d	0.350 x d
4	180	0.042	0.010 x d	0.580 x d	60	0.035	0.010 x d	0.350 x d
5	180	0.042	0.010 x d	0.580 x d	60	0.035	0.010 x d	0.350 x d
6	180	0.042	0.010 x d	0.580 x d	60	0.035	0.010 x d	0.350 x d
8	180	0.085	0.010 x d	0.580 x d	60	0.065	0.010 x d	0.350 x d
10	180	0.085	0.010 x d	0.580 x d	60	0.065	0.010 x d	0.350 x d
12 - 16	180	0.125	0.010 x d	0.580 x d	60	0.105	0.010 x d	0.350 x d

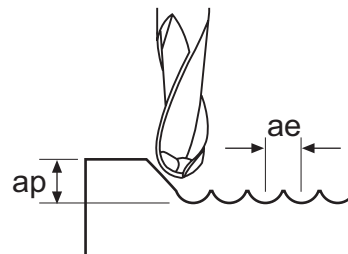
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: 200DRJ - 200DJ ROUGHING

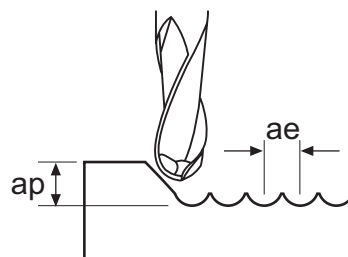
MATERIAL	Steel - СТАЛЬ							
HARDNESS	< HRC 48				< HRC 55			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1	150-250	0.02-0.04	0.100 x d	0.100 x d	100-180	0.02-0.03	0.100 x d	0.100 x d
2 - 3	150-250	0.04-0.07	0.100 x d	0.100 x d	100-180	0.03-0.06	0.100 x d	0.100 x d
4 - 6	150-250	0.08-0.11	0.100 x d	0.100 x d	100-180	0.07-0.10	0.100 x d	0.100 x d
8 - 10	150-250	0.11-0.14	0.100 x d	0.100 x d	100-180	0.10-0.13	0.100 x d	0.100 x d
12	150-250	0.12-0.15	0.100 x d	0.100 x d	100-180	0.12-0.14	0.100 x d	0.100 x d
16	150-250	0.14-0.16	0.100 x d	0.100 x d	100-180	0.14-0.16	0.100 x d	0.100 x d
20	150-250	0.17-0.20	0.100 x d	0.100 x d	100-180	0.16-0.18	0.100 x d	0.100 x d



MATERIAL	Steel - СТАЛЬ								Cast Iron - ЧУГУН			
HARDNESS	< HRC 60				< HRC 65							
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
1	80-120	0.02-0.03	0.060 x d	0.060 x d	70-100	0.02-0.03	0.060 x d	0.060 x d	150-300	0.02-0.04	0.200 x d	0.200 x d
2 - 3	80-120	0.03-0.05	0.060 x d	0.060 x d	70-100	0.03-0.05	0.060 x d	0.060 x d	150-300	0.04-0.07	0.200 x d	0.200 x d
4 - 6	80-120	0.07-0.08	0.060 x d	0.060 x d	70-100	0.07-0.08	0.060 x d	0.060 x d	150-300	0.08-0.11	0.200 x d	0.200 x d
8 - 10	80-120	0.09-0.11	0.060 x d	0.060 x d	70-100	0.09-0.11	0.060 x d	0.060 x d	150-300	0.11-0.14	0.200 x d	0.200 x d
12	80-120	0.09-0.11	0.060 x d	0.060 x d	70-100	0.09-0.11	0.060 x d	0.060 x d	150-300	0.12-0.15	0.200 x d	0.200 x d
15	80-120	0.10-0.13	0.060 x d	0.060 x d	70-100	0.10-0.13	0.060 x d	0.060 x d	150-300	0.14-0.16	0.200 x d	0.200 x d
20	80-120	0.12-0.15	0.060 x d	0.060 x d	70-100	0.12-0.15	0.060 x d	0.060 x d	150-300	0.17-0.20	0.200 x d	0.200 x d

CODE: 200DRJ - 200DJ FINISHING

MATERIAL	Steel - СТАЛЬ							
HARDNESS	< HRC 48				< HRC 55			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1	200-300	0.02-0.03	0.03-0.05	0.03-0.05	150-200	0.02-0.03	0.03-0.05	0.03-0.05
2 - 3	200-300	0.02-0.03	0.07-0.10	0.07-0.10	150-200	0.02-0.03	0.07-0.10	0.07-0.10
4 - 6	200-300	0.05-0.06	0.10-0.15	0.10-0.15	150-200	0.05-0.06	0.10-0.15	0.10-0.15
8 - 10	200-300	0.06-0.07	0.15-0.20	0.15-0.20	150-200	0.06-0.07	0.15-0.20	0.15-0.20
12	200-300	0.07-0.08	0.20-0.24	0.20-0.24	150-200	0.07-0.08	0.20-0.24	0.20-0.24
16	200-300	0.08-0.10	0.24-0.28	0.24-0.28	150-200	0.08-0.09	0.24-0.28	0.24-0.28
20	200-300	0.10-0.12	0.28-0.32	0.28-0.32	150-200	0.09-0.10	0.28-0.32	0.28-0.32



MATERIAL	Steel - СТАЛЬ								Cast Iron - ЧУГУН			
HARDNESS	< HRC 60				< HRC 65							
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
1	100-130	0.01-0.02	0.03-0.05	0.03-0.05	80-120	0.01-0.02	0.03-0.05	0.03-0.05	200-300	0.02-0.03	0.100 x d	0.100 x d
2 - 3	100-130	0.01-0.03	0.07-0.10	0.07-0.10	80-120	0.01-0.03	0.07-0.10	0.07-0.10	200-300	0.02-0.03	0.100 x d	0.100 x d
4 - 6	100-130	0.03-0.05	0.10-0.15	0.10-0.15	80-120	0.03-0.05	0.10-0.15	0.10-0.15	200-300	0.05-0.06	0.100 x d	0.100 x d
8 - 10	100-130	0.05-0.07	0.15-0.20	0.15-0.20	80-120	0.05-0.07	0.15-0.20	0.15-0.20	200-300	0.06-0.07	0.100 x d	0.100 x d
12	100-130	0.06-0.07	0.20-0.24	0.20-0.24	80-120	0.06-0.07	0.20-0.24	0.20-0.24	200-300	0.07-0.08	0.100 x d	0.100 x d
15	100-130	0.07-0.08	0.24-0.28	0.24-0.28	80-120	0.07-0.08	0.24-0.28	0.24-0.28	200-300	0.08-0.10	0.100 x d	0.100 x d
20	100-130	0.08-0.10	0.28-0.32	0.28-0.32	80-120	0.08-0.10	0.28-0.32	0.28-0.32	200-300	0.10-0.12	0.100 x d	0.100 x d

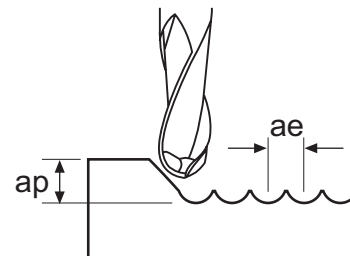
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řezná rychlost

CODE: 200SRJ - 200SRJL - 400SRJ ROUGHING - HIGH SPEED CUTTING

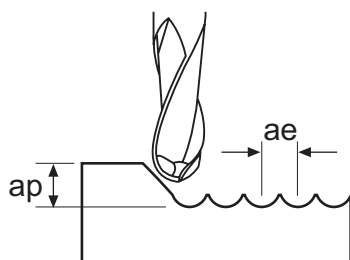
MATERIAL	Steel - СТАЛЬ							
HARDNESS	< 170 HB				< HRC 50			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	240	0.045	0.400 x d	0.100 x d	225	0.040	0.300 x d	0.080 x d
4 - 6	240	0.080	0.400 x d	0.100 x d	225	0.070	0.300 x d	0.080 x d
8 - 10	240	0.160	0.400 x d	0.100 x d	225	0.130	0.300 x d	0.080 x d
12 - 16	240	0.220	0.400 x d	0.100 x d	225	0.200	0.300 x d	0.080 x d
20	240	0.300	0.400 x d	0.100 x d	225	0.260	0.300 x d	0.080 x d



MATERIAL	Steel - СТАЛЬ				Cast Iron - ЧУГУН				Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ			
HARDNESS	< HRC 48 - 60											
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	215	0.035	0.250 x d	0.060 x d	200	0.035	0.300 x d	0.080 x d	110	0.019	0.150 x d	0.080 x d
4 - 6	215	0.060	0.250 x d	0.060 x d	200	0.060	0.300 x d	0.080 x d	110	0.039	0.150 x d	0.080 x d
8 - 10	215	0.120	0.250 x d	0.060 x d	200	0.120	0.300 x d	0.080 x d	110	0.077	0.150 x d	0.080 x d
12 - 16	215	0.170	0.250 x d	0.060 x d	200	0.170	0.300 x d	0.080 x d	110	0.114	0.150 x d	0.080 x d
20	215	0.220	0.250 x d	0.060 x d	200	0.220	0.300 x d	0.080 x d	110	0.192	0.150 x d	0.080 x d

CODE: 200SRJ - 400SRJ FINISHING - HIGH SPEED CUTTING

MATERIAL	Steel - СТАЛЬ							
HARDNESS	< 170 HB				< HRC 50			
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	500	0.028	0.010 x d	0.020 x d	390	0.026	0.020 x d	0.010 x d
4 - 6	500	0.055	0.010 x d	0.020 x d	390	0.055	0.020 x d	0.010 x d
8 - 10	500	0.110	0.010 x d	0.020 x d	390	0.109	0.020 x d	0.010 x d
12 - 16	500	0.165	0.010 x d	0.020 x d	390	0.164	0.020 x d	0.010 x d
20	500	0.220	0.010 x d	0.020 x d	390	0.218	0.020 x d	0.010 x d



MATERIAL	Steel - СТАЛЬ				Cast Iron - ЧУГУН				Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ			
HARDNESS	< HRC 48 - 60											
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
1 - 3	375	0.024	0.010 x d	0.020 x d	325	0.025	0.020 x d	0.020 x d	215	0.022	0.010 x d	0.020 x d
4 - 6	375	0.050	0.010 x d	0.020 x d	325	0.025	0.020 x d	0.020 x d	215	0.045	0.010 x d	0.020 x d
8 - 10	375	0.099	0.010 x d	0.020 x d	325	0.105	0.020 x d	0.020 x d	215	0.090	0.010 x d	0.020 x d
12 - 16	375	0.149	0.010 x d	0.020 x d	325	0.154	0.020 x d	0.020 x d	215	0.133	0.010 x d	0.020 x d
20	375	0.198	0.010 x d	0.020 x d	325	0.209	0.020 x d	0.020 x d	215	0.223	0.010 x d	0.020 x d

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: 300NRJ MINIMUM CONDITION

Ø	< 20 HRC		20 - 30 HRC		30 - 40 HRC	
	VC m/min	200	VC m/min	200	VC m/min	200
	RPM (min.-1)	vf (m/min.)	RPM (min.-1)	vf (m/min.)	RPM (min.-1)	vf (m/min.)
3	21.000	3.80	21.000	3.10	21.000	3.10
4	16.000	3.70	16.000	3.50	16.000	3.50
5	13.000	4.00	13.000	3.80	13.000	3.80
6	11.000	4.10	11.000	4.00	11.000	4.00
8	8.000	4.00	8.000	3.90	8.000	3.90
10	6.400	3.80	6.400	3.80	6.400	3.80
12	5.300	3.70	5.300	3.60	5.300	3.60

Ø	40 - 50 HRC		50 - 60 HRC		< 72 HRC	
	VC m/min	200	VC m/min	200	VC m/min	200
	RPM (min.-1)	vf (m/min.)	RPM (min.-1)	vf (m/min.)	RPM (min.-1)	vf (m/min.)
3	21.000	3.00	21.000	2.30	21.000	1.50
4	16.000	3.40	16.000	2.60	16.000	1.72
5	13.000	3.70	13.000	2.75	13.000	1.83
6	11.000	3.80	11.000	2.90	11.000	1.91
8	8.000	3.70	8.000	2.80	8.000	1.86
10	6.400	3.70	6.400	2.80	6.400	1.86
12	5.300	3.40	5.300	2.60	5.300	1.72

Cutting depth: d x 0.05

CODE: 300NRJ MAXIMUM CONDITION

Ø	< 20 HRC		20 - 30 HRC		30 - 40 HRC	
	VC m/min	300	VC m/min	300	VC m/min	300
	RPM (min.-1)	vf (m/min.)	RPM (min.-1)	vf (m/min.)	RPM (min.-1)	vf (m/min.)
3	32.000	4.90	32.000	4.70	32.000	4.70
4	24.000	5.50	24.000	5.30	24.000	5.30
5	19.000	5.50	19.000	5.70	19.000	5.70
6	16.000	6.20	16.000	5.90	16.000	5.90
8	12.000	6.00	12.000	5.80	12.000	5.80
10	9.500	5.90	9.500	5.70	9.500	5.70
12	8.000	5.50	8.000	5.30	8.000	5.30

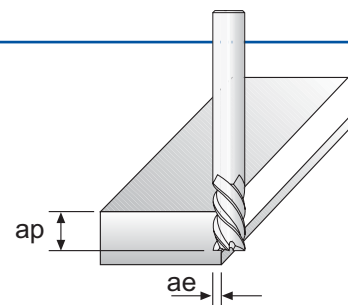
Ø	40 - 50 HRC		50 - 60 HRC		< 72 HRC	
	VC m/min	300	VC m/min	300	VC m/min	300
	RPM (min.-1)	vf (m/min.)	RPM (min.-1)	vf (m/min.)	RPM (min.-1)	vf (m/min.)
3	32.000	4.50	32.000	3.40	32.000	2.10
4	24.000	5.10	24.000	3.80	24.000	2.40
5	19.000	5.50	19.000	4.10	19.000	2.60
6	16.000	5.70	16.000	4.30	16.000	2.70
8	12.000	5.50	12.000	4.10	12.000	2.60
10	9.500	5.50	9.500	4.10	9.500	2.60
12	8.000	5.10	8.000	3.80	8.000	2.45

Cutting depth: d x 0.05

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost



CODE: Y300R ROUGHING - HIGH SPEED CUTTING

MATERIAL	Steel - СТАЛЬ								Cast Iron - ЧУГУН			
HARDNESS	< 170 HB				< HRC 45							
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
3	310	0.024	0.046 x d	1.120 x d	285	0.022	0.035 x d	0.820 x d	250	0.021	0.021 x d	0.850 x d
4	310	0.048	0.046 x d	1.120 x d	285	0.044	0.035 x d	0.820 x d	250	0.043	0.021 x d	0.850 x d
6	310	0.048	0.046 x d	1.120 x d	285	0.044	0.035 x d	0.820 x d	250	0.043	0.021 x d	0.850 x d
8	310	0.097	0.046 x d	1.120 x d	285	0.089	0.035 x d	0.820 x d	250	0.088	0.021 x d	0.850 x d
10	310	0.097	0.046 x d	1.120 x d	285	0.089	0.035 x d	0.820 x d	250	0.088	0.021 x d	0.850 x d
12	310	0.145	0.046 x d	1.120 x d	285	0.134	0.035 x d	0.820 x d	250	0.129	0.021 x d	0.850 x d

MATERIAL	Titanium - ТИТАН				Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ				Super Alloy - СУПЕР СПЛАВ			
HARDNESS												
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
3	140	0.017	0.020 x d	0.750 x d	140	0.018	0.020 x d	0.830 x d	40	0.015	0.020 x d	0.520 x d
4	140	0.035	0.020 x d	0.750 x d	140	0.036	0.020 x d	0.830 x d	40	0.030	0.020 x d	0.520 x d
6	140	0.035	0.020 x d	0.750 x d	140	0.036	0.020 x d	0.830 x d	40	0.030	0.020 x d	0.520 x d
8	140	0.070	0.020 x d	0.750 x d	140	0.073	0.020 x d	0.830 x d	40	0.056	0.020 x d	0.520 x d
10	140	0.070	0.020 x d	0.750 x d	140	0.073	0.020 x d	0.830 x d	40	0.056	0.020 x d	0.520 x d
12	140	0.104	0.020 x d	0.750 x d	140	0.108	0.020 x d	0.830 x d	40	0.090	0.020 x d	0.520 x d

CODE: Y300R FINISHING - HIGH SPEED CUTTING

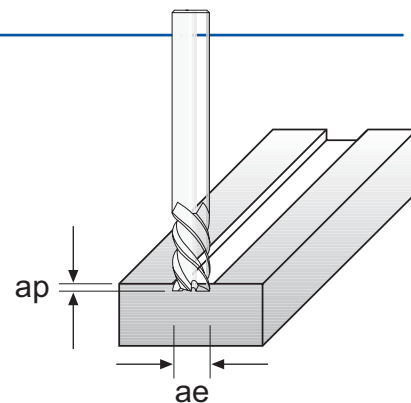
MATERIAL	Steel - СТАЛЬ								Cast Iron - ЧУГУН			
HARDNESS	< 170 HB				< HRC 45							
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
3	415	0.025	0.030 x d	0.850 x d	355	0.024	0.020 x d	0.650 x d	285	0.023	0.010 x d	0.640 x d
4	415	0.050	0.030 x d	0.850 x d	355	0.050	0.020 x d	0.650 x d	285	0.047	0.010 x d	0.640 x d
6	415	0.050	0.030 x d	0.850 x d	355	0.050	0.020 x d	0.650 x d	285	0.047	0.010 x d	0.640 x d
8	415	0.100	0.030 x d	0.850 x d	355	0.099	0.020 x d	0.650 x d	285	0.095	0.010 x d	0.640 x d
10	415	0.100	0.030 x d	0.850 x d	355	0.099	0.020 x d	0.650 x d	285	0.095	0.010 x d	0.640 x d
12	415	0.150	0.030 x d	0.850 x d	355	0.149	0.020 x d	0.650 x d	285	0.140	0.010 x d	0.640 x d

MATERIAL	Titanium - ТИТАН				Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ				Super Alloy - СУПЕР СПЛАВ			
HARDNESS												
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
3	160	0.020	0.010 x d	0.430 x d	180	0.021	0.010 x d	0.580 x d	60	0.018	0.010 x d	0.350 x d
4	160	0.040	0.010 x d	0.430 x d	180	0.042	0.010 x d	0.580 x d	60	0.035	0.010 x d	0.350 x d
6	160	0.040	0.010 x d	0.430 x d	180	0.042	0.010 x d	0.580 x d	60	0.035	0.010 x d	0.350 x d
8	160	0.080	0.010 x d	0.430 x d	180	0.085	0.010 x d	0.580 x d	60	0.065	0.010 x d	0.350 x d
10	160	0.080	0.010 x d	0.430 x d	180	0.085	0.010 x d	0.580 x d	60	0.065	0.010 x d	0.350 x d
12	160	0.120	0.010 x d	0.430 x d	180	0.125	0.010 x d	0.580 x d	60	0.105	0.010 x d	0.350 x d

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost



CODE: Y300R ROUGHING - HIGH SPEED CUTTING

MATERIAL	Steel - СТАЛЬ								Cast Iron - ЧУГУН			
HARDNESS	< 170 HB				< HRC 45							
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
3	180	0.015	1 x d	0.096 x d	165	0.014	1 x d	0.046 x d	150	0.014	1 x d	0.042 x d
4	180	0.029	1 x d	0.096 x d	165	0.027	1 x d	0.046 x d	150	0.028	1 x d	0.042 x d
6	180	0.029	1 x d	0.096 x d	165	0.055	1 x d	0.046 x d	150	0.028	1 x d	0.042 x d
8	180	0.060	1 x d	0.096 x d	165	0.055	1 x d	0.046 x d	150	0.058	1 x d	0.042 x d
10	180	0.060	1 x d	0.096 x d	165	0.083	1 x d	0.046 x d	150	0.058	1 x d	0.042 x d
12	180	0.092	1 x d	0.096 x d	165	0.083	1 x d	0.046 x d	150	0.084	1 x d	0.042 x d

MATERIAL	Titanium - ТИТАН				Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ				Super Alloy - СУПЕР СПЛАВ			
HARDNESS												
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
3	85	0.010	1 x d	0.030 x d	85	0.011	1 x d	0.040 x d	25	0.009	1 x d	0.030 x d
4	85	0.021	1 x d	0.030 x d	85	0.022	1 x d	0.040 x d	25	0.018	1 x d	0.030 x d
6	85	0.021	1 x d	0.030 x d	85	0.022	1 x d	0.040 x d	25	0.018	1 x d	0.030 x d
8	85	0.042	1 x d	0.030 x d	85	0.044	1 x d	0.040 x d	25	0.034	1 x d	0.030 x d
10	85	0.042	1 x d	0.030 x d	85	0.044	1 x d	0.040 x d	25	0.034	1 x d	0.030 x d
12	85	0.063	1 x d	0.030 x d	85	0.065	1 x d	0.040 x d	25	0.054	1 x d	0.030 x d

CODE: Y300R FINISHING - HIGH SPEED CUTTING

MATERIAL	Steel - СТАЛЬ								Cast Iron - ЧУГУН			
HARDNESS	< 170 HB				< HRC 45							
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
3	270	0.016	1 x d	0.032 x d	210	0.015	1 x d	0.020 x d	175	0.015	1 x d	0.020 x d
4	270	0.032	1 x d	0.032 x d	210	0.032	1 x d	0.020 x d	175	0.031	1 x d	0.020 x d
6	270	0.032	1 x d	0.032 x d	210	0.032	1 x d	0.020 x d	175	0.031	1 x d	0.020 x d
8	270	0.065	1 x d	0.032 x d	210	0.065	1 x d	0.020 x d	175	0.062	1 x d	0.020 x d
10	270	0.065	1 x d	0.032 x d	210	0.065	1 x d	0.020 x d	175	0.062	1 x d	0.020 x d
12	270	0.095	1 x d	0.032 x d	210	0.097	1 x d	0.020 x d	175	0.091	1 x d	0.020 x d

MATERIAL	Titanium - ТИТАН				Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ				Super Alloy - СУПЕР СПЛАВ			
HARDNESS												
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
3	95	0.012	1 x d	0.010 x d	110	0.013	1 x d	0.010 x d	30	0.011	1 x d	0.010 x d
4	95	0.024	1 x d	0.010 x d	110	0.025	1 x d	0.010 x d	30	0.021	1 x d	0.010 x d
6	95	0.024	1 x d	0.010 x d	110	0.025	1 x d	0.010 x d	30	0.021	1 x d	0.010 x d
8	95	0.048	1 x d	0.010 x d	110	0.051	1 x d	0.010 x d	30	0.039	1 x d	0.010 x d
10	95	0.048	1 x d	0.010 x d	110	0.051	1 x d	0.010 x d	30	0.039	1 x d	0.010 x d
12	95	0.072	1 x d	0.010 x d	110	0.075	1 x d	0.010 x d	30	0.063	1 x d	0.010 x d

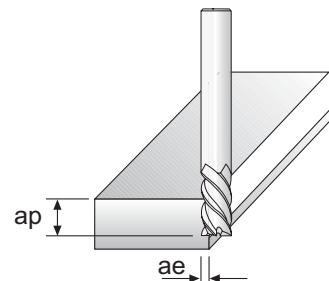
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

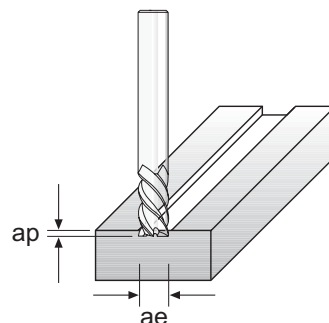
CODE: Y300 SIDE MILLING

MATERIAL	Carbon Steel-Cast Iron ЧУГУНн		Alloy Steel-Tool Steel ЛЕГИРОВАННАЯ СТАЛЬ		Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ	
HARDNESS	< 30 HRC		< 45 HRC			
Ø	RPM	Feed mm/min	RPM	Feed mm/min	RPM	Feed mm/min
	$a_e < 0.1 \times d$ ($d < 3\text{mm}$) $a_p < 1.5 \times d$ ($d > 3\text{mm}$) $a_p < 1.5 \times d$					
2	11000	600	7200	310	6000	210
3	8500	770	5300	380	4400	220
4	7200	850	4400	480	3700	250
6	5300	940	3200	490	2700	270
8	4000	1000	2400	560	2000	280
10	3200	1000	1900	480	1600	300
12	2700	950	1600	440	1300	300
16	2000	720	1200	350	1000	260
20	1600	600	1000	290	800	240



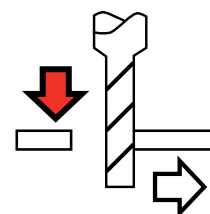
CODE: Y300 SLOT MILLING

MATERIAL	Carbon Steel-Cast Iron ЧУГУНн		Alloy Steel-Tool Steel ЛЕГИРОВАННАЯ СТАЛЬ		Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ	
HARDNESS	< 30 HRC		< 45 HRC			
Ø	RPM	Feed mm/min	RPM	Feed mm/min	RPM	Feed mm/min
	$a_e = 1 \times d$ $a_p < 1 \times d$		$a_e = 1 \times d$ $a_p < 1 \times d$		$a_e = 1 \times d$ $a_p < 0.5 \times d$	
2	11000	500	7200	260	6000	130
3	8500	650	5300	320	4200	130
4	7200	650	4400	370	3400	140
6	5300	720	3200	380	2200	140
8	4000	780	2400	430	1600	140
10	3200	770	1900	370	1300	150
12	2700	730	1600	340	1100	150
16	2000	600	1200	290	800	130
20	1600	500	1000	240	640	120



CODE: Y300 DRILLING & MILLING

MATERIAL	Carbon Steel-Cast Iron ЧУГУНн		Alloy Steel-Tool Steel ЛЕГИРОВАННАЯ СТАЛЬ		Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ	
HARDNESS	< 30 HRC		< 45 HRC			
Ø	RPM	Feed mm/min	RPM	Feed mm/min	RPM	Feed mm/min
	$a_p < 1 \times d$		$a_p < 1 \times d$		$a_p < 0.5 \times d$	
2	11000	200	7200	140	6000	30
3	8500	250	5300	180	4400	50
4	7200	300	4400	210	3700	60
6	5300	300	3200	210	2700	70
8	4000	320	2400	220	2000	80
10	3200	340	1900	240	1600	70
12	2700	320	1600	220	1300	70
16	2000	250	1200	180	1000	55
20	1600	200	1000	140	800	55

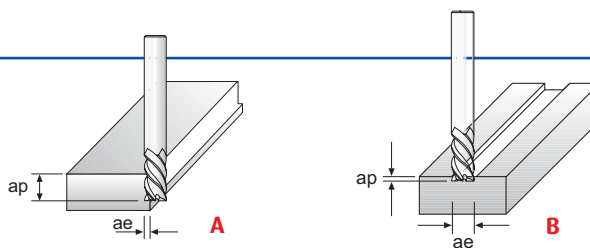


Parametri di taglio

Cutting speed

Richtwerte - Paramètres

Режимы обработки - Řežná rychlost



CODE: 302 - 404 SIDE MILLING (A)

MATERIAL	Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Super Alloy СУПЕР СПЛАВ						Inconel 718 ИНКОНЕЛЬ					
HARDNESS	Cr-Ni						Cr-Ni-Mo																	
Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
3	80	0.015	8490	380	1.2	3	40	0.015	4250	190	1.2	3	25	0.015	2650	120	1.2	3	15	0.015	1600	70	1.2	3
4	80	0.020	6365	380	1.6	4	40	0.020	3200	190	1.6	4	25	0.020	2000	120	1.6	4	15	0.020	1200	70	1.6	4
5	80	0.025	5095	380	2	5	40	0.025	2560	190	2	5	25	0.025	1600	120	2	5	15	0.025	960	70	2	5
6	80	0.030	4245	380	2.4	6	40	0.030	2120	190	2.4	6	25	0.030	1330	120	2.4	6	15	0.030	800	70	2.4	6
8	80	0.040	3185	380	3.2	8	40	0.040	1600	190	3.2	8	25	0.035	1000	105	3.2	8	15	0.035	600	60	3.2	8
10	80	0.055	2545	420	4	10	40	0.055	1280	210	4	10	25	0.045	800	105	4	10	15	0.045	480	65	4	10
12	80	0.065	2120	415	4.8	12	40	0.065	1050	205	4.8	12	25	0.050	670	100	4.8	12	15	0.050	410	60	4.8	12
16	80	0.085	1590	405	6.4	16	40	0.085	800	205	6.4	16	25	0.060	500	90	6.4	16	15	0.060	305	55	6.4	16

CODE: 302 - 404 SLOT MILLING (B)

MATERIAL	Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Super Alloy СУПЕР СПЛАВ						Inconel 718 ИНКОНЕЛЬ					
HARDNESS	Cr-Ni						Cr-Ni-Mo																	
Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
3	60	0.015	6370	285	3.00	1.5	30	0.015	3190	145	3	1.5	20	0.015	2120	95	3	1.5	10	0.015	1060	50	3	1.5
4	60	0.020	4780	285	4.00	2	30	0.020	2390	145	4	2	20	0.020	1600	95	4	2	10	0.020	800	50	4	2
5	60	0.025	3800	285	5.00	2.5	30	0.025	1900	145	5	2.5	20	0.025	1280	95	5	2.5	10	0.025	640	50	5	2.5
6	60	0.030	3200	285	6.00	3	30	0.030	1600	145	6	3	20	0.030	1080	95	6	3	10	0.030	530	50	6	3
8	60	0.040	3390	285	8.00	4	30	0.040	1200	145	8	4	20	0.035	800	95	8	4	10	0.035	401	40	8	4
10	60	0.055	1900	315	10.00	5	30	0.055	960	160	10	5	20	0.045	640	95	10	5	10	0.045	320	45	10	5
12	60	0.065	1600	310	12.00	6	30	0.065	800	155	12	6	20	0.050	540	95	12	6	10	0.050	270	40	12	6
16	60	0.085	1200	305	16.00	8	30	0.085	600	150	16	8	20	0.060	400	95	16	8	10	0.060	200	35	16	8

CODE: Y401 SIDE MILLING (A)

MATERIAL	Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Super Alloy СУПЕР СПЛАВ						Inconel 718 ИНКОНЕЛЬ					
HARDNESS	Cr-Ni						Cr-Ni-Mo																	
Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
3	80	0.015	8500	510	1.20	4.5	40	0.015	4250	260	1.20	4.5	25	0.010	2660	105	1.2	4.5	15	0.01	1600	65	1.2	4.5
4	80	0.020	6370	510	1.60	6	40	0.020	3190	260	1.60	6	25	0.015	2000	120	1.6	6	15	0.015	1200	70	1.6	6
5	80	0.025	5100	510	2.00	7.5	40	0.025	2550	260	2.00	7.5	25	0.020	1600	125	2	7.5	15	0.02	1000	75	2	7.5
6	80	0.025	4250	425	2.40	9	40	0.025	2120	210	2.40	9	25	0.020	1325	105	2.4	9	15	0.02	800	65	2.4	9
8	80	0.035	3190	445	3.20	12	40	0.035	1600	230	3.20	12	25	0.030	1000	120	3.2	12	15	0.03	600	70	3.2	12
10	80	0.045	2550	460	4.00	15	40	0.045	1280	230	4.00	15	25	0.035	800	110	4	15	15	0.035	480	65	4	15
12	80	0.050	2120	425	4.80	18	40	0.050	1060	210	4.80	18	25	0.040	665	105	4.8	18	15	0.04	400	65	4.8	18
16	80	0.075	1600	475	6.4	24	40	0.075	800	240	6.4	24	25	0.060	500	120	6.4	24	15	0.06	300	70	6.4	24

CODE: Y401 SLOT MILLING (B)

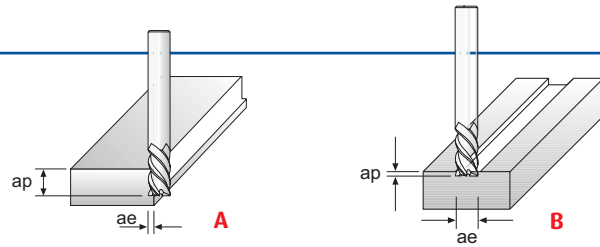
MATERIAL	Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Super Alloy СУПЕР СПЛАВ						Inconel 718 ИНКОНЕЛЬ					
HARDNESS	Cr-Ni						Cr-Ni-Mo																	
Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
3	60	0.015	6400	380	3	1.5	30	0.015	3185	190	3	1.5	20	0.015	2120	125	3	1.5	10	0.015	1060	65	3	1.5
4	60	0.020	4780	380	4	2	30	0.020	2385	190	4	2	20	0.020	1600	125	4	2	10	0.020	800	65	4	2
5	60	0.025	3820	380	5	2.5	30	0.025	1910	190	5	2.5	20	0.025	1280	130	5	2.5	10	0.025	640	65	5	2.5
6	60	0.030	3200	380	6	3	30	0.030	1590	190	6	3	20	0.025	1060	105	6	3	10	0.025	530	65	6	3
8	60	0.040	2390	380	8	4	30	0.040	1200	190	8	4	20	0.035	800	110	8	4	10	0.035	400	65	8	4
10	60	0.055	1910	420	10	5	30	0.055	960	190	10	5	20	0.045	640	115	10	5	10	0.045	320	65	10	5
12	60	0.055	1600	350	12	6	30	0.055	800	190	12	6	20	0.050	530	115	12	6	10	0.050	265	65	12	6
16	60	0.085	1200	410	16	8	30	0.085	600	190	16	8	20	0.075	400	120	16	8	10	0.075	200	65	16	8

Parametri di taglio

Cutting speed

Richtwerte - Paramètres

Режимы обработки - Řežná rychlost



CODE: Y401 SIDE MILLING (A)

MATERIAL	Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Super Alloy СУПЕР СПЛАВ						Inconel 718 ИНКОНЭЛЬ					
HARDNESS	Cr-Ni						Cr-Ni-Mo																	
Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
6	80	0.025	4250	425	2.4	9	40	0.025	2120	210	2.40	9	25	0.020	1330	105	2.4	9	15	0.020	800	65	2.4	9
8	80	0.035	3200	445	3.2	12	40	0.035	1600	225	3.20	12	25	0.030	1000	120	3.2	12	15	0.030	600	70	3.2	12
10	80	0.045	2550	460	4.0	15	40	0.045	1300	230	4.00	15	25	0.035	800	110	4	15	15	0.035	480	65	4	15
12	80	0.050	2120	425	4.8	18	40	0.050	1060	210	4.80	18	25	0.040	670	105	4.8	18	15	0.040	400	65	4.8	18
16	80	0.075	1600	475	3.2	24	40	0.075	800	240	6.40	24	25	0.060	500	120	6.4	24	15	0.060	300	70	6.4	24

CODE: Y401 SLOT MILLING (B)

MATERIAL	Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Super Alloy СУПЕР СПЛАВ						Inconel 718 ИНКОНЭЛЬ					
HARDNESS	Cr-Ni						Cr-Ni-Mo																	
Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
6	60	0.030	3200	380	6	3	30	0.030	1600	190	6	3	20	0.025	1060	105	6	3	30	0.025	530	55	6	3
8	60	0.040	2390	380	8	4	30	0.040	1200	190	8	4	20	0.035	800	110	8	4	30	0.035	400	55	8	4
10	60	0.055	1910	420	10	5	30	0.055	960	210	10	5	20	0.045	640	115	10	5	30	0.045	320	60	10	5
12	60	0.055	1600	350	12	6	30	0.055	800	175	12	6	20	0.050	530	105	12	6	30	0.050	265	55	12	6
16	60	0.085	1200	405	16	8	30	0.085	600	200	16	8	20	0.075	400	120	16	8	30	0.075	200	60	16	8

CODE: 506 - Y507 SIDE MILLING (A)

MATERIAL	Steel - СТАЛЬ																Cast Iron -ЧУГУН							
HARDNESS	< 850						< HRC 52						< HRC56											
Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
1	170	0.010	19100	764	0.10	1	110	0.010	35000	1400	0.05	1.5	90	0.010	28660	1146	0.1	1.5	130	0.010	41400	1656	0.1	1
2	170	0.010	19100	764	0.15	2	110	0.010	35000	1400	0.05	3	90	0.010	14330	573	0.1	3	130	0.010	20700	828	0.1	2
3	170	0.010	18046	721	0.15	3	110	0.015	11670	700	0.05	4.5	90	0.010	9550	380	0.1	4.5	130	0.010	13795	550	0.2	3
4	170	0.010	13535	541	0.20	4	110	0.020	8755	700	0.1	6	90	0.015	7160	430	0.1	6	130	0.010	10345	415	0.2	4
5	170	0.015	10828	650	0.25	5	110	0.025	7000	875	0.1	7.5	90	0.020	5730	575	0.1	7.5	130	0.015	8275	495	0.3	5
6	170	0.015	9020	810	0.30	9	110	0.030	5835	1050	0.1	9	90	0.025	4775	715	0.1	9	130	0.015	6895	620	0.3	9
8	170	0.025	6765	1015	0.40	12	110	0.040	4375	1050	0.1	12	90	0.030	3580	645	0.1	12	130	0.025	5175	775	0.4	12
10	170	0.030	5410	975	0.50	15	110	0.050	3500	1050	0.1	15	90	0.040	2865	690	0.1	15	130	0.030	4140	745	0.5	15
12	170	0.035	4510	945	0.60	18	110	0.060	2920	1050	0.1	18	90	0.050	2385	715	0.1	18	130	0.035	3450	725	0.6	18
16	170	0.045	3380	912	0.80	24	110	0.080	2190	1050	0.1	24	90	0.065	1790	700	0.1	24	130	0.045	2585	930	0.8	24
20	170	0.055	2705	892	1.0	30	110	0.100	1750	1050	0.1	30	90	0.080	1430	687	0.1	30	130	0.055	2070	683	1.00	30
25	170	0.070	2165	1818	1.25	37	110	0.120	1410	2030	0.1	37	90	0.100	1146	1375	0.1	37	130	0.060	1656	1192	1.25	37

CODE: 506 - Y507 SIDE MILLING (A)

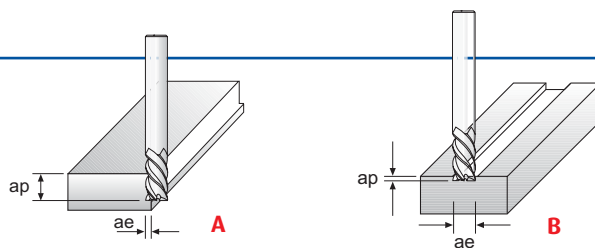
MATERIAL	Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ						Super Alloy СУПЕР СПЛАВ					
HARDNESS												
Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
1	90	0.010	28662	1720	0.50	1	130	0.010	41401	2484	0.05	1.5
2	90	0.010	14331	860	1.00	2	130	0.010	20701	1242	0.05	3
3	90	0.015	9554	860	1.50	3	130	0.020	13800	1656	0.05	4.5
4	90	0.020	7166	860	2.00	4	130	0.025	10350	1553	0.1	6
5	90	0.025	5732	860	2.50	5	130	0.030	8280	1490	0.1	7.5
6	90	0.030	4777	860	3.00	6	130	0.040	6900	1656	0.1	8
8	90	0.040	3583	860	4.00	8	130	0.055	5175	1708	0.1	12
10	90	0.055	2866	946	5.00	10	130	0.065	4140	1615	0.1	15
12	90	0.055	2389	788	6.00	12	130	0.070	3450	1449	0.12	18
16	90	0.085	1791	914	8.00	16	130	0.080	2588	1242	0.16	24
20	90	0.100	1433	860	10.0	20	130	0.100	2070	1242	0.20	30
25	90	0.120	1146	1651	12.00	25	130	0.120	1656	2384	0.25	37

Parametri di taglio

Cutting speed

Richtwerte - Paramètres

Режимы обработки - Řežná rychlost



CODE: Y400RS ROUGHING - HIGH SPEED (B)

MATERIAL	Steel - СТАЛЬ								Cast Iron -ЧУГУ/Нn			
HARDNESS	HRC 48-60				<HRC 70							
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
2	160	0.014	1 x d	0.044 x d	75	0.010	1 x d	0.028 x d	150	0.014	1 x d	0.042 x d
3	160	0.014	1 x d	0.044 x d	75	0.010	1 x d	0.028 x d	150	0.014	1 x d	0.042 x d
4	160	0.027	1 x d	0.044 x d	75	0.020	1 x d	0.028 x d	150	0.028	1 x d	0.042 x d
5	160	0.027	1 x d	0.044 x d	75	0.020	1 x d	0.028 x d	150	0.028	1 x d	0.042 x d
6	160	0.027	1 x d	0.044 x d	75	0.020	1 x d	0.028 x d	150	0.028	1 x d	0.042 x d
8	160	0.055	1 x d	0.044 x d	75	0.043	1 x d	0.028 x d	150	0.058	1 x d	0.042 x d
10	160	0.055	1 x d	0.044 x d	75	0.043	1 x d	0.028 x d	150	0.058	1 x d	0.042 x d
12	160	0.083	1 x d	0.044 x d	75	0.065	1 x d	0.028 x d	150	0.084	1 x d	0.042 x d

CODE: Y400RS FINISHING (B)

MATERIAL	Steel - СТАЛЬ								Cast Iron -ЧУГУ/Нn			
HARDNESS	HRC 48-60				<HRC 70							
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
2	200	0.014	1 x d	0.020 x d	85	0.012	1 x d	0.010 x d	175	0.015	1 x d	0.020 x d
3	200	0.014	1 x d	0.020 x d	85	0.012	1 x d	0.010 x d	175	0.015	1 x d	0.020 x d
4	200	0.029	1 x d	0.020 x d	85	0.023	1 x d	0.010 x d	175	0.031	1 x d	0.020 x d
5	200	0.029	1 x d	0.020 x d	85	0.023	1 x d	0.010 x d	175	0.031	1 x d	0.020 x d
6	200	0.029	1 x d	0.020 x d	85	0.049	1 x d	0.010 x d	175	0.031	1 x d	0.020 x d
8	200	0.059	1 x d	0.020 x d	85	0.049	1 x d	0.010 x d	175	0.062	1 x d	0.020 x d
10	200	0.059	1 x d	0.020 x d	85	0.075	1 x d	0.010 x d	175	0.062	1 x d	0.020 x d
12	200	0.088	1 x d	0.020 x d	85	0.075	1 x d	0.010 x d	175	0.091	1 x d	0.020 x d

CODE: Y400RS ROUGHING (A)

MATERIAL	Steel - СТАЛЬ								Cast Iron -ЧУГУ/Нn			
HARDNESS	HRC 48-60				<HRC 70							
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
2	275	0.021	0.033 x d	0.820 x d	125	0.015	0.028 x d	0.750 x d	250	0.021	0.021 x d	0.850 x d
3	275	0.021	0.033 x d	0.820 x d	125	0.015	0.028 x d	0.750 x d	250	0.021	0.021 x d	0.850 x d
4	275	0.042	0.033 x d	0.820 x d	125	0.030	0.028 x d	0.750 x d	250	0.043	0.021 x d	0.850 x d
5	275	0.042	0.033 x d	0.820 x d	125	0.030	0.028 x d	0.750 x d	250	0.043	0.021 x d	0.850 x d
6	275	0.042	0.033 x d	0.820 x d	125	0.030	0.028 x d	0.750 x d	250	0.043	0.021 x d	0.850 x d
8	275	0.085	0.033 x d	0.820 x d	125	0.065	0.028 x d	0.750 x d	250	0.088	0.021 x d	0.850 x d
10	275	0.085	0.033 x d	0.820 x d	125	0.065	0.028 x d	0.750 x d	250	0.088	0.021 x d	0.850 x d
12	275	0.128	0.033 x d	0.820 x d	125	0.100	0.028 x d	0.750 x d	250	0.129	0.021 x d	0.850 x d

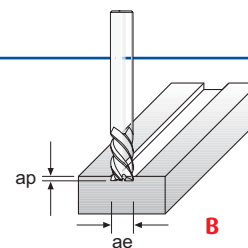
CODE: Y400RS FINISHING (A)

MATERIAL	Steel - СТАЛЬ								Cast Iron -ЧУГУ/Нn			
HARDNESS	HRC 48-60				<HRC 70							
Ø	VC	FZ	ae	ap	VC	FZ	ae	ap	VC	FZ	ae	ap
2	340	0.022	0.020 x d	0.650 x d	140	0.018	0.010 x d	0.450 x d	285	0.023	0.010 x d	0.640 x d
3	340	0.022	0.020 x d	0.650 x d	140	0.018	0.010 x d	0.450 x d	285	0.023	0.010 x d	0.640 x d
4	340	0.045	0.020 x d	0.650 x d	140	0.035	0.010 x d	0.450 x d	285	0.047	0.010 x d	0.640 x d
5	340	0.045	0.020 x d	0.650 x d	140	0.035	0.010 x d	0.450 x d	285	0.047	0.010 x d	0.640 x d
6	340	0.045	0.020 x d	0.650 x d	140	0.035	0.010 x d	0.450 x d	285	0.047	0.010 x d	0.640 x d
8	340	0.090	0.020 x d	0.650 x d	140	0.075	0.010 x d	0.450 x d	285	0.095	0.010 x d	0.640 x d
10	340	0.090	0.020 x d	0.650 x d	140	0.075	0.010 x d	0.450 x d	285	0.095	0.010 x d	0.640 x d
12	340	0.135	0.020 x d	0.650 x d	140	0.115	0.010 x d	0.450 x d	285	0.140	0.010 x d	0.640 x d

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost



CODE: 406 - Y406 ROUGHING

MATERIAL	Free Machining Steel ЛЕГКОБРАБАТЫВАЕМАЯ СТАЛЬ			Normal tool Steel ИНСТРУМЕНТАЛЬНАЯ СТАЛЬ			Tool Steel & Steel Castings ИНСТРУМЕНТАЛЬНАЯ СТАЛЬ И ЛИТЬЕВАЯ ФОРМА			Steel СТАЛЬ		
HARDNESS										< 50 HRC		
Ø	VC	FZ	ap	VC	FZ	ap	VC	FZ	ap	VC	FZ	ap
2	150 - 250	0.02 - 0.04	1.0 - 1.5	150 - 220	0.02 - 0.04	1.0 - 1.5	120 - 170	0.02 - 0.04	1.0 - 1.5	150 - 190	0.02 - 0.04	0.04 - 0.1
3 - 4	150 - 250	0.03 - 0.06	1.5 - 2.0	150 - 220	0.03 - 0.06	1.5 - 2.0	120 - 170	0.03 - 0.06	1.5 - 2.0	150 - 190	0.03 - 0.06	0.08 - 0.2
5 - 6	150 - 250	0.05 - 0.08	2.5 - 3.0	150 - 220	0.05 - 0.08	2.5 - 3.0	120 - 170	0.05 - 0.08	2.5 - 3.0	150 - 190	0.05 - 0.08	0.1 - 0.3
8	150 - 250	0.05 - 0.08	3.5 - 4.0	150 - 220	0.05 - 0.08	3.5 - 4.0	120 - 170	0.05 - 0.08	3.5 - 4.0	150 - 190	0.05 - 0.08	0.15 - 0.4
10	150 - 250	0.06 - 0.10	4.5 - 5.0	150 - 220	0.06 - 0.10	4.5 - 5.0	120 - 170	0.06 - 0.10	4.5 - 5.0	150 - 190	0.06 - 0.10	0.2 - 0.5
12	150 - 250	0.07 - 0.12	5.0 - 6.0	150 - 220	0.07 - 0.12	5.0 - 6.0	120 - 170	0.07 - 0.12	5.0 - 6.0	150 - 190	0.07 - 0.12	0.2 - 0.6
16	150 - 250	0.08 - 0.12	6.0 - 8.0	150 - 220	0.08 - 0.12	6.0 - 8.0	120 - 170	0.08 - 0.12	6.0 - 8.0	150 - 190	0.08 - 0.12	0.2 - 0.8
20	150 - 250	0.08 - 0.12	6.0 - 8.0	150 - 220	0.08 - 0.12	6.0 - 8.0	120 - 170	0.08 - 0.12	6.0 - 8.0	150 - 190	0.08 - 0.12	0.2 - 0.8

MATERIAL	Cast Iron ЧУГУН									Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ		
HARDNESS	Grey - СЕРЫЙ			Spheroidal - СФЕРОИД			Tempered Casting - ТЕРМО ФОРМОВКА					
Ø	VC	FZ	ap	VC	FZ	ap	VC	FZ	ap	VC	FZ	ap
2	250 - 300	0.02 - 0.04	1.0 - 1.5	150 - 220	0.02 - 0.04	1.0 - 1.5	100 - 160	0.02 - 0.04	1.0 - 1.5	70 - 110	0.02 - 0.04	0.3 - 0.7
3 - 4	250 - 300	0.03 - 0.06	1.5 - 2.0	150 - 220	0.03 - 0.06	1.5 - 2.0	100 - 160	0.03 - 0.06	1.5 - 2.0	70 - 110	0.03 - 0.06	0.7 - 1.2
5 - 6	250 - 300	0.05 - 0.08	2.5 - 3.0	150 - 220	0.05 - 0.08	2.5 - 3.0	100 - 160	0.05 - 0.08	2.5 - 3.0	70 - 110	0.05 - 0.08	1.5 - 1.8
8	250 - 300	0.05 - 0.08	3.5 - 4.0	150 - 220	0.05 - 0.08	3.5 - 4.0	100 - 160	0.05 - 0.08	3.5 - 4.0	70 - 110	0.05 - 0.08	2.0 - 2.5
10	250 - 300	0.06 - 0.10	4.5 - 5.0	150 - 220	0.06 - 0.10	4.5 - 5.0	100 - 160	0.06 - 0.10	4.5 - 5.0	70 - 110	0.06 - 0.10	2.5 - 3.0
12	250 - 300	0.07 - 0.12	5.0 - 6.0	150 - 220	0.07 - 0.12	5.0 - 6.0	100 - 160	0.07 - 0.12	5.0 - 6.0	70 - 110	0.07 - 0.12	3.0 - 3.5
16	250 - 300	0.08 - 0.12	6.0 - 8.0	150 - 220	0.08 - 0.12	6.0 - 8.0	100 - 160	0.08 - 0.12	6.0 - 8.0	70 - 110	0.08 - 0.12	4.0 - 4.5
20	250 - 300	0.08 - 0.12	6.0 - 8.0	150 - 220	0.08 - 0.12	6.0 - 8.0	100 - 160	0.08 - 0.12	6.0 - 8.0	70 - 110	0.08 - 0.12	4.0 - 4.5

CODE: 406 - Y406 FINISHING

MATERIAL	Free Machining Steel ЛЕГКОБРАБАТЫВАЕМАЯ СТАЛЬ			Normal tool Steel ИНСТРУМЕНТАЛЬНАЯ СТАЛЬ			Tool Steel & Steel Castings ИНСТРУМЕНТАЛЬНАЯ СТАЛЬ И ЛИТЬЕВАЯ ФОРМА			Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ		
HARDNESS												
Ø	VC	FZ	ap	VC	FZ	ap	VC	FZ	ap	VC	FZ	ap
2	250 - 300	0.02 - 0.04	1.0 - 1.5	220-300	0.02 - 0.04	1.0 - 1.5	170-250	0.02 - 0.04	1.0 - 1.5	110-150	0.02 - 0.04	0.3 - 0.7
3 - 4	250 - 300	0.03 - 0.06	1.5 - 2.0	220-300	0.03 - 0.06	1.5 - 2.0	170-250	0.03 - 0.06	1.5 - 2.0	110-150	0.03 - 0.06	0.7 - 1.2
5 - 6	250 - 300	0.05 - 0.08	2.5 - 3.0	220-300	0.05 - 0.08	2.5 - 3.0	170-250	0.05 - 0.08	2.5 - 3.0	110-150	0.05 - 0.08	1.5 - 1.8
8	250 - 300	0.05 - 0.08	3.5 - 4.0	220-300	0.05 - 0.08	3.5 - 4.0	170-250	0.05 - 0.08	3.5 - 4.0	110-150	0.05 - 0.08	2.0 - 2.5
10	250 - 300	0.06 - 0.10	4.5 - 5.0	220-300	0.06 - 0.10	4.5 - 5.0	170-250	0.06 - 0.10	4.5 - 5.0	110-150	0.06 - 0.10	2.5 - 3.0
12	250 - 300	0.07 - 0.12	5.0 - 6.0	220-300	0.07 - 0.12	5.0 - 6.0	170-250	0.07 - 0.12	5.0 - 6.0	110-150	0.07 - 0.12	3.0 - 3.5
16	250 - 300	0.08 - 0.12	6.0 - 8.0	220-300	0.08 - 0.12	6.0 - 8.0	170-250	0.08 - 0.12	6.0 - 8.0	110-150	0.08 - 0.12	4.0 - 4.5
20	250 - 300	0.08 - 0.12	6.0 - 8.0	220-300	0.08 - 0.12	6.0 - 8.0	170-250	0.08 - 0.12	6.0 - 8.0	110-150	0.08 - 0.12	4.0 - 4.5

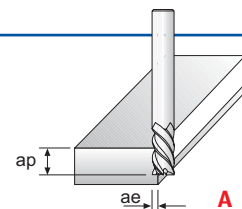
MATERIAL	Steel - СТАЛЬ								
HARDNESS	< 50 HRC			< 60 HRC			< 70 HRC		
Ø	VC	FZ	ap	VC	FZ	ap	VC	FZ	ap
2	190 - 250	0.02 - 0.04	0.04 - 0.1	120 - 250	0.02 - 0.04	0.04 - 0.1	80 - 120	0.02 - 0.04	0.04 - 0.1
3 - 4	190 - 250	0.03 - 0.06	0.08 - 0.2	120 - 250	0.03 - 0.06	0.08 - 0.2	80 - 120	0.03 - 0.06	0.08 - 0.2
5 - 6	190 - 250	0.05 - 0.08	0.1 - 0.3	120 - 250	0.05 - 0.08	0.1 - 0.3	80 - 120	0.05 - 0.08	0.1 - 0.3
8	190 - 250	0.05 - 0.08	0.15 - 0.4	120 - 250	0.05 - 0.08	0.15 - 0.4	80 - 120	0.05 - 0.08	0.15 - 0.35
10	190 - 250	0.06 - 0.10	0.2 - 0.5	120 - 250	0.06 - 0.10	0.2 - 0.5	80 - 120	0.06 - 0.10	0.2 - 0.45
12	190 - 250	0.07 - 0.12	0.2 - 0.6	120 - 250	0.07 - 0.12	0.2 - 0.6	80 - 120	0.07 - 0.12	0.2 - 0.5
16	190 - 250	0.08 - 0.12	0.2 - 0.8	120 - 250	0.08 - 0.12	0.2 - 0.8	80 - 120	0.08 - 0.12	0.2 - 0.6
20	190 - 250	0.08 - 0.12	0.2 - 0.8	120 - 250	0.08 - 0.12	0.2 - 0.8	80 - 120	0.08 - 0.12	0.2 - 0.6

MATERIAL	Cast Iron -ЧУГУН								
HARDNESS	Grey - СЕРЫЙ			Spheroidal - СФЕРОИД			Tempered Casting - ТЕРМО ФОРМОВКА		
Ø	VC	FZ	ap	VC	FZ	ap	VC	FZ	ap
2	300 - 400	0.02 - 0.04	1.0 - 1.5	200 - 250	0.02 - 0.04	1.0 - 1.5	160 - 200	0.02 - 0.04	1.0 - 1.5
3 - 4	300 - 400	0.03 - 0.06	1.5 - 2.0	200 - 250	0.03 - 0.06	1.5 - 2.0	160 - 200	0.03 - 0.06	1.5 - 2.0
5 - 6	300 - 400	0.05 - 0.08	2.5 - 3.0	200 - 250	0.05 - 0.08	2.5 - 3.0	160 - 200	0.05 - 0.08	2.5 - 3.0
8	300 - 400	0.05 - 0.08	3.5 - 4.0	200 - 250	0.05 - 0.08	3.5 - 4.0	160 - 200	0.05 - 0.08	3.5 - 4.0
10	300 - 400	0.06 - 0.10	4.5 - 5.0	200 - 250	0.06 - 0.10	4.5 - 5.0	160 - 200	0.06 - 0.10	4.5 - 5.0
12	300 - 400	0.07 - 0.12	5.0 - 6.0	200 - 250	0.07 - 0.12	5.0 - 6.0	160 - 200	0.07 - 0.12	5.0 - 6.0
16	300 - 400	0.08 - 0.12	6.0 - 8.0	200 - 250	0.08 - 0.12	6.0 - 8.0	160 - 200	0.08 - 0.12	6.0 - 8.0
20	300 - 400	0.08 - 0.12	6.0 - 8.0	200 - 250	0.08 - 0.12	6.0 - 8.0	160 - 200	0.08 - 0.12	6.0 - 8.0

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost



CODE: 406 - Y406 ROUGHING

MATERIAL	Free Machining Steel ЛЕГКООБРАБАТЫВАЕМАЯ СТАЛЬ		Normal tool Steel ИНСТРУМЕНТАЛЬНАЯ СТАЛЬ		Tool Steel & Steel Castings ИНСТРУМЕНТАЛЬНАЯ СТАЛЬ И ЛИТЬЕВАЯ ФОРМА		Steel СТАЛЬ	
HARDNESS							< 50 HRC	
Ø	VC	FZ	VC	FZ	VC	FZ	VC	FZ
2	150 - 250	0.05 - 0.09	150 - 220	0.05 - 0.09	120 - 170	0.05 - 0.09	100 - 160	0.03 - 0.06
3 - 4	150 - 250	0.09 - 0.12	150 - 220	0.09 - 0.12	120 - 170	0.09 - 0.12	100 - 160	0.07 - 0.10
5 - 6	150 - 250	0.12 - 0.18	150 - 220	0.12 - 0.18	120 - 170	0.12 - 0.18	100 - 160	0.10 - 0.15
8	150 - 250	0.12 - 0.18	150 - 220	0.12 - 0.18	120 - 170	0.12 - 0.18	100 - 160	0.10 - 0.15
10	150 - 250	0.15 - 0.20	150 - 220	0.15 - 0.20	120 - 170	0.15 - 0.20	100 - 160	0.12 - 0.17
12	150 - 250	0.15 - 0.20	150 - 220	0.15 - 0.20	120 - 170	0.15 - 0.20	100 - 160	0.12 - 0.17
16	150 - 250	0.20 - 0.25	150 - 220	0.20 - 0.25	120 - 170	0.20 - 0.25	100 - 160	0.17 - 0.22
20	150 - 250	0.20 - 0.25	150 - 220	0.20 - 0.25	120 - 170	0.20 - 0.25	100 - 160	0.20 - 0.25

MATERIAL	Cast Iron -ЧУГУНn						Stainless Steel	
HARDNESS	Grey - СЕРЫЙ		Spheroidal - СФЕРОИД		Tempered Casting - ТЕРМО ФОРМОВКА			
Ø	VC	FZ	VC	FZ	VC	FZ	VC	FZ
2	250 - 300	0.05 - 0.09	150 - 200	0.05 - 0.09	100 - 160	0.05 - 0.09	70 - 110	0.05 - 0.09
3 - 4	250 - 300	0.05 - 0.09	150 - 200	0.09 - 0.12	100 - 160	0.09 - 0.12	70 - 110	0.09 - 0.12
5 - 6	250 - 300	0.09 - 0.12	150 - 200	0.12 - 0.18	100 - 160	0.12 - 0.18	70 - 110	0.12 - 0.18
8	250 - 300	0.12 - 0.18	150 - 200	0.12 - 0.18	100 - 160	0.12 - 0.18	70 - 110	0.12 - 0.18
10	250 - 300	0.12 - 0.18	150 - 200	0.15 - 0.20	100 - 160	0.15 - 0.20	70 - 110	0.15 - 0.20
12	250 - 300	0.15 - 0.20	150 - 200	0.15 - 0.20	100 - 160	0.15 - 0.20	70 - 110	0.15 - 0.20
16	250 - 300	0.15 - 0.20	150 - 200	0.20 - 0.25	100 - 160	0.20 - 0.25	70 - 110	0.15 - 0.20
20	250 - 300	0.20 - 0.25	150 - 200	0.25 - 0.30	100 - 160	0.25 - 0.30	70 - 110	0.20 - 0.25

CODE: 406 - Y406 FINISHING

MATERIAL	Free Machining Steel ЛЕГКООБРАБАТЫВАЕМАЯ СТАЛЬ		Normal tool Steel ИНСТРУМЕНТАЛЬНАЯ СТАЛЬ		Tool Steel & Steel Castings ИНСТРУМЕНТАЛЬНАЯ СТАЛЬ И ЛИТЬЕВАЯ ФОРМА		Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ	
HARDNESS								
Ø	VC	FZ	VC	FZ	VC	FZ	VC	FZ
2	250 - 350	0.05 - 0.09	220 - 300	0.05 - 0.09	170 - 250	0.05 - 0.09	110 - 150	0.05 - 0.09
3 - 4	250 - 350	0.09 - 0.12	220 - 300	0.09 - 0.12	170 - 250	0.09 - 0.12	110 - 150	0.09 - 0.12
5 - 6	250 - 350	0.12 - 0.18	220 - 300	0.12 - 0.18	170 - 250	0.12 - 0.18	110 - 150	0.12 - 0.18
8	250 - 350	0.12 - 0.18	220 - 300	0.12 - 0.18	170 - 250	0.12 - 0.18	110 - 150	0.12 - 0.18
10	250 - 350	0.15 - 0.20	220 - 300	0.15 - 0.20	170 - 250	0.15 - 0.20	110 - 150	0.15 - 0.20
12	250 - 350	0.15 - 0.20	220 - 300	0.15 - 0.20	170 - 250	0.15 - 0.20	110 - 150	0.15 - 0.20
16	250 - 350	0.20 - 0.25	220 - 300	0.20 - 0.25	170 - 250	0.20 - 0.25	110 - 150	0.20 - 0.25
20	250 - 350	0.20 - 0.25	220 - 300	0.20 - 0.25	170 - 250	0.20 - 0.25	110 - 150	0.20 - 0.25

MATERIAL	Steel - СТАЛЬ					
HARDNESS	< 50 HRC		< 60 HRC		< 70 HRC	
Ø	VC	FZ	VC	FZ	VC	FZ
2	190 - 250	0.03 - 0.06	120 - 250	0.03 - 0.06	80 - 120	0.03 - 0.06
3 - 4	190 - 250	0.07 - 0.10	120 - 250	0.07 - 0.10	80 - 120	0.07 - 0.10
5 - 6	190 - 250	0.10 - 0.15	120 - 250	0.10 - 0.15	80 - 120	0.10 - 0.15
8	190 - 250	0.10 - 0.15	120 - 250	0.10 - 0.15	80 - 120	0.10 - 0.15
10	190 - 250	0.12 - 0.17	120 - 250	0.12 - 0.17	80 - 120	0.12 - 0.17
12	190 - 250	0.12 - 0.17	120 - 250	0.12 - 0.17	80 - 120	0.12 - 0.17
16	190 - 250	0.17 - 0.22	120 - 250	0.17 - 0.22	80 - 120	0.17 - 0.22
20	190 - 250	0.20 - 0.25	120 - 250	0.20 - 0.25	80 - 120	0.20 - 0.25

MATERIAL	Cast Iron -ЧУГУНn					
HARDNESS	Grey - СЕРЫЙ		Spheroidal - СФЕРОИД		Tempered Casting - ТЕРМО ФОРМОВКА	
Ø	VC	FZ	VC	FZ	VC	FZ
2	300 - 400	0.05 - 0.09	200 - 250	0.05 - 0.09	160 - 200	0.05 - 0.09
3 - 4	300 - 400	0.05 - 0.09	200 - 250	0.09 - 0.12	160 - 200	0.09 - 0.12
5 - 6	300 - 400	0.09 - 0.12	200 - 250	0.12 - 0.18	160 - 200	0.12 - 0.18
8	300 - 400	0.12 - 0.18	200 - 250	0.12 - 0.18	160 - 200	0.12 - 0.18
10	300 - 400	0.12 - 0.18	200 - 250	0.15 - 0.20	160 - 200	0.15 - 0.20
12	300 - 400	0.15 - 0.20	200 - 250	0.15 - 0.20	160 - 200	0.15 - 0.20
16	300 - 400	0.15 - 0.20	200 - 250	0.20 - 0.25	160 - 200	0.20 - 0.25
20	300 - 400	0.20 - 0.25	200 - 250	0.25 - 0.30	160 - 200	0.25 - 0.30

ap = up to 100%
of Cutting Length

ae = up to 20%
of the diameter
for non-hardened materials

ae = up to 5%
of the diameter
for hardened materials

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: Y303 - Y400D LOW SPEED, HIGH FEED

MATERIAL	Carbon Steel-Cast Iron			Alloy Steel-Tool Steel - ЛЕГИРОВАННАЯ СТАЛЬ			Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ		
HARDNESS	750 N/mm2			<30 HRC			<45 HRC		
Ø	RPM	Vf	Fz	RPM	Vf	Fz	RPM	Vf	Fz
	R<2 ap=0.2XR ae=0.5xD 2<R ap=0.4mm ae=0.5xD								
2	15200	4990	0.08	15200	4510	0.07	10450	3180	0.07
3	9970	5940	0.14	9970	5320	0.13	7080	3705	0.13
4	7550	6270	0.20	7550	5700	0.19	5270	3990	0.19
5	6030	6650	0.28	6030	6030	0.25	4230	4230	0.25
6	5030	6650	0.33	5030	6030	0.30	3510	4230	0.30
8	3800	6650	0.43	3800	6030	0.39	2660	4230	0.40
10	3040	6650	0.54	3040	6030	0.49	2140	4230	0.50
12	2520	6650	0.66	2520	6030	0.59	1760	4230	0.60

MATERIAL	Carbon Steel-Cast Iron			Heat Resistant Steel-Ti Alloy - ЛЕГИРОВАННАЯ СТАЛЬ			Steel - СТАЛЬ		
HARDNESS	<40HRC			<55 HRC			<65 HRC		
Ø	RPM	Vf	Fz	RPM	Vf	Fz	RPM	Vf	Fz
	R<2 ap=0.2XR ae=0.5xD 2<R ap=0.4mm ae=0.5xD						R<2 ap=0.1XR ae=0.5xD 2<R ap=0.2mm ae=0.5xD		
2	11870	3610	0.07	7550	2040	0.06	4510	820	0.04
3	8070	4270	0.13	5030	2470	0.12	3040	940	0.08
4	6030	4560	0.19	3800	2610	0.17	2280	1000	0.11
5	4840	4840	0.25	3040	2710	0.22	1800	1090	0.15
6	4040	4840	0.30	2530	2710	0.26	1520	1090	0.18
8	3040	4840	0.40	1900	2710	0.36	1140	1090	0.23
10	2420	4840	0.50	1520	2710	0.44	910	1090	0.30
12	2000	4840	0.60	1280	2710	0.53	750	1090	0.36

The cutting speeds are referred to milling by interpolation. In case to milling without interpolation, reduce the parameters 50%60% (ONLY FOR Y400D).

Y303: +30%

CODE: Y303 - Y400D HIGH SPEED

MATERIAL	Carbon Steel-Cast Iron			Alloy Steel-Tool Steel - ЛЕГИРОВАННАЯ СТАЛЬ			Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ		
HARDNESS	750 N/mm2			<30 HRC			<45 HRC		
Ø	RPM	Vf	Fz	RPM	Vf	Fz	RPM	Vf	Fz
	ap=0.1xR ae=0.3xD								
2	30250	9970	0.08	30400	9070	0.07	22800	6800	0.07
3	19950	11870	0.14	19950	11400	0.14	15200	7980	0.13
4	15200	12350	0.20	15200	11400	0.18	11400	8550	0.18
5	11870	13300	0.28	11870	11870	0.25	9070	9070	0.25
6	10070	13300	0.33	10070	12060	0.30	7550	9070	0.30
8	7550	13300	0.44	7550	12060	0.40	5650	9070	0.40
10	6030	13300	0.55	6030	12060	0.50	4510	9070	0.50
12	5030	13300	0.66	5030	12060	0.60	3800	9070	0.60

MATERIAL	Carbon Steel-Cast Iron			Heat Resistant Steel-Ti Alloy - ЛЕГИРОВАННАЯ СТАЛЬ			Steel - СТАЛЬ		
HARDNESS	<40HRC			<55 HRC			<60 HRC		
Ø	RPM	Vf	Fz	RPM	Vf	Fz	RPM	Vf	Fz
ap	ap=0.1xR ae=0.3xD			R<2 ap=0.1xR ae=0.3xD 2<R ap=0.2mm ae=0.3xD			R<2 ap=0.05xR ae=0.3xD 2<R ap=0.1mm ae=0.3xD		
2	30400	9070	0.07	22800	6130	0.06	15200	2710	0.04
3	19950	11400	0.14	15200	7450	0.12	9980	3130	0.07
4	15200	11400	0.18	11400	7790	0.17	7550	3370	0.11
5	11870	11870	0.25	9070	8170	0.22	6030	3610	0.15
6	10070	12060	0.30	7550	8170	0.27	5030	3610	0.18
8	7550	12060	0.40	5650	8170	0.36	3800	3610	0.23
10	6030	12060	0.50	4510	8170	0.45	3040	3610	0.30
12	5030	12060	0.60	3800	8170	0.53	2520	3610	0.36

The cutting speeds are referred to milling by interpolatin. In case to milling without interpolation, reduce the parameters 50%60% (ONLY FOR Y400D).

Y303: +30%

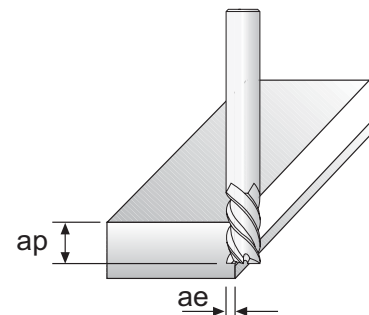
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: Y400R HIGH SPEED CONDITION - HIGH REVOLUTION, HIGH FEED

MATERIAL	Cast Iron - ЧУГУН			Steel - СТАЛЬ		
HARDNESS	HB 150-250			HRC 25-35		
Ø	n	FZ	VF	n	FZ	VF
4.0	9.900	0.270	10.530	8.800	0.240	8.560
5.0	8.000	0.330	10.640	7.000	0.300	8.510
6.0	6.600	0.420	11.090	5.800	0.380	8.910
8.0	5.000	0.560	11.200	4.400	0.510	9.010
10.0	4.000	0.700	11.200	3.500	0.640	8.960
12.0	3.300	0.800	10.530	2.900	0.730	8.460

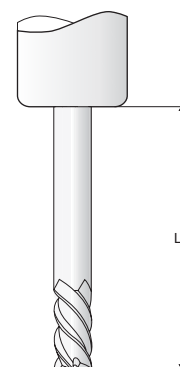


CODE: Y400R HIGH SPEED CONDITION - HIGH REVOLUTION, HIGH FEED

MATERIAL	Steel - СТАЛЬ								
HARDNESS	HRC 35-45			HRC 45-55			<HRC 72		
Ø	n	FZ	VF	n	FZ	VF	n	FZ	VF
4.0	8.000	0.190	6.080	6.400	0.190	4.860	5.600	0.080	1.700
5.0	6.400	0.240	6.080	5.100	0.240	4.850	4.500	0.100	1.710
6.0	5.300	0.300	6.360	4.200	0.300	5.040	3.700	0.120	1.780
8.0	4.000	0.400	6.400	3.200	0.400	5.120	2.800	0.160	1.790
10.0	3.200	0.500	6.400	2.500	0.500	5.000	2.200	0.200	1.760
12.0	2.700	0.570	6.160	2.100	0.570	4.790	1.900	0.230	1.730

Ø d x L ap = deep of cut

MATERIAL		Cast Iron - ЧУГУН		Steel - СТАЛЬ							
HARDNESS		HB 150-250		HRC 25-35		HRC 35-45		HRC 45-55		<HRC 72	
Ø	LT	ap	ae	ap	ae	ap	ae	ap	ae	ap	ae
4.0	5 x d	0.240	1	0.240	1	0.210	1	0.180	1	0.120	1
	8 x d	0.184	1	0.184	1	0.161	1	0.138	1	0.092	1
5.0	5 x d	0.288	1.3	0.288	1.3	0.252	1.3	0.216	1.3	0.144	1.3
	8 x d	0.221	1.3	0.221	1.3	0.193	1.3	0.166	1.3	0.110	1.3
6.0	5 x d	0.360	1.5	0.360	1.5	0.315	1.5	0.270	1.5	0.180	1.5
	8 x d	0.276	1.5	0.276	1.5	0.242	1.5	0.207	1.5	0.138	1.5
8.0	5 x d	0.480	2	0.480	2	0.420	2	0.360	2	0.240	2
	8 x d	0.368	2	0.368	2	0.322	2	0.276	2	0.184	2
10.0	5 x d	0.480	3	0.480	3	0.420	3	0.360	3	0.240	3
	8 x d	0.368	3	0.368	3	0.322	3	0.276	3	0.184	3
12.0	5 x d	0.480	4	0.480	4	0.420	4	0.360	4	0.240	4
	8 x d	0.368	4	0.368	4	0.322	4	0.276	4	0.184	4



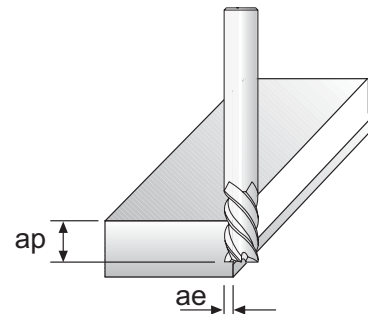
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: Y400R LOW REVOLUTION, HIGH FEED

MATERIAL	Cast Iron -ЧУГУН			Steel - СТАЛЬ		
HARDNESS	HB 150-250			HRC 25-35		
Ø	n	FZ	VF	n	FZ	VF
4.0	6.000	0.270	6.380	5.600	0.240	5.450
5.0	4.800	0.330	6.380	4.500	0.300	5.470
6.0	4.000	0.420	6.720	3.700	0.380	6.680
8.0	3.000	0.560	6.720	2.800	0.510	5.730
10.0	2.400	0.700	6.720	2.200	0.640	5.630
12.0	2.000	0.800	6.380	1.900	0.730	5.540

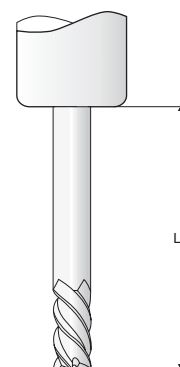


CODE: Y400R LOW REVOLUTION, HIGH FEED

MATERIAL	Steel - СТАЛЬ								
HARDNESS	HRC 35-45			HRC 45-55			<HRC 72		
Ø	n	FZ	VF	n	FZ	VF	n	FZ	VF
4.0	5.200	0.190	3.950	4.000	0.190	3.040	4.000	0.080	1.220
5.0	4.100	0.240	3.900	3.200	0.240	3.040	3.200	0.100	1.220
6.0	3.400	0.300	4.080	2.700	0.300	3.240	2.700	0.120	1.300
8.0	2.600	0.400	4.160	2.000	0.400	3.200	2.000	0.160	1.280
10.0	2.100	0.500	4.200	1.600	0.500	3.200	1.600	0.200	1.280
12.0	1.700	0.570	3.880	1.300	0.570	2.960	1.300	0.230	1.190

Ø d x L ap = deep of cut

MATERIAL		Cast Iron -ЧУГУН		Steel - СТАЛЬ							
HARDNESS		HB 150-250		HRC 25-35		HRC 35-45		HRC 45-55		<HRC 72	
Ø	LT	ap	ae	ap	ae	ap	ae	ap	ae	ap	ae
4.0	5 x d	0.300	1	0.300	1	0.300	1	0.210	1	0.150	1
	8 x d	0.230	1	0.230	1	0.230	1	0.161	1	0.115	1
5.0	5 x d	0.360	1.3	0.360	1.3	0.360	1.3	0.252	1.3	0.180	1.3
	8 x d	0.276	1.3	0.276	1.3	0.276	1.3	0.193	1.3	0.138	1.3
6.0	5 x d	0.450	1.5	0.450	1.5	0.450	1.5	0.315	1.5	0.300	1.5
	8 x d	0.345	1.5	0.345	1.5	0.345	1.5	0.242	1.5	0.230	1.5
8.0	5 x d	0.600	2	0.600	2	0.600	2	0.420	2	0.300	2
	8 x d	0.460	2	0.460	2	0.460	2	0.322	2	0.230	2
10.0	5 x d	0.600	3	0.600	3	0.600	3	0.420	3	0.300	3
	8 x d	0.460	3	0.460	3	0.460	3	0.322	3	0.230	3
12.0	5 x d	0.600	4	0.600	4	0.600	4	0.420	4	0.300	4
	8 x d	0.460	4	0.460	4	0.460	4	0.322	4	0.230	4



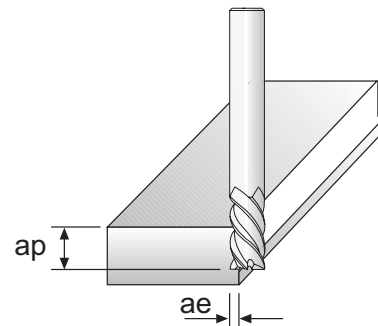
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: Y400R LOW REVOLUTION, HIGH DEPTH OF CUT

MATERIAL	Cast Iron -ЧУГУН			Steel - СТАЛЬ		
HARDNESS	HB 150-250			HRC 25-35		
Ø	Vc	Fz	RPM	Vc	Fz	RPM
4.0	6.000	0.120	2.920	5.600	0.110	2.550
5.0	4.800	0.150	2.920	4.500	0.140	2.570
6.0	4.000	0.190	3.070	3.700	0.180	2.660
8.0	3.000	0.260	3.070	2.800	0.240	2.690
10.0	2.400	0.320	3.070	2.200	0.300	2.640
12.0	2.000	0.360	2.920	1.900	0.340	2.600

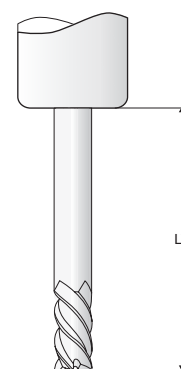


CODE: Y400R LOW REVOLUTION, HIGH DEPTH OF CUT

MATERIAL	Steel - СТАЛЬ								
HARDNESS	HRC 35-45			HRC 45-55			<HRC 72		
Ø	n	FZ	VF	n	FZ	VF	n	FZ	VF
4	5.200	0.100	1.980	4.000	0.100	1.520	4.000	0.050	730
5	4.100	0.120	1.950	3.200	0.120	1.520	3.200	0.060	730
6	3.400	0.150	2.040	2.700	0.150	1.620	2.700	0.070	780
8	2.600	0.200	2.080	2.000	0.200	1.600	2.000	0.100	770
10	2.100	0.250	2.100	1.600	0.250	1.600	1.600	0.120	770
12	1.700	0.290	1.940	1.300	0.290	1.480	1.300	0.140	710

Ø d x L ap = depth of cut

MATERIAL		Cast Iron -ЧУГУН		Steel - СТАЛЬ							
HARDNESS		HB 150-250		HRC 25-35		HRC 35-45		HRC 45-55		<HRC 72	
Ø	LT	ap	ae	ap	ae	ap	ae	ap	ae	ap	ae
4	5 x d	0.600	1	0.540	1	0.480	1	0.360	1	0.210	1
	8 x d	0.460	1	0.414	1	0.368	1	0.276	1	0.161	1
5	5 x d	0.720	1.3	0.648	1.3	0.576	1.3	0.432	1.3	0.252	1.3
	8 x d	0.552	1.3	0.497	1.3	0.442	1.3	0.331	1.3	0.193	1.3
6	5 x d	0.900	1.5	0.810	1.5	0.720	1.5	0.540	1.5	0.315	1.5
	8 x d	0.690	1.5	0.621	1.5	0.552	1.5	0.414	1.5	0.242	1.5
8	5 x d	1.200	2	1.080	2	0.960	2	0.720	2	0.420	2
	8 x d	0.920	2	0.828	2	0.736	2	0.552	2	0.322	2
10	5 x d	1.200	3	1.080	3	0.960	3	0.720	3	0.420	3
	8 x d	0.920	3	0.828	3	0.736	3	0.552	3	0.322	3
12	5 x d	1.200	4	1.080	4	0.960	4	0.720	4	0.420	4
	8 x d	0.920	4	0.828	4	0.736	4	0.552	4	0.322	4



Parametri di taglio

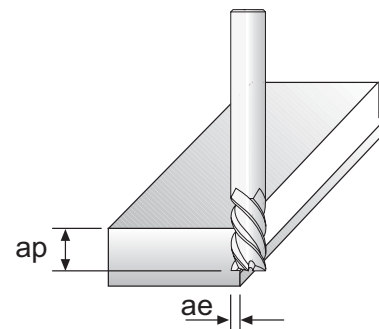
Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řezná rychlost

CODE: Y400-Y400P-400V-Y400V SIDE MILLING

MATERIAL	Carbon Steel - Cast Iron			Aloy Steel - Tool Steel - СУПЕР СПЛАВ			Steel - СТАЛЬ		
HARDNESS	750/mm2			<30HRC			<40HRC		
Ø	Vc	Fz	RPM	Vc	Fz	RPM	Vc	Fz	RPM
	ae=0.2xd ap=1.5xd			ae=0.2xd ap=1.5xd			ae=0.2xd ap=1.5xd		
3	100	0.02	10600	78	0.02	8280	65	0.02	6900
4	100	0.03	7960	78	0.03	6210	65	0.03	5175
5	100	0.03	6370	78	0.03	4968	65	0.03	4140
6	100	0.06	5300	78	0.06	4140	65	0.06	3450
8	100	0.08	3980	78	0.08	3105	65	0.08	2587
10	100	0.09	3185	78	0.09	2480	65	0.09	2070
12	100	0.10	2650	78	0.10	2070	65	0.10	1720
16	100	0.12	1990	78	0.12	1550	65	0.12	1293
20	100	0.12	1592	78	0.12	1242	65	0.12	1035

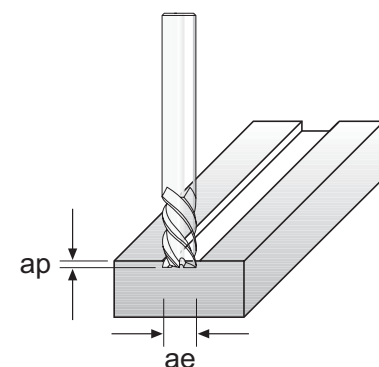
MATERIAL	Steel - СТАЛЬ					
HARDNESS	<45HRC			<50HRC		
Ø	Vc	Fz	RPM	Vc	Fz	RPM
	ae=0.1xd ap=1.5xd			ae=0.05xd ap=1xd		
3	62	0.02	6580	60	0.02	6370
4	62	0.03	4936	60	0.03	4780
5	62	0.04	3950	60	0.04	3820
6	62	0.04	3290	60	0.04	3184
8	62	0.06	2468	60	0.06	2388
10	62	0.07	1974	60	0.07	1910
12	62	0.08	1645	60	0.07	1592
16	62	0.09	1234	60	0.08	1194
20	62	0.10	990	60	0.08	955



CODE: Y400-Y400P-400V-Y400V SLOT MILLING

MATERIAL	Carbon Steel - Cast Iron			Aloy Steel - Tool Steel - СУПЕР СПЛАВ			Steel - СТАЛЬ		
HARDNESS	750/mm2			<30HRC			<40HRC		
Ø	Vc	Fz	RPM	Vc	Fz	RPM	Vc	Fz	RPM
	ap=0.5xd								
3	100	0.02	8500	78	0.03	6350	65	0.02	5850
4	100	0.03	6350	78	0.03	4750	65	0.03	4400
5	100	0.03	5100	78	0.04	3800	65	0.03	3500
6	100	0.04	4250	78	0.04	3200	65	0.06	2900
8	100	0.05	3200	78	0.05	2400	65	0.08	2200
10	100	0.06	2550	78	0.07	1900	65	0.09	1750
12	100	0.07	2100	78	0.07	1600	65	0.10	1450
16	100	0.09	1600	78	0.09	1200	65	0.12	1100
20	100	0.10	1250	78	0.10	955	65	0.12	875

MATERIAL	Steel - СТАЛЬ					
HARDNESS	<45HRC			<50HRC		
Ø	Vc	Fz	RPM	Vc	Fz	RPM
	ap=0.5xd			ap=0.5xd		
3	62	0.02	5500	60	0.02	4450
4	62	0.03	4150	60	0.03	3350
5	62	0.03	3300	60	0.04	2650
6	62	0.04	2750	60	0.05	2250
8	62	0.06	2050	60	0.06	1650
10	62	0.07	1650	60	0.07	1350
12	62	0.08	1400	60	0.09	1100
16	62	0.09	1050	60	0.09	835
20	62	0.10	830	60	0.10	670

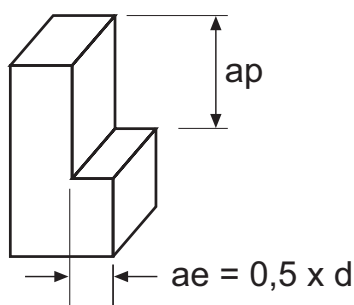


Y400V: +30%

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řezná rychlost



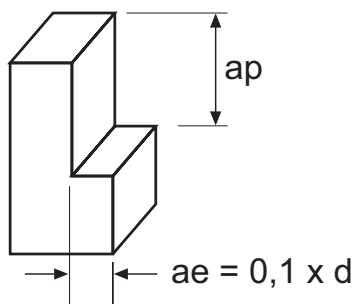
CODE: 400SV - 500RV - 500SV - T2201 ROUGHING

MATERIAL	APPLICATION	VC m/min	ROUGHING								
			FZ mm/tooth								
			Ø 3	Ø 4	Ø 6	Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 20
Construction steel 500 N/mm ²	ap=1xd	170-200	0.024	0.028	0.041	0.058	0.073	0.09	0.1	0.11	0.13
	ap=2xd (ae=0.25xd)	110-130	0.016	0.021	0.027	0.035	0.044	0.052	0.058	0.063	0.08
Construction steel 510-800 N/mm ²	ap=1xd	160-188	0.022	0.026	0.036	0.052	0.066	0.085	0.093	0.1	0.12
	ap=2xd	100-125	0.015	0.02	0.031	0.042	0.05	0.058	0.065	0.071	0.09
Tooling steel 850-1000 N/mm ²	ap=1xd	70-90	0.016	0.021	0.029	0.042	0.053	0.063	0.071	0.079	0.097
	ap=2xd (ae=0.25xd)	80-100	0.01	0.015	0.025	0.032	0.039	0.048	0.053	0.058	0.073
Stainless steel 850 N/mm ²	ap=1xd	95-115	0.019	0.024	0.039	0.053	0.065	0.079	0.087	0.095	0.11
Tooling steel <60 HRC	ap=1xd	45-55	0.015	0.02	0.031	0.042	0.05	0.059	0.065	0.071	0.09
Super Alloy 850-1000 N/mm ²	ap=1xd	150-185	0.019	0.024	0.039	0.053	0.065	0.079	0.087	0.095	0.11
	ap=2xd (ae=0.25xd)	95-120	0.01	0.015	0.027	0.035	0.044	0.052	0.058	0.063	0.08
Super Alloy 1000-1200 N/mm ²	ap=1xd	125-150	0.013	0.02	0.033	0.047	0.059	0.072	0.08	0.088	0.1
	ap=2xd (ae=0.25xd)	80-100	0.01	0.015	0.025	0.032	0.039	0.048	0.052	0.058	0.073
Inconell 1200 N/mm ²	ap=1xd	56-70	0.013	0.02	0.033	0.047	0.059	0.072	0.08	0.088	0.1
Cast iron 240 HB	ap=1xd	220-270	0.022	0.026	0.036	0.052	0.066	0.085	0.093	0.1	0.12
	ap=2xd (ae=0.25xd)	140-170	0.015	0.02	0.031	0.042	0.05	0.058	0.065	0.071	0.09
Cast iron <300 HB	ap=1xd	115-140	0.019	0.024	0.039	0.053	0.065	0.079	0.087	0.095	0.11
	ap=2xd (ae=0.25xd)	130-160	0.01	0.016	0.027	0.064	0.044	0.052	0.058	0.063	0.08
Titanium <850 N/mm ²	ap=1xd	90-110	0.013	0.02	0.033	0.047	0.059	0.072	0.08	0.088	0.1
	ap=2xd (ae=0.25xd)	60-70	0.01	0.015	0.025	0.032	0.039	0.048	0.053	0.058	0.073
Titanium 850-1200 N/mm ²	ap=1xd	75-90	0.016	0.021	0.029	0.042	0.053	0.063	0.071	0.079	0.097
	ap=2xd (ae=0.25xd)	50-60	0.01	0.015	0.024	0.032	0.038	0.046	0.05	0.054	0.066
Aluminium	ap=1xd ap=2xd (ae=0.25xd)	500-650	0.016	0.021	0.029	0.042	0.053	0.063	0.071	0.079	0.097
Copper	ap=1xd	210-260	0.022	0.026	0.036	0.052	0.066	0.085	0.093	0.1	0.12
	ap=2xd (ae=0.25xd)	140-171	0.015	0.02	0.031	0.042	0.05	0.059	0.065	0.071	0.09

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost



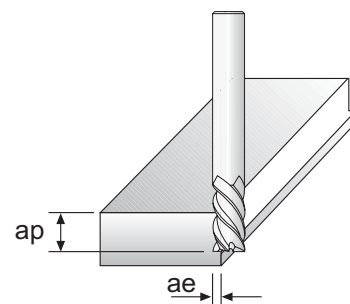
CODE: 400SV - 500SV - 500RV FINISHING

MATERIAL	APPLICATION	VC m/min	FINISHING FZ mm/tooth								
			Ø 3	Ø 4	Ø 6	Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 20
Construction steel 500 N/mm ²	ap=1xd	210-250	0.01	0.015	0.025	0.032	0.039	0.048	0.053	0.058	0.073
	ap=2xd	140-170	0.01	0.015	0.025	0.032	0.039	0.048	0.053	0.058	0.073
Construction steel 510-800 N/mm ²	ap=1xd	190-230	0.013	0.039	0.033	0.047	0.059	0.072	0.08	0.088	0.1
	ap=2xd	125-155	0.01	0.015	0.024	0.032	0.038	0.046	0.05	0.054	0.066
Tooling steel 850-1000 N/mm ²	ap=1xd	160-200	0.015	0.02	0.031	0.042	0.05	0.059	0.065	0.071	0.09
	ap=2xd	100-125	0.004	0.007	0.013	0.019	0.025	0.03	0.034	0.038	0.045
Stainless steel 850 N/mm ²	ap=1xd	70-90	0.016	0.021	0.029	0.042	0.053	0.063	0.071	0.079	0.097
Tempered steel <60 HRC	ap=1xd	60-75	0.007	0.016	0.017	0.024	0.03	0.036	0.041	0.045	0.057
Super Alloy 850-1000 N/mm ²	ap=1xd	180-230	0.016	0.021	0.029	0.042	0.053	0.063	0.071	0.079	0.097
	ap=2xd	120-140	0.007	0.016	0.017	0.024	0.03	0.036	0.041	0.045	0.057
Super Alloy 1000-1200 N/mm ²	ap=1xd	155-190	0.015	0.02	0.031	0.042	0.05	0.059	0.065	0.071	0.09
	ap=2xd	100-125	0.004	0.007	0.013	0.019	0.025	0.03	0.034	0.038	0.045
Inconell	ap=1xd	70-90	0.015	0.02	0.031	0.042	0.05	0.059	0.065	0.071	0.09
Cast iron 240 HB	ap=1xd	255-313	0.013	0.02	0.033	0.047	0.059	0.072	0.08	0.088	0.1
	ap=2xd	180-220	0.01	0.015	0.024	0.032	0.038	0.046	0.05	0.054	0.065
Cast iron <300 HB	ap=1xd	250-313	0.016	0.021	0.029	0.042	0.053	0.063	0.071	0.079	0.097
	ap=2xd	160-200	0.007	0.011	0.017	0.024	0.03	0.036	0.041	0.045	0.057
Titanium <850 N/mm ²	ap=1xd	120-145	0.015	0.02	0.031	0.042	0.05	0.059	0.065	0.071	0.09
	ap=2xd	80-95	0.004	0.007	0.013	0.019	0.025	0.03	0.034	0.038	0.045
Titanium Alloy	ap=1xd	100-120	0.01	0.015	0.027	0.035	0.044	0.052	0.058	0.063	0.08
	ap=2xd	60-75	0.003	0.006	0.011	0.016	0.021	0.026	0.029	0.032	0.038
Aluminium	ap=2xd	600-740	0.015	0.02	0.031	0.042	0.05	0.059	0.065	0.071	0.09
Copper	ap=2xd	180-220	0.01	0.015	0.027	0.035	0.044	0.052	0.058	0.063	0.08

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řezná rychlost



CODE: 506 - Y508 ROUGHING - HIGH SPEED CUTTING

MATERIAL	Steel - СТАЛЬ							
HARDNESS	< HRC 48-60				< HRC 72			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
6	275	0.042	0.033 x d	0.820 x d	125	0.030	0.028 x d	0.750 x d
8	275	0.085	0.033 x d	0.820 x d	125	0.065	0.028 x d	0.750 x d
10	275	0.085	0.033 x d	0.820 x d	125	0.065	0.028 x d	0.750 x d
12	275	0.128	0.033 x d	0.820 x d	125	0.100	0.028 x d	0.750 x d
16	275	0.128	0.033 x d	0.820 x d	125	0.100	0.028 x d	0.750 x d
20	275	0.170	0.033 x d	0.820 x d	125	0.144	0.028 x d	0.750 x d

CODE: 506 - Y508 FINISHING - HIGH SPEED CUTTING

MATERIAL	Steel - СТАЛЬ							
HARDNESS	< HRC 48-60				< HRC 72			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
6	340	0.045	0.020 x d	0.650 x d	140	0.030	0.010 x d	0.450 x d
8	340	0.090	0.020 x d	0.650 x d	140	0.075	0.010 x d	0.450 x d
10	340	0.090	0.020 x d	0.650 x d	140	0.075	0.010 x d	0.450 x d
12	340	0.135	0.020 x d	0.650 x d	140	0.115	0.010 x d	0.450 x d
16	340	0.135	0.020 x d	0.650 x d	140	0.115	0.010 x d	0.450 x d
20	340	0.180	0.020 x d	0.650 x d	140	0.165	0.010 x d	0.450 x d

CODE: T2204

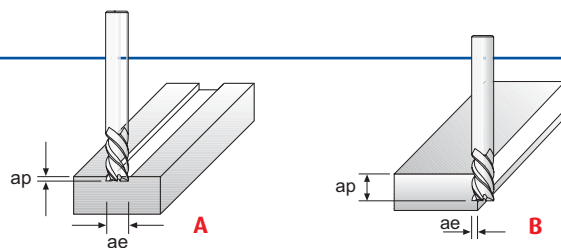
MATERIAL	Hardness	Applications			Vc	Fz(mm/Tooth)						
		Side Milling	Slot Milling	Slot Milling								
	HRC	ap	ae	ap	m/min	Ø 6	Ø 8	Ø 10	Ø 12	Ø 16	Ø 20	Ø 25
Steels СТАЛЬ	35-45	1.5 x d	0.40 x d	0.50 x d	150	0.020	0.025	0.030	0.040	0.050	0.065	0.070
	45-55	1.5 x d	0.33 x d	0.50 x d	110	0.015	0.020	0.025	0.030	0.040	0.050	0.055
	55-60	1.5 x d	0.25 x d	0.30 x d	90	0.010	0.015	0.020	0.025	0.030	0.040	0.045
Titanium ТИТАН	<40	1.5 x d	0.33 x d	0.50 x d	70	0.030	0.035	0.040	0.050	0.070	0.080	0.085
	>40	1.5 x d	0.25 x d	0.30 x d	60	0.025	0.030	0.035	0.045	0.060	0.075	0.080
Cast Iron ЧУГУН	-	1.5 x d	0.20 x d	0.25 x d	30	0.015	0.020	0.025	0.030	0.040	0.050	0.055
Inox	<900N	1.5 x d	0.20 x d	0.30 x d	25	0.014	0.020	0.032	0.044	0.053	0.059	0.065
	>900N	1.5 x d	0.20 x d	0.30 x d	20	0.014	0.020	0.032	0.044	0.053	0.059	0.065

Parametri di taglio

Cutting speed

Richtwerte - Paramètres

Режимы обработки - Řežná rychlost



CODE: 5040 - 5040G - Y5040 - 5040R (A)

MATERIAL	ROUGHING																				
	Fine Grain Graphite					Mean Grain Graphite					Coarse Grain Graphite					Carbon Fibre					
Hardned	Vc	n	Vf	ae	ap	Vc	n	Vf	ae	ap	Vc	n	Vf	ae	ap	Vc	Fz	n	Vf	ae	ap
Ø	m/min	min/°	mm/min	mm	mm	m/min	min/°	mm/min	mm	mm	m/min	min/°	mm/min	mm	mm	m/min	mm	min/°	mm/min	mm	mm
3	520	55202	3900-6500	3	10	780	24841	3900-6500	3	10	1040	33121	3900-6500	3	10	150	0.010	15924	955	3	1.5
4	520	41401	4550-7150	4	10	780	24841	4550-7150	4	10	1040	33121	4550-7150	4	10	150	0.015	11943	1075	4	2.5
5	520	33121	4875-8125	5	10	780	24841	4875-8125	5	10	1040	33121	4875-8125	5	10	150	0.020	9554	1146	5	3.1
6	520	27601	5200-9100	6	20	780	12420	5200-9100	6	20	1040	16561	5200-9100	6	20	150	0.020	7962	955	6	3.7
8	520	20701	5850-10400	8	20	780	12420	5850-10400	8	20	1040	16561	5850-10400	8	20	150	0.025	5971	1200	8	5
10	520	16561	6500-11050	10	25	780	9936	6500-11050	10	25	1040	13248	6500-11050	10	25	150	0.040	4777	1529	10	6.2
12	520	13800	7800-11700	12	30	780	8280	7800-11700	12	30	1040	11040	7800-11700	12	30	150	0.050	3981	1990	12	7.5

CODE: 6010D - 6010RD (A)

MATERIAL	ROUGHING														
	Fine Grain Graphite					Mean Grain Graphite					Coarse Grain Graphite				
Hardned	Vc	n	Vf	ae	ap	Vc	n	Vf	ae	ap	Vc	n	Vf	ae	ap
Ø	m/min	min/°	mm/min	mm	mm	m/min	min/°	mm/min	mm	mm	m/min	min/°	mm/min	mm	mm
3	400	42463	3000-5000	3	10	600	19108	3000-5000	3	10	800	25478	3000-5000	3	10
4	400	31847	3500-5500	4	10	600	19108	3500-5500	4	10	800	25478	3500-5500	4	10
5	400	25478	3750-6250	5	10	600	19108	3750-6250	5	10	800	25478	3750-6250	5	10
6	400	21231	4000-7000	6	20	600	9554	4000-7000	6	20	800	12739	4000-7000	6	20
8	400	15924	4500-8000	8	20	600	9554	4500-8000	8	20	800	12739	4500-8000	8	20
10	400	12739	5000-8500	10	25	600	7643	5000-8500	10	25	800	10191	5000-8500	10	25
12	400	10616	6000-9000	12	30	600	6369	6000-9000	12	30	800	8493	6000-9000	12	30

CODE: Y507 (B)

MATERIAL	SIDE MILLING																							
	Stainless Steel Cr-Ni НЕРЖАВЕЮЩАЯ СТАЛЬ						Stainless Steel Cr-Ni-Mo НЕРЖАВЕЮЩАЯ СТАЛЬ						Super Alloy СУПЕР СПЛАВ						Inconel 718 ИНКОНЕЛЬ					
Hardned	Vc	FZ	n	Vf	ae	ap	Vc	Fz	n	Vf	ae	ap	Vc	Fz	n	Vf	ae	ap	Vc	Fz	n	Vf	ae	ap
Ø	m/min	mm	min/°	mm/min	mm	mm	m/min	mm	min/°	mm/min	mm	mm	m/min	mm	min/°	mm/min	mm	mm	m/min	mm	min/°	mm/min	mm	mm
3	80	0.010	8493	340	1.2	3	40	0.010	4246	170	2.40	3	25	0.010	2654	106	2.4	9	30	0.010	1592	64	2.4	3
4	80	0.015	6369	382	1.6	4	40	0.015	3185	191	2.40	4	25	0.015	1990	119	3.2	12	30	0.015	1194	72	2.4	4
6	80	0.020	4246	510	2.4	6	40	0.020	2123	255	2.40	6	25	0.020	1327	159	2.4	12	30	0.020	796	96	2.4	6
8	80	0.030	3185	573	3.2	8	40	0.030	1592	287	3.20	8	25	0.030	995	179	3.2	12	30	0.030	597	107	3.2	8
10	80	0.035	2548	713	4.0	10	40	0.035	1274	357	4.00	10	25	0.035	796	223	4.0	15	30	0.035	478	134	4.0	10
12	80	0.040	2123	679	4.8	12	40	0.040	1062	340	4.80	12	25	0.040	663	212	4.8	18	30	0.040	398	127	4.8	12
16	80	0.065	1592	828	3.2	16	40	0.065	796	518	6.40	16	25	0.065	498	323	6.4	24	30	0.065	299	194	6.4	16
20	80	0.070	1274	713	3.2	20	40	0.070	637	446	6.40	20	25	0.070	398	279	6.4	24	30	0.070	239	167	6.4	20
25	80	0.080	1019	652	3.2	25	40	0.080	510	408	6.40	25	25	0.080	318	255	6.4	24	30	0.080	191	153	6.4	25

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: 200G - 200GD - 200GRD - 300GD - 300GRD - 200GRL ROUGHING

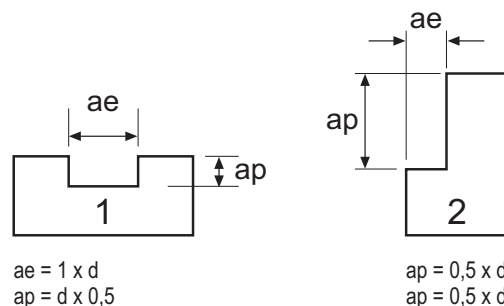
Ø	FZ mm/tooth		N = RPM											
			8000		15000		24000		30000		36000		45000	
	1	2	1	2	1	2	1	2	1	2	1	2	1	2
0.4	0.004	0.005	-	-	-	-	-	-	240	300	288	360	360	450
0.5	0.005	0.007	-	-	-	-	240	316	300	420	360	504	450	630
0.6	0.006	0.008	-	-	-	-	288	384	360	480	432	576	540	720
0.8	0.008	0.010	-	-	240	300	384	480	480	600	576	720	720	900
1.0	0.010	0.012	-	-	300	360	480	576	600	720	720	864	900	1.080
1.2	0.012	0.015	-	-	360	450	576	720	720	900	864	1.080	1.080	1.350
1.5	0.014	0.018	224	288	420	540	672	864	840	1.080	1.080	1.296	1.260	1.620
2.0	0.016	0.020	256	320	480	600	768	960	960	1.200	1.152	1.440	1.440	1.800
3.0	0.024	0.025	384	400	720	750	1.152	1.200	1.440	1.500	1.728	1.800	2.160	2.250
4.0	0.032	0.040	512	640	960	960	1.536	1.920	1.920	2.400	2.300	2.880	2.880	3.600
5.0	0.040	0.050	640	800	1.200	1.500	1.920	2.400	2.400	3.000	2.880	3.600	3.600	4.500
6.0	0.048	0.065	768	1.040	1.440	1.950	2.304	3.120	2.880	3.900	2.456	4.680	4.320	5.850
8.0	0.064	0.080	1.024	1.280	1.920	2.400	3.072	3.840	3.840	4.800	4.608	5.760	5.760	7.200
10.0	0.080	0.100	1.280	1.600	2.400	3.000	3.840	4.800	4.800	6.000	5.760	7.200	7.200	-
12.0	0.100	0.120	1.600	1.920	3.000	3.600	4.800	5.760	6.000	7.200	7.200	-	-	-

CODE: 200G - 200GD - 200GRD - 300GD - 300GRD - 200GRL FINISHING

Ø	FZ mm/tooth	N = RPM					
		8000	15000	24000	30000	36000	45000
		VF	VF	VF	VF	VF	VF
0.4	0.006	-	-	-	360	432	540
0.5	0.008	-	-	384	480	576	720
0.6	0.010	-	-	480	600	720	900
0.8	0.012	-	360	576	720	864	1.080
1.0	0.015	-	450	720	900	1.080	1.350
1.2	0.018	-	540	864	1.080	1.296	1.620
1.5	0.020	320	600	960	1.200	1.440	1.800
2.0	0.025	400	750	1.200	1.500	1.800	2.250
3.0	0.035	560	1.050	1.680	2.100	2.520	3.150
4.0	0.050	800	1.500	2.400	3.000	3.600	4.500
5.0	0.060	960	1.800	2.880	3.600	4.320	5.400
6.0	0.070	1.120	2.100	3.360	4.200	5.040	6.300
8.0	0.085	1.360	2.550	4.080	5.100	6.120	7.650
10.0	0.110	1.760	3.300	5.280	6.600	-	-
12.0	0.130	2.080	3.900	6.240	7.800	-	-

CODE: 204GD - 204GRD

MATERIAL	Graphyte - ГРАФИТ		
HARDNESS			
Ø	VC	FZ	ap
0.4 - 0.8	300-500	0.01-0.03	0.01-0.30
1 - 2	300-500	0.02-0.08	0.10-0.50
3 - 4	300-500	0.04-0.10	0.15-1.00
5 - 6	300-500	0.06-0.15	0.20-1.50

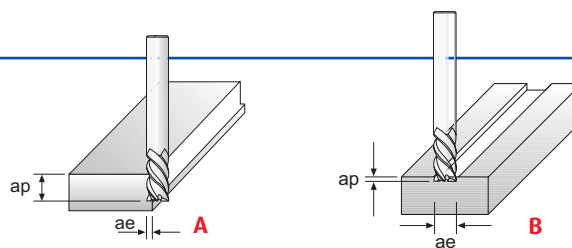


Parametri di taglio

Cutting speed

Richtwerte - Paramètres

Режимы обработки - Řežná rychlost



CODE: 100 - 700 - 730 - 750

	Side Milling A						Slot Milling B					
MATERIAL	Aluminium Alloy - АЛЮМИНИЙ						Aluminium Alloy - АЛЮМИНИЙ					
HARDNESS												
Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
3	250	0.030	26539	1592	0.80	4.5	150	0.020	15924	637	3	2
4	250	0.040	19904	1592	1.00	6.0	150	0.030	11943	717	4	2
5	250	0.050	15924	1592	1.30	7.5	150	0.035	9554	669	5	3
6	250	0.060	13270	1592	1.50	9.0	150	0.045	7962	717	6	3
8	250	0.080	9952	1592	2.00	12.0	150	0.055	5971	657	8	4
10	250	0.100	7962	1592	2.50	15.0	150	0.070	4777	669	10	5
12	250	0.120	6635	1592	3.00	18.0	150	0.085	3981	677	12	6
16	250	0.130	4976	1294	4.00	24.0	150	0.115	2986	687	16	8
20	250	0.150	3981	1194	5.00	30.0	150	0.145	2389	693	20	10

CODE: 755

	Slot Milling B						
MATERIAL	Aluminium Alloy - АЛЮМИНИЙ						
HARDNESS							
Ø	Vc m/min	Fz mm	n min/°	Vf Min. mm/min	Vf Max mm/min	ae mm	ap mm
3	200	0.024	21231	1000	1200	3.0	3.0
4	250	0.025	19904	1000	1200	4.0	4.0
5	300	0.026	19108	1000	1200	5.0	5.0
6	400	0.066	21231	2800	4000	6.0	6.0
8	400	0.094	15924	3000	4000	8.0	8.0
10	400	0.141	12739	3600	4500	10.0	10.0
12	400	0.170	10616	3600	4500	12.0	12.0
16	450	0.201	8957	3600	4500	16.0	16.0
20	450	0.223	7166	3200	4300	20.0	20.0

CODE: 300V - 456

	Side Milling A						Slot Milling B					
MATERIAL	Aluminium Alloy - АЛЮМИНИЙ						Aluminium Alloy - АЛЮМИНИЙ					
HARDNESS												
Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
3	550	0.045	58400	7880	1.20	3.6	450	0.030	47800	4300	3	1
4	550	0.060	43770	7880	1.60	4.8	450	0.040	35900	4300	4	2
5	550	0.075	35015	7880	2.00	6.0	450	0.055	28700	4725	5	2
6	550	0.100	29200	8760	2.40	7.2	450	0.070	23900	5015	6	2
8	550	0.120	21900	7890	3.20	9.6	450	0.085	17900	4656	8	3
10	550	0.150	17510	7890	4.00	12.0	450	0.105	14300	4510	10	4
12	550	0.180	14600	7890	4.80	14.4	450	0.125	11940	4475	12	5
16	550	0.190	10950	6235	6.40	19.2	450	0.135	9000	3625	16	6
20	550	0.225	8760	5900	8.00	24.0	450	0.160	7160	3435	20	8

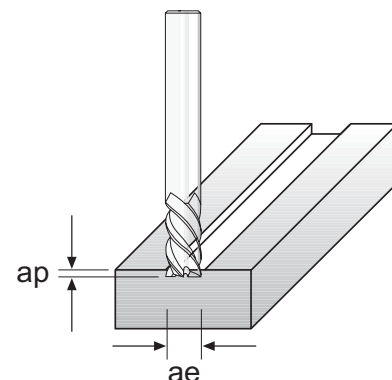
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řezná rychlost

CODE: Y700R - Y703 ROUGHING HIGH SPEED CUTTING

MATERIAL	Aluminium - АЛЮМИНИЙ				Copper - МЕДЬ			
HARDNESS								
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	500	0.021	1 x d	0.5 x d	300	0.015	1 x d	0.5 x d
4	500	0.028	1 x d	0.5 x d	300	0.016	1 x d	0.5 x d
5	500	0.035	1 x d	0.5 x d	300	0.020	1 x d	0.5 x d
6	500	0.045	1 x d	0.5 x d	300	0.024	1 x d	0.5 x d
8	500	0.056	1 x d	0.5 x d	300	0.032	1 x d	0.5 x d
10	500	0.070	1 x d	0.5 x d	300	0.040	1 x d	0.5 x d
12	500	0.084	1 x d	0.5 x d	300	0.048	1 x d	0.5 x d
16	500	0.112	1 x d	0.5 x d	300	0.064	1 x d	0.5 x d



CODE: Y700R - Y703 ROUGHING HIGH SPEED CUTTING

MATERIAL	Thermo Plastic - ТЕРМО ПЛАСТИК							
HARDNESS	Soft				Harder			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	500	0.021	1 x d	0.5 x d	300	0.013	1 x d	0.5 x d
4	500	0.028	1 x d	0.5 x d	300	0.020	1 x d	0.5 x d
5	500	0.033	1 x d	0.5 x d	300	0.026	1 x d	0.5 x d
6	500	0.042	1 x d	0.5 x d	300	0.030	1 x d	0.5 x d
8	500	0.056	1 x d	0.5 x d	300	0.040	1 x d	0.5 x d
10	500	0.060	1 x d	0.5 x d	300	0.051	1 x d	0.5 x d
12	500	0.084	1 x d	0.5 x d	300	0.060	1 x d	0.5 x d
16	500	0.112	1 x d	0.5 x d	300	0.075	1 x d	0.5 x d

Y703: +30%

CODE: Y700R - Y703 FINISHING HIGH SPEED CUTTING

MATERIAL	Aluminium - АЛЮМИНИЙ				Copper - МЕДЬ			
HARDNESS								
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	500	0.021	1 x d	0.050 x d	300	0.015	1 x d	0.030 x d
4	500	0.028	1 x d	0.050 x d	300	0.016	1 x d	0.030 x d
5	500	0.035	1 x d	0.050 x d	300	0.020	1 x d	0.030 x d
6	500	0.045	1 x d	0.050 x d	300	0.024	1 x d	0.030 x d
8	500	0.056	1 x d	0.050 x d	300	0.032	1 x d	0.030 x d
10	500	0.070	1 x d	0.050 x d	300	0.040	1 x d	0.030 x d
12	500	0.084	1 x d	0.050 x d	300	0.048	1 x d	0.030 x d
16	500	0.112	1 x d	0.050 x d	300	0.064	1 x d	0.030 x d

CODE: Y700R - Y703 FINISHING HIGH SPEED CUTTING

MATERIAL	Thermo Plastic - ТЕРМО ПЛАСТИК							
HARDNESS	Soft				Harder			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	500	0.021	1 x d	0.030 x d	300	0.013	1 x d	0.020 x d
4	500	0.028	1 x d	0.030 x d	300	0.016	1 x d	0.020 x d
5	500	0.035	1 x d	0.030 x d	300	0.020	1 x d	0.020 x d
6	500	0.045	1 x d	0.030 x d	300	0.024	1 x d	0.020 x d
8	500	0.056	1 x d	0.030 x d	300	0.032	1 x d	0.020 x d
10	500	0.070	1 x d	0.030 x d	300	0.040	1 x d	0.020 x d
12	500	0.084	1 x d	0.030 x d	300	0.048	1 x d	0.020 x d
16	500	0.128	1 x d	0.030 x d	300	0.064	1 x d	0.020 x d

Y703: +30%

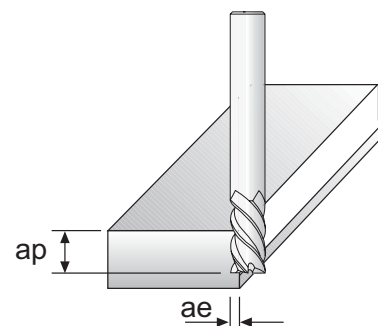
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: Y700R ROUGHING HIGH SPEED CUTTING

MATERIAL	Aluminium - АЛЮМИНИЙ				Copper - МЕДЬ			
HARDNESS								
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	500	0.045	0.250 x d	1 x d	300	0.030	0.150 x d	1 x d
4	500	0.057	0.250 x d	1 x d	300	0.038	0.150 x d	1 x d
5	500	0.075	0.250 x d	1 x d	300	0.050	0.150 x d	1 x d
6	500	0.109	0.250 x d	1 x d	300	0.060	0.150 x d	1 x d
8	500	0.120	0.250 x d	1 x d	300	0.076	0.150 x d	1 x d
10	500	0.150	0.250 x d	1 x d	300	0.100	0.150 x d	1 x d
12	500	0.160	0.250 x d	1 x d	300	0.120	0.150 x d	1 x d
16	500	0.240	0.250 x d	1 x d	300	0.140	0.150 x d	1 x d



CODE: Y700R ROUGHING HIGH SPEED CUTTING

MATERIAL	Thermo Plastic - ТЕРМО ПЛАСТИК							
HARDNESS					Harder			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	500	0.045	0.080 x d	1 x d	300	0.036	0.020 x d	1 x d
4	500	0.060	0.080 x d	1 x d	300	0.048	0.020 x d	1 x d
5	500	0.075	0.080 x d	1 x d	300	0.060	0.020 x d	1 x d
6	500	0.090	0.080 x d	1 x d	300	0.072	0.020 x d	1 x d
8	500	0.120	0.080 x d	1 x d	300	0.096	0.020 x d	1 x d
10	500	0.150	0.080 x d	1 x d	300	0.120	0.020 x d	1 x d
12	500	0.180	0.080 x d	1 x d	300	0.144	0.020 x d	1 x d
16	500	0.200	0.080 x d	1 x d	300	0.168	0.020 x d	1 x d

CODE: Y700R FINISHING HIGH SPEED CUTTING

MATERIAL	Aluminium - АЛЮМИНИЙ				Copper - МЕДЬ			
HARDNESS								
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	500	0.045	0.050 x d	0.820 x d	300	0.030	0.040 x d	1.750 x d
4	500	0.060	0.050 x d	0.820 x d	300	0.040	0.040 x d	1.750 x d
5	500	0.075	0.050 x d	0.820 x d	300	0.050	0.040 x d	1.750 x d
6	500	0.109	0.050 x d	0.820 x d	300	0.060	0.040 x d	1.750 x d
8	500	0.120	0.050 x d	0.820 x d	300	0.080	0.040 x d	1.750 x d
10	500	0.150	0.050 x d	0.820 x d	300	0.100	0.040 x d	1.750 x d
12	500	0.160	0.050 x d	0.820 x d	300	0.120	0.040 x d	1.750 x d
16	500	0.240	0.050 x d	0.820 x d	300	0.140	0.040 x d	1.750 x d

CODE: Y700R FINISHING HIGH SPEED CUTTING

MATERIAL	Thermo Plastic - ТЕРМО ПЛАСТИК							
HARDNESS	Soft				Harder			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	500	0.045	0.040 x d	0.630 x d	300	0.030	0.010 x d	0.320 x d
4	500	0.060	0.040 x d	0.630 x d	300	0.038	0.010 x d	0.320 x d
5	500	0.075	0.040 x d	0.630 x d	300	0.050	0.010 x d	0.320 x d
6	500	0.109	0.040 x d	0.630 x d	300	0.060	0.010 x d	0.320 x d
8	500	0.120	0.040 x d	0.630 x d	300	0.075	0.010 x d	0.320 x d
10	500	0.150	0.040 x d	0.630 x d	300	0.100	0.010 x d	0.320 x d
12	500	0.160	0.040 x d	0.630 x d	300	0.110	0.010 x d	0.320 x d
16	500	0.240	0.040 x d	0.630 x d	300	0.140	0.010 x d	0.320 x d

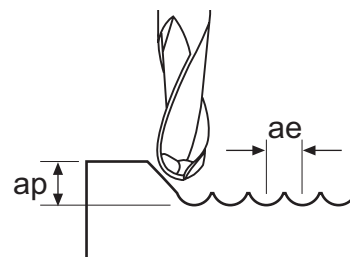
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řezná rychlost

CODE: 700SR ROUGHING STANDARD CUTTING SPEED

MATERIAL	Steel - СТАЛЬ				Aluminium - АЛЮМИНИЙ			
HARDNESS								
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
1 - 3	140	0.016	0.03 x d	0.03 x d	Max	0.021	0.30 x d	0.03 x d
4	140	0.032	0.03 x d	0.03 x d	Max	0.042	0.30 x d	0.03 x d
6	140	0.032	0.03 x d	0.03 x d	Max	0.042	0.30 x d	0.03 x d
8	140	0.064	0.03 x d	0.03 x d	Max	0.084	0.30 x d	0.03 x d
10	140	0.064	0.03 x d	0.03 x d	Max	0.084	0.30 x d	0.03 x d
12 - 18	140	0.096	0.03 x d	0.03 x d	Max	0.126	0.30 x d	0.03 x d
20 - 25	140	0.160	0.03 x d	0.03 x d	Max	0.210	0.30 x d	0.03 x d



CODE: 700SR

MATERIAL	Copper - МЕДЬ				Titanium - ТИТАН			
HARDNESS								
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
1 - 3	350	0.020	0.03 x d	0.03 x d	90	0.014	0.30 x d	0.03 x d
4	350	0.040	0.03 x d	0.03 x d	90	0.028	0.30 x d	0.03 x d
6	350	0.040	0.03 x d	0.03 x d	90	0.028	0.30 x d	0.03 x d
8	350	0.080	0.03 x d	0.03 x d	90	0.057	0.30 x d	0.03 x d
10	350	0.080	0.03 x d	0.03 x d	90	0.057	0.30 x d	0.03 x d
12 - 18	350	0.120	0.03 x d	0.03 x d	90	0.085	0.30 x d	0.03 x d
20 - 25	350	0.200	0.03 x d	0.03 x d	90	0.142	0.30 x d	0.03 x d

For finishing:
 $ae < 0,02 - 0,03 \times d$
 $ap < 0,8 \times d$
 $Vc = 1,2 \times Vc$ (Parameter List)
 $Fz = 0,7 \times Vc$ (Parameter List)

CODE: 700SR

MATERIAL	Super Alloy - СУПЕР СПЛАВ								Thermo Plastic - ТЕРМО ПЛАСТИК			
HARDNESS									Harder			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
1 - 3	40	0.015	0.03 x d	0.03 x d	350	0.020	0.03 x d	0.03 x d	170	0.008	0.03 x d	0.03 x d
4	40	0.030	0.03 x d	0.03 x d	350	0.040	0.03 x d	0.03 x d	170	0.016	0.03 x d	0.03 x d
6	40	0.030	0.03 x d	0.03 x d	350	0.040	0.03 x d	0.03 x d	170	0.016	0.03 x d	0.03 x d
8	40	0.060	0.03 x d	0.03 x d	350	0.080	0.03 x d	0.03 x d	170	0.031	0.03 x d	0.03 x d
10	40	0.060	0.03 x d	0.03 x d	350	0.080	0.03 x d	0.03 x d	170	0.031	0.03 x d	0.03 x d
12 - 18	40	0.090	0.03 x d	0.03 x d	350	0.120	0.03 x d	0.03 x d	170	0.047	0.03 x d	0.03 x d
20 - 25	40	0.150	0.03 x d	0.03 x d	350	0.200	0.03 x d	0.03 x d	170	0.078	0.03 x d	0.03 x d

HSC

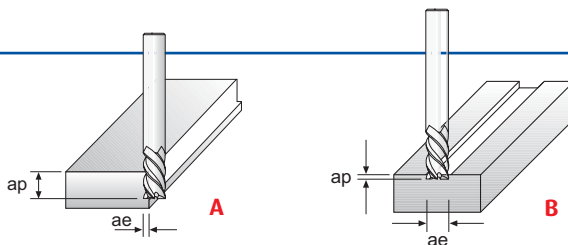
= Standard Cutting Speed X 1,4

Parametri di taglio

Cutting speed

Richtwerte - Paramètres

Режимы обработки - Řežná rychlost



CODE: 756

MATERIAL	Side Milling A						Slot Milling B					
	Aluminium Alloy - АЛЮМИНИЙ						Aluminium Alloy - АЛЮМИНИЙ					
HARDNESS Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
6	400	0.095	21231	6051	1.50	3.6	500	0.110	26539	8758	0.35	0.35
8	400	0.130	15924	6210	2.00	4.8	500	0.145	19904	8658	0.40	0.40
10	400	0.160	12739	6115	2.50	6.0	500	0.180	15924	8599	0.45	0.45
12	400	0.175	10616	5573	3.00	7.2	500	0.240	13270	9554	0.50	0.50
16	400	0.195	7962	4658	4.00	9.6	500	0.320	9952	9554	0.60	0.60
20	400	0.230	6369	4395	5.00	12.0	500	0.400	7962	9554	0.75	0.75

CODE: T2202

MATERIAL	Side Milling A											
	Aluminium Alloy - АЛЮМИНИЙ						Copper - МЕДЬ					
HARDNESS Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
6	600	0.070	31847	6688	2.4	9.0	400	0.070	21231	4459	2.4	9.0
8	600	0.090	23885	6449	3.2	12.0	400	0.090	15924	4299	3.2	12.0
10	600	0.110	19108	6306	4.0	15.0	400	0.110	12739	4299	4.0	15.0
12	600	0.135	15924	6449	4.8	18.0	400	0.135	10616	4299	4.8	18.0
16	600	0.180	11943	6449	6.4	24.0	400	0.180	7962	4299	6.4	24.0
20	600	0.220	9554	6306	8.0	30.0	400	0.220	6369	4299	8.0	30.0

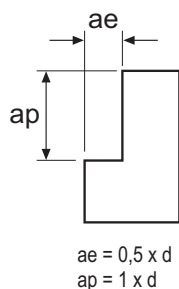
CODE: T2202

MATERIAL	Slot Milling B											
	Aluminium Alloy - АЛЮМИНИЙ						Copper - МЕДЬ					
HARDNESS Ø	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm	Vc m/min	Fz mm	n min/°	Vf mm/min	ae mm	ap mm
6	500	0.060	26539	4777	6	4.8	270	0.060	14331	2580	6	4.8
8	500	0.080	19904	4777	8	6.4	270	0.080	10748	2580	8	6.4
10	500	0.100	15924	4777	10	8.0	270	0.100	8599	2580	10	8.0
12	500	0.120	13270	4777	12	9.6	270	0.120	7166	2580	12	9.6
16	500	0.160	9952	4777	16	12.8	270	0.160	5374	2580	16	12.8
20	500	0.200	7962	4777	20	16.0	270	0.200	4299	2580	20	16.0

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost



CODE: T2000 - T2200 - T2203 - T3000 - T4000 - 451 - 452 - 454 - 455

MATERIAL	HARDNESS	Ø									
		Ø 3.0		Ø 4.0		Ø 5.0		Ø 6.0		Ø 8.0	
		Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
Non Alloy Steel	< 500 N/mm	80-140	0.023	80-140	0.023	80-140	0.033	80-140	0.033	80-140	0.045
	< 700 N/mm	70-120	0.023	120	0.023	120	0.033	120	0.033	120	0.045
	< 800 N/mm	70-120	0.023	70-120	0.023	70-120	0.033	70-120	0.033	70-120	0.045
Alloy Steel	< 1000 N/mm	50-85	0.014	50-85	0.014	80-85	0.022	50-85	0.022	50-85	0.280
	< 1200 N/mm	40-70	0.013	40-70	0.013	40-70	0.020	40-70	0.020	40-70	0.025
High Alloy Steel	< 1000 N/mm	50-85	0.014	50-85	0.014	80-85	0.022	50-85	0.022	50-85	0.280
	< 1200 N/mm	40-70	0.013	40-70	0.013	40-70	0.020	40-70	0.020	40-70	0.025
Steel	< 50 HRC	35-45	0.013	35-45	0.013	35-45	0.015	35-45	0.015	35-45	0.015
	< 65 HRC	30-40	0.010	30-40	0.010	30-40	0.012	30-40	0.012	30-40	0.012
Stainless Steel	< 700 HRC	55-90	0.015	55-90	0.015	55-90	0.025	55-90	0.025	55-90	0.030
	< 850 HRC	45-85	0.012	45-85	0.012	45-85	0.017	45-85	0.017	45-85	0.025
Cast Iron	< 180 HB	70-130	0.010	70-130	0.020	70-130	0.030	70-130	0.030	70-130	0.040
	< 180 HB	60-100	0.010	60-100	0.020	60-100	0.030	60-100	0.030	60-100	0.040
Titanium		55-75	0.008	55-75	0.016	55-75	0.024	55-75	0.024	55-75	0.032
Inconel		50-70	0.090	50-70	0.090	50-70	0.015	50-70	0.015	50-70	0.015
Graphyte		100-200	0.014	100-200	0.014	100-200	0.014	100-200	0.028	100-200	0.056

CODE: T2000 - T2200 - T2203 - T3000 - T4000 - 451 - 452 - 454 - 455

MATERIAL	HARDNESS	Ø							
		Ø 10.0		Ø 12.0		Ø 14 - 16		Ø 18 - 20	
		Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
Non Alloy Steel	< 500 N/mm	80-140	0.060	80-140	0.080	80-140	0.100	80-140	0.120
	< 700 N/mm	120	0.060	120	0.080	120	0.100	120	0.120
	< 850 N/mm	70-120	0.060	70-120	0.080	70-120	0.100	70-120	0.120
Alloy Steel	< 1000 N/mm	50-85	0.035	50-85	0.045	50-85	0.060	50-85	0.080
	< 1200 N/mm	40-70	0.030	40-70	0.040	40-70	0.055	40-70	0.065
High Alloy Steel	< 1000 N/mm	50-85	0.035	50-85	0.045	50-85	0.060	50-85	0.080
	< 1200 N/mm	40-70	0.030	40-70	0.040	40-70	0.055	40-70	0.065
Steel	< 50 HRC	35-45	0.030	35-45	0.030	35-45	0.040	35-45	0.065
	< 65 HRC	30-40	0.020	30-40	0.020	30-40	0.030	30-40	0.050
Stainless Steel	< 700 HRC	55-90	0.040	55-90	0.050	55-90	0.055	55-90	0.090
	< 850 HRC	45-85	0.032	45-85	0.045	45-85	0.060	45-85	0.075
Cast Iron	< 180 HB	70-130	0.050	70-130	0.060	70-130	0.080	70-130	0.100
	< 180 HB	60-100	0.050	60-100	0.060	60-100	0.080	60-100	0.100
Titanium		55-75	0.040	55-75	0.050	55-75	0.060	55-75	0.070
Inconel		50-70	0.030	50-70	0.030	50-70	0.050	50-70	0.060
Graphyte		100-200	0.056	100-200	0.084	100-200	0.084	100-200	0.140

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řezná rychlost

CODE: 900T - 910 - 910T

MATERIAL	CUTTING SPEED V _c = m/mm	FEED fz = mm per tooth				
		Ø 1 ÷ 4	Ø 4 ÷ 8	Ø 8 ÷ 12	Ø 12 ÷ 16	Ø 16 ÷ 20
Non alloy steel	15 ÷ 22	0.12	0.16	0.25	0.30	0.35
	10 ÷ 18	0.10	0.13	0.20	0.25	0.30
	8 ÷ 15	0.10	0.15	0.16	0.20	0.25
Alloy steel	6 ÷ 12	0.07	0.10	0.13	0.15	0.25
	5 ÷ 10	0.05	0.08	0.10	0.13	0.15
Heat resistant steels	5 ÷ 10	0.03	0.05	0.08	0.10	0.12
Stainless steel	8 ÷ 12	0.04	0.06	0.08	0.10	0.12
Cast Iron	8 ÷ 12	0.20	0.25	0.30	0.35	0.40
	10 ÷ 14	0.20	0.25	0.30	0.30	0.35
Aluminium and other non-ferrous materials	18 ÷ 30	0.20	0.30	0.35	0.40	0.50

CODE: CTK - CTK.R

MATERIAL	VC	FZ				
		Ø 3-4	Ø 5-8	Ø 10-12	Ø 13-25	Ø 26-40
Steel <500 N/mm	40 - 80	0.012	0.015	0.020	0.020	0.020
Steel <800 N/mm	40 - 80	0.012	0.015	0.020	0.020	0.020
Steel >800 N/mm	30 - 50	0.012	0.013	0.017	0.017	0.017
Stainless steel	30 - 50	0.010	0.010	0.015	0.015	0.015
Inconell	25 - 40	0.010	0.010	0.015	0.015	0.015
Titanium	20 - 40	0.010	0.010	0.015	0.015	0.015
Cast Iron	20 - 50	0.012	0.013	0.012	0.012	0.016
Steel	20 - 50	0.012	0.013	0.013	0.013	0.015
Alluminium	70 - 150	0.012	0.015	0.020	0.020	0.025
Brass, Bronze, Copper, Plastic	60 - 100	0.012	0.015	0.060	0.120	0.160

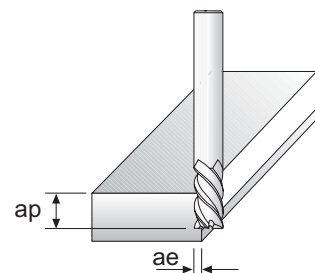
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řezná rychlost

CODE: 5010 - 5020 - 5030 ROUGHING HIGH SPEED CUTTING

MATERIAL	Construction Steel - КОНСТРУКЦИОННАЯ СТАЛЬ							
HARDNESS	< 500 N/mm2				< 850 N/mm2			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	100	0.032	0.1 x d	1.5 x d	90	0.032	0.1 x d	1.5 x d
	190	0.032	0.1 x d	1.5 x d	170	0.032	0.1 x d	1.5 x d
4	100	0.032	0.1 x d	1.5 x d	90	0.032	0.1 x d	1.5 x d
	190	0.032	0.1 x d	1.5 x d	170	0.032	0.1 x d	1.5 x d
5	100	0.054	0.1 x d	1.5 x d	90	0.054	0.1 x d	1.5 x d
	190	0.054	0.1 x d	1.5 x d	170	0.054	0.1 x d	1.5 x d
6	100	0.054	0.1 x d	1.5 x d	90	0.054	0.1 x d	1.5 x d
	190	0.054	0.1 x d	1.5 x d	170	0.054	0.1 x d	1.5 x d
8	100	0.063	0.1 x d	1.5 x d	90	0.063	0.1 x d	1.5 x d
	190	0.063	0.1 x d	1.5 x d	170	0.063	0.1 x d	1.5 x d
10	100	0.072	0.1 x d	1.5 x d	90	0.072	0.1 x d	1.5 x d
	190	0.072	0.1 x d	1.5 x d	170	0.072	0.1 x d	1.5 x d
12	100	0.080	0.1 x d	1.5 x d	90	0.080	0.1 x d	1.5 x d
	190	0.080	0.1 x d	1.5 x d	170	0.080	0.1 x d	1.5 x d



CODE: 5010 - 5020 - 5030

MATERIAL	Tooling Steel - ИНСТРУМЕНТАЛЬНАЯ СТАЛЬ				Steel - СТАЛЬ			
HARDNESS	1100-1400 N/mm2				HRC 48-45			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	45	0.020	0.1 x d	1.5 x d	25	0.020	0.1 x d	1.5 x d
	85	0.020	0.1 x d	1.5 x d	65	0.020	0.1 x d	1.5 x d
4	45	0.020	0.1 x d	1.5 x d	25	0.020	0.1 x d	1.5 x d
	85	0.020	0.1 x d	1.5 x d	65	0.020	0.1 x d	1.5 x d
5	45	0.030	0.1 x d	1.5 x d	25	0.030	0.1 x d	1.5 x d
	85	0.030	0.1 x d	1.5 x d	65	0.030	0.1 x d	1.5 x d
6	45	0.030	0.1 x d	1.5 x d	25	0.030	0.1 x d	1.5 x d
	85	0.030	0.1 x d	1.5 x d	65	0.030	0.1 x d	1.5 x d
8	45	0.040	0.1 x d	1.5 x d	25	0.040	0.1 x d	1.5 x d
	85	0.040	0.1 x d	1.5 x d	65	0.040	0.1 x d	1.5 x d
10	45	0.050	0.1 x d	1.5 x d	25	0.050	0.1 x d	1.5 x d
	85	0.050	0.1 x d	1.5 x d	65	0.050	0.1 x d	1.5 x d
12	45	0.060	0.1 x d	1.5 x d	25	0.060	0.1 x d	1.5 x d
	85	0.060	0.1 x d	1.5 x d	65	0.060	0.1 x d	1.5 x d

MATERIAL	Steel - СТАЛЬ								Graphite/Carbon Fibre/Glass Fibre			
HARDNESS	HRC 55-60				HRC 60-70							
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	50	0.016	0.1 x d	1.5 x d	30	0.012	0.1 x d	1.5 x d	90	0.020	0.1 x d	1.5 x d
									150	0.020	0.1 x d	1.5 x d
4	50	0.016	0.1 x d	1.5 x d	30	0.012	0.1 x d	1.5 x d	90	0.020	0.1 x d	1.5 x d
									150	0.020	0.1 x d	1.5 x d
5	50	0.023	0.1 x d	1.5 x d	30	0.018	0.1 x d	1.5 x d	90	0.027	0.1 x d	1.5 x d
									150	0.027	0.1 x d	1.5 x d
6	50	0.023	0.1 x d	1.5 x d	30	0.018	0.1 x d	1.5 x d	90	0.027	0.1 x d	1.5 x d
									150	0.027	0.1 x d	1.5 x d
8	50	0.030	0.1 x d	1.5 x d	30	0.025	0.1 x d	1.5 x d	90	0.054	0.1 x d	1.5 x d
									150	0.054	0.1 x d	1.5 x d
10	50	0.038	0.1 x d	1.5 x d	30	0.030	0.1 x d	1.5 x d	90	0.072	0.1 x d	1.5 x d
									150	0.072	0.1 x d	1.5 x d
12	50	0.045	0.1 x d	1.5 x d	30	0.038	0.1 x d	1.5 x d	90	0.089	0.1 x d	1.5 x d
									150	0.089	0.1 x d	1.5 x d

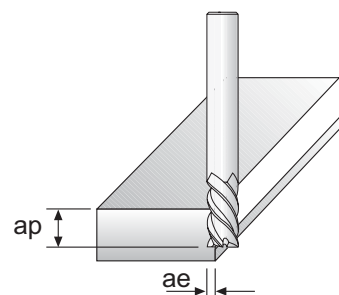
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: 300 - 300T - 450 - 450T - 453 - 500 - 500T

MATERIAL	Aluminium - АЛЮМИНИЙ				Copper - МЕДЬ			
HARDNESS								
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	Max	0.018	0.4 x d	1 x d	300	0.016	0.3 x d	1 x d
4	Max	0.036	0.4 x d	1 x d	300	0.032	0.3 x d	1 x d
5	Max	0.036	0.4 x d	1 x d	300	0.032	0.3 x d	1 x d
6	Max	0.036	0.4 x d	1 x d	300	0.032	0.3 x d	1 x d
8	Max	0.072	0.4 x d	1 x d	300	0.064	0.3 x d	1 x d
10	Max	0.072	0.4 x d	1 x d	300	0.064	0.3 x d	1 x d
12	Max	0.108	0.4 x d	1 x d	300	0.096	0.3 x d	1 x d
14 - 18	Max	0.108	0.4 x d	1 x d	300	0.096	0.3 x d	1 x d
20 - 25	Max	0.180	0.4 x d	1 x d	300	0.160	0.3 x d	1 x d



CODE: 410 - 450 - 450T - 453 - 500 - 500T

MATERIAL	Titanium - ТИТАН				Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ			
HARDNESS								
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	80	0.011	0.1 x d	1 x d	70	0.012	0.1 x d	1 x d
4	80	0.023	0.1 x d	1 x d	70	0.024	0.1 x d	1 x d
5	80	0.023	0.1 x d	1 x d	70	0.024	0.1 x d	1 x d
6	80	0.023	0.1 x d	1 x d	70	0.024	0.1 x d	1 x d
8	80	0.046	0.1 x d	1 x d	70	0.047	0.1 x d	1 x d
10	80	0.046	0.1 x d	1 x d	70	0.047	0.1 x d	1 x d
12	80	0.068	0.1 x d	1 x d	70	0.071	0.1 x d	1 x d
14 - 18	80	0.068	0.1 x d	1 x d	70	0.071	0.1 x d	1 x d
20 - 25	80	0.114	0.1 x d	1 x d	70	0.118	0.1 x d	1 x d

CODE: 450 - 450T - 453 - 500 - 500T

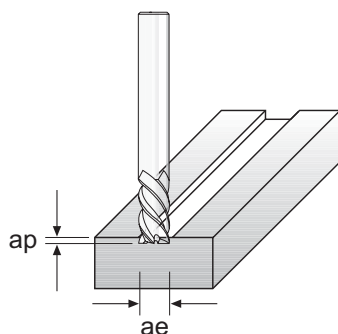
MATERIAL	Super Alloy - СУПЕР СПЛАВ				Steel - СТАЛЬ							
HARDNESS					< 35 HRC				< 50 HRC			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	30	0.012	0.08 x d	1 x d	130	0.012	0.2 x d	1 x d	110	0.013	0.1 x d	1 x d
4	30	0.024	0.08 x d	1 x d	130	0.024	0.2 x d	1 x d	110	0.026	0.1 x d	1 x d
5	30	0.024	0.08 x d	1 x d	130	0.024	0.2 x d	1 x d	110	0.026	0.1 x d	1 x d
6	30	0.024	0.08 x d	1 x d	130	0.024	0.2 x d	1 x d	110	0.026	0.1 x d	1 x d
8	30	0.048	0.08 x d	1 x d	130	0.048	0.2 x d	1 x d	110	0.052	0.1 x d	1 x d
10	30	0.048	0.08 x d	1 x d	130	0.048	0.2 x d	1 x d	110	0.052	0.1 x d	1 x d
12	30	0.072	0.08 x d	1 x d	130	0.072	0.2 x d	1 x d	110	0.078	0.1 x d	1 x d
14 - 18	30	0.072	0.08 x d	1 x d	130	0.072	0.2 x d	1 x d	110	0.078	0.1 x d	1 x d
20 - 25	30	0.120	0.08 x d	1 x d	130	0.120	0.2 x d	1 x d	110	0.130	0.1 x d	1 x d

Parametri di taglio

Cutting speed

Richtwerte - Paramètres

Режимы обработки - Řežná rychlost



CODE: 300 - 300T - 450 - 450T - 453 - 500 - 500T

MATERIAL	Aluminium - АЛЮМИНИЙ				Copper - МЕДЬ			
HARDNESS								
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	Max	0.010	1 x d	0.4 x d	200	0.009	1 x d	0.3 x d
4	Max	0.020	1 x d	0.4 x d	200	0.018	1 x d	0.3 x d
5	Max	0.020	1 x d	0.4 x d	200	0.018	1 x d	0.3 x d
6	Max	0.020	1 x d	0.4 x d	200	0.018	1 x d	0.3 x d
8	Max	0.040	1 x d	0.4 x d	200	0.036	1 x d	0.3 x d
10	Max	0.040	1 x d	0.4 x d	200	0.036	1 x d	0.3 x d
12	Max	0.060	1 x d	0.4 x d	200	0.054	1 x d	0.3 x d
14 - 18	Max	0.060	1 x d	0.4 x d	200	0.054	1 x d	0.3 x d
20 - 25	Max	0.100	1 x d	0.4 x d	200	0.090	1 x d	0.3 x d

CODE: 300 - 300T - 410 - 450 - 450T - 453 - 500 - 500T

MATERIAL	Titanium - ТИТАН				Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ			
HARDNESS								
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	60	0.006	1 x d	0.1 x d	50	0.006	1 x d	0.1 x d
4	60	0.013	1 x d	0.1 x d	50	0.013	1 x d	0.1 x d
5	60	0.013	1 x d	0.1 x d	50	0.013	1 x d	0.1 x d
6	60	0.013	1 x d	0.1 x d	50	0.013	1 x d	0.1 x d
8	60	0.026	1 x d	0.1 x d	50	0.026	1 x d	0.1 x d
10	60	0.026	1 x d	0.1 x d	50	0.026	1 x d	0.1 x d
12	60	0.038	1 x d	0.1 x d	50	0.038	1 x d	0.1 x d
14 - 18	60	0.038	1 x d	0.1 x d	50	0.038	1 x d	0.1 x d
20 - 25	60	0.064	1 x d	0.1 x d	50	0.064	1 x d	0.1 x d

CODE: 450 - 450T - 453 - 500 - 500T

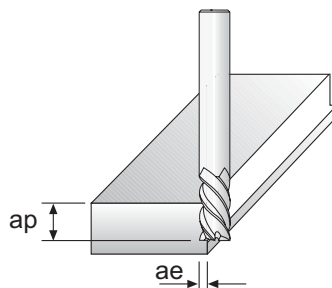
MATERIAL	Super Alloy - СУПЕР СПЛАВ				Steel - СТАЛЬ							
HARDNESS					< 40 HRC				< 50 HRC			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
3	20	0.006	1 x d	0.08 x d	110	0.008	1 x d	0.1 x d	90	0.007	1 x d	0.1 x d
4	20	0.012	1 x d	0.08 x d	110	0.016	1 x d	0.1 x d	90	0.012	1 x d	0.1 x d
5	20	0.012	1 x d	0.08 x d	110	0.016	1 x d	0.1 x d	90	0.012	1 x d	0.1 x d
6	20	0.012	1 x d	0.08 x d	110	0.016	1 x d	0.1 x d	90	0.012	1 x d	0.1 x d
8	20	0.025	1 x d	0.08 x d	110	0.032	1 x d	0.1 x d	90	0.024	1 x d	0.1 x d
10	20	0.025	1 x d	0.08 x d	110	0.032	1 x d	0.1 x d	90	0.024	1 x d	0.1 x d
12	20	0.037	1 x d	0.08 x d	110	0.048	1 x d	0.1 x d	90	0.036	1 x d	0.1 x d
14 - 18	20	0.037	1 x d	0.08 x d	110	0.048	1 x d	0.1 x d	90	0.036	1 x d	0.1 x d
20 - 25	20	0.062	1 x d	0.08 x d	110	0.080	1 x d	0.1 x d	90	0.060	1 x d	0.1 x d

Parametri di taglio

Cutting speed

Richtwerte - Paramètres

Режимы обработки - Řežná rychlost



For finishing:

$ae < 0,02 - 0,03 \times d$

$ap < 0,8 \times d$

$Vc = 1,2 \times Vc$ (Parameter List)

$Fz = 0,7 \times Vc$ (Parameter List)

CODE: 300C - 400 - 400T - 410

MATERIAL	Steel - СТАЛЬ											
HARDNESS	< 170 HRC				< 50 HRC				HRC 48 - 56			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
1 - 3	130	0.012	0.2 x d	1 x d	110	0.013	0.1 x d	1 x d	60	0.010	0.05 x d	0.010 x d
4	130	0.024	0.2 x d	1 x d	110	0.026	0.1 x d	1 x d	60	0.020	0.05 x d	0.010 x d
5	130	0.024	0.2 x d	1 x d	110	0.026	0.1 x d	1 x d	60	0.020	0.05 x d	0.010 x d
6	130	0.024	0.2 x d	1 x d	110	0.026	0.1 x d	1 x d	60	0.020	0.05 x d	0.010 x d
8	130	0.048	0.2 x d	1 x d	110	0.052	0.1 x d	1 x d	60	0.040	0.05 x d	0.010 x d
10	130	0.048	0.2 x d	1 x d	110	0.052	0.1 x d	1 x d	60	0.040	0.05 x d	0.010 x d
12	130	0.072	0.2 x d	1 x d	110	0.078	0.1 x d	1 x d	60	0.060	0.05 x d	0.010 x d
14 - 18	130	0.072	0.2 x d	1 x d	110	0.078	0.1 x d	1 x d	60	0.060	0.05 x d	0.010 x d
20 - 25	130	0.120	0.2 x d	1 x d	110	0.130	0.1 x d	1 x d	60	0.100	0.05 x d	0.010 x d

CODE: 300C - 400 - 400T - 410

MATERIAL	Cast Iron - ЧУГУН								Copper - МЕДЬ			
HARDNESS	Nodulaire - ЧУГУН				Lamellaire - ЛАМЕЛАР							
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
1 - 3	110	0.013	0.1 x d	1 x d	120	0.017	0.2 x d	1 x d	300	0.016	0.3 x d	1 x d
4	110	0.026	0.1 x d	1 x d	120	0.034	0.2 x d	1 x d	300	0.032	0.3 x d	1 x d
5	110	0.026	0.1 x d	1 x d	120	0.034	0.2 x d	1 x d	300	0.032	0.3 x d	1 x d
6	110	0.026	0.1 x d	1 x d	120	0.034	0.2 x d	1 x d	300	0.032	0.3 x d	1 x d
8	110	0.052	0.1 x d	1 x d	120	0.068	0.2 x d	1 x d	300	0.064	0.3 x d	1 x d
10	110	0.052	0.1 x d	1 x d	120	0.068	0.2 x d	1 x d	300	0.064	0.3 x d	1 x d
12	110	0.078	0.1 x d	1 x d	120	0.102	0.2 x d	1 x d	300	0.096	0.3 x d	1 x d
14 - 18	110	0.078	0.1 x d	1 x d	120	0.102	0.2 x d	1 x d	300	0.096	0.3 x d	1 x d
20 - 25	110	0.130	0.1 x d	1 x d	120	0.170	0.2 x d	1 x d	300	0.160	0.3 x d	1 x d

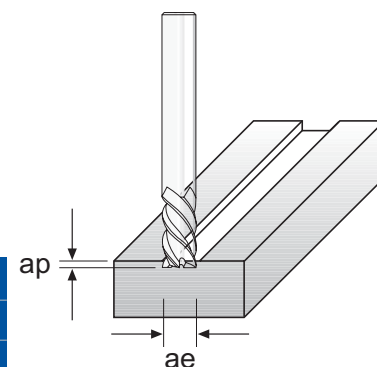
CODE: 300C - 400 - 400T - 410

MATERIAL	Titanium - ТИТАН				Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ				Super Alloy - СУПЕР СПЛАВ			
HARDNESS												
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
1 - 3	80	0.011	0.1 x d	1 x d	70	0.012	0.1 x d	1 x d	30	0.012	0.08 x d	1 x d
4	80	0.023	0.1 x d	1 x d	70	0.024	0.1 x d	1 x d	30	0.024	0.08 x d	1 x d
5	80	0.023	0.1 x d	1 x d	70	0.024	0.1 x d	1 x d	30	0.024	0.08 x d	1 x d
6	80	0.023	0.1 x d	1 x d	70	0.024	0.1 x d	1 x d	30	0.024	0.08 x d	1 x d
8	80	0.046	0.1 x d	1 x d	70	0.047	0.1 x d	1 x d	30	0.048	0.08 x d	1 x d
10	80	0.046	0.1 x d	1 x d	70	0.047	0.1 x d	1 x d	30	0.048	0.08 x d	1 x d
12	80	0.068	0.1 x d	1 x d	70	0.071	0.1 x d	1 x d	30	0.072	0.08 x d	1 x d
14 - 18	80	0.068	0.1 x d	1 x d	70	0.071	0.1 x d	1 x d	30	0.072	0.08 x d	1 x d
20 - 25	80	0.114	0.1 x d	1 x d	70	0.118	0.1 x d	1 x d	30	0.120	0.08 x d	1 x d

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost



CODE: 200 - 200T - 200D - 200DT - 200S - 200ST - 201 - 210
300 - 300T - 300C - 400 - 400T - 400D - 400DT - 401 - 410

MATERIAL	Steel - СТАЛЬ							
HARDNESS	< 170 HB				< 50HRC			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap
1 - 3	110	0.008	1 x d	0.1 x d	90	0.007	1 x d	0.1 x d
4	110	0.016	1 x d	0.1 x d	90	0.012	1 x d	0.1 x d
5	110	0.016	1 x d	0.1 x d	90	0.012	1 x d	0.1 x d
6	110	0.016	1 x d	0.1 x d	90	0.012	1 x d	0.1 x d
8	110	0.032	1 x d	0.1 x d	90	0.024	1 x d	0.1 x d
10	110	0.032	1 x d	0.1 x d	90	0.024	1 x d	0.1 x d
12	110	0.048	1 x d	0.1 x d	90	0.036	1 x d	0.1 x d
14 - 18	110	0.048	1 x d	0.1 x d	90	0.036	1 x d	0.1 x d
20 - 25	110	0.080	1 x d	0.1 x d	90	0.060	1 x d	0.1 x d

For finishing:
ae < 0,02 - 0,03 x d
ap < 0,8 x d
Vc = 1,2 x Vc (Parameter List)
Fz = 0,7 x Vc (Parameter List)

HSC = Standard Cutting Speed X 2

MATERIAL	Steel - СТАЛЬ				Cast Iron							
HARDNESS	HRC 48 - 56				Nodulaire - ЧУГУН				Lamellaire - ЛАМЕЛАР			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
1-3	40	0.006	1 x d	0.05 x d	90	0.006	1 x d	0.1 x d	100	0.009	1 x d	0.2 x d
4	40	0.008	1 x d	0.05 x d	90	0.013	1 x d	0.1 x d	100	0.018	1 x d	0.2 x d
5	40	0.008	1 x d	0.05 x d	90	0.013	1 x d	0.1 x d	100	0.018	1 x d	0.2 x d
6	40	0.008	1 x d	0.05 x d	90	0.013	1 x d	0.1 x d	100	0.018	1 x d	0.2 x d
8	40	0.016	1 x d	0.05 x d	90	0.026	1 x d	0.1 x d	100	0.036	1 x d	0.2 x d
10	40	0.016	1 x d	0.05 x d	90	0.026	1 x d	0.1 x d	100	0.036	1 x d	0.2 x d
12	40	0.024	1 x d	0.05 x d	90	0.038	1 x d	0.1 x d	100	0.054	1 x d	0.2 x d
14 - 18	40	0.024	1 x d	0.05 x d	90	0.038	1 x d	0.1 x d	100	0.054	1 x d	0.2 x d
20 - 25	40	0.040	1 x d	0.05 x d	90	0.064	1 x d	0.1 x d	100	0.090	1 x d	0.2 x d

CODE: T2204R SIDE MILLING

MATERIAL	Aluminum		Cast Aluminum		Steel - СТАЛЬ								Inox		Cast Iron - ЧУГУН	
HARDNESS			>10%Si		<500N		<750N		<900N		<1100N		<900N			
Ø	VC m/'	FZ mm	VC m/'	FZ mm	VC m/'	FZ mm	VC m/'	FZ mm	VC m/'	FZ mm	VC m/'	FZ mm	VC m/'	FZ mm	VC	FZ
5	350	0.023	250	0.023	160	0.023	140	0.023	130	0.023	80	0.023	90	0.023	120	0.023
6	350	0.033	250	0.033	160	0.033	140	0.033	130	0.033	80	0.033	90	0.033	120	0.033
8	350	0.045	250	0.045	160	0.045	140	0.045	130	0.045	80	0.045	90	0.045	120	0.045
10	350	0.060	250	0.060	160	0.060	140	0.060	130	0.060	80	0.060	90	0.060	120	0.060
12	350	0.080	250	0.080	160	0.080	140	0.080	130	0.080	80	0.080	90	0.080	120	0.080
14	350	0.080	250	0.080	160	0.080	140	0.080	130	0.080	80	0.080	90	0.080	120	0.080
16	350	0.100	250	0.100	160	0.100	140	0.100	130	0.100	80	0.100	90	0.100	120	0.100
18	350	0.100	250	0.100	160	0.100	140	0.100	130	0.100	80	0.100	90	0.100	120	0.100
20	350	0.120	250	0.120	160	0.120	140	0.120	130	0.120	80	0.120	90	0.120	120	0.120

CODE: T2204R SLOT MILLING

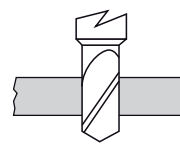
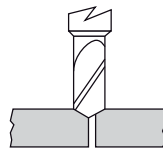
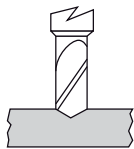
MATERIAL	Aluminum		Cast Aluminum		Steel - СТАЛЬ								Inox		Cast Iron - ЧУГУН	
HARDNESS			>10%Si		<500N		<750N		<900N		<1100N		<900N			
Ø	VC m/'	FZ mm	VC m/'	FZ mm	VC m/'	FZ mm	VC m/'	FZ mm	VC m/'	FZ mm	VC m/'	FZ mm	VC m/'	FZ mm	VC m/'	FZ mm
5	350	0.025	250	0.025	160	0.025	140	0.025	130	0.025	80	0.025	90	0.025	120	0.025
6	350	0.037	250	0.037	160	0.037	140	0.037	130	0.037	80	0.037	90	0.037	120	0.037
8	350	0.051	250	0.051	160	0.051	140	0.051	130	0.051	80	0.051	90	0.051	120	0.051
10	350	0.068	250	0.068	160	0.068	140	0.068	130	0.068	80	0.068	90	0.068	120	0.068
12	350	0.090	250	0.090	160	0.090	140	0.090	130	0.090	80	0.090	90	0.090	120	0.090
14	350	0.090	250	0.090	160	0.090	140	0.090	130	0.090	80	0.090	90	0.090	120	0.090
16	350	0.113	250	0.113	160	0.113	140	0.113	130	0.113	80	0.113	90	0.113	120	0.113
18	350	0.113	250	0.113	160	0.113	140	0.113	130	0.113	80	0.113	90	0.113	120	0.113
20	350	0.135	250	0.135	160	0.135	140	0.135	130	0.135	80	0.135	90	0.135	120	0.135

Parametri di taglio

Cutting speed

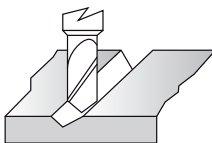
Richtwerte - Paramètres

Режимы обработки - Řežná rychlost

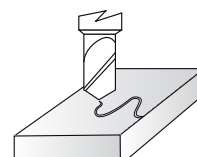
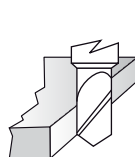
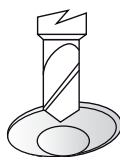
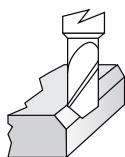


CODE: 200V

MATERIAL	HARDNESS	Vc							Ø											
			Ø3 - Ø4			Ø5 - Ø6			Ø8 - Ø10			Ø12			Ø16			Ø20		
			n	Vf	Fz	n	Vf	Fz	n	Vf	Fz	n	Vf	Fz	n	Vf	Fz	n	Vf	Fz
Steel	< 500 N/mm2	70-75	6400	320	0.050	4000	320	0.080	2500	350	0.140	1900	361	0.190	1500	360	0.240	1300	364	0.280
Steel	< 800 N/mm2	40-60	4000	200	0.050	2600	208	0.080	1600	224	0.140	1200	240	0.20	900	225	0.250	850	238	0.280
Steel	< 1000 N/mm2	35-40	3200	144	0.045	2200	154	0.070	1400	168	0.120	1000	180	0.180	850	187	0.220	680	190	0.280
Cast Iron	< 180 HB																			
Stainless Steel-Steel	< 1300 N/mm2	30-35	2800	126	0.045	1800	126	0.070	1100	132	0.120	800	136	0.170	650	143	0.220	550	143	0.260
Cast Iron	> 180 HB																			
Stainless Steel-Steel		25-30	2200	88	0.040	1600	96	0.060	900	99	0.110	660	105	0.160	500	110	0.220	480	120	0.250
Inconel		20	1800	72	0.040	1100	66	0.060	700	77	0.110	500	80	0.160	400	80	0.200	320	80	0.250
Titanium																				
Copper-Bronze-Brass		50-120	5000	500	0.100	3500	525	0.150	2200	550	0.250	1900	570	0.30	1700	595	0.350	1400	630	0.450
Aluminoium		150	10000	500	0.050	6300	567	0.090	4000	600	0.150	3200	640	0.20	2500	625	0.270	2000	700	0.350



MATERIAL	HARDNESS	Vc	Ø																		
			Ø3 - Ø4			Ø5 - Ø6			Ø8 - Ø10			Ø12			Ø16			Ø20			
			n	Vf	Fz	n	Vf	Fz	n	Vf	Fz	n	Vf	Fz	n	Vf	Fz	n	Vf	Fz	
Steel	< 500 N/mm2	70-75	6800	65	0.005	4300	65	0.008	2650	70	0.014	2000	75	0.019	1500	75	0.025	1200	75	0.030	
Steel	< 800 N/mm2	40-60	5400	55	0.005	3500	55	0.008	2100	58	0.014	1600	60	0.019	1200	60	0.025	1000	60	0.030	
Steel	< 1000 N/mm2	35-40	3600	28	0.004	2300	28	0.006	1400	34	0.012	1000	35	0.017	800	35	0.020	630	35	0.027	
Cast Iron	< 180 HB		3000	25	0.004	2000	25	0.006	1200	30	0.012	900	30	0.016	700	30	0.020	550	30	0.027	
Stainless Steel-Steel	< 1300 N/mm2	30-35	3000	25	0.004	2000	25	0.006	1200	30	0.012	900	30	0.016	700	30	0.020	550	30	0.027	
Cast Iron	> 180 HB	20	25-30	2200	17	0.004	1600	20	0.006	1000	20	0.010	760	20	0.013	600	22	0.018	400	22	0.027
Stainless Steel-Steel			1800	11	0.003	1100	12	0.005	700	14	0.010	500	14	0.013	400	15	0.018	320	16	0.025	
Inconel																					
Titanium																					
Copper-Bronze-Brass		50-120	7000	112	0.008	6000	120	0.010	3500	120	0.017	3200	128	0.020	2200	132	0.030	1750	140	0.040	
Aluminoium		150	13000	200	0.008	8600	220	0.013	5300	240	0.023	4000	240	0.030	3000	250	0.040	2400	250	0.050	

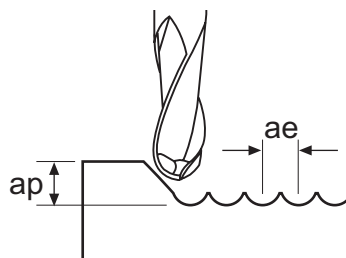


MATERIAL	HARDNESS	Vc	Ø																	
			Ø3 - Ø4			Ø5 - Ø6			Ø8 - Ø10			Ø12			Ø16			Ø20		
			n	Vf	Fz	n	Vf	Fz	n	Vf	Fz	n	Vf	Fz	n	Vf	Fz	n	Vf	Fz
Steel	< 500 N/mm2	70-75	6800	110	0.008	4300	120	0.014	2650	130	0.025	2000	150	0.040	1500	156	0.052	1200	156	0.065
Steel	< 800 N/mm2	40-60	5400	85	0.008	3500	90	0.013	2100	105	0.025	1600	120	0.040	1200	125	0.052	1000	125	0.062
Steel	< 1000 N/mm2	35-40	3600	58	0.008	2300	60	0.013	1400	70	0.025	1000	80	0.040	800	80	0.050	630	80	0.062
Cast Iron	< 180 HB																			
Stainless Steel-Steel	< 1300 N/mm2	30-35	3000	45	0.008	2000	50	0.013	1200	60	0.025	900	65	0.036	700	65	0.050	550	65	0.060
Cast Iron	> 180 HB																			
Stainless Steel-Steel		25-30	2200	35	0.008	1600	40	0.013	1000	50	0.025	760	55	0.036	600	55	0.045	400	55	0.070
Inconel		20	1800	25	0.007	1100	25	0.011	700	35	0.025	500	35	0.035	400	40	0.050	320	40	0.060
Titanium																				
Copper-Bronze-Brass		50-120	7000	200	0.010	6000	210	0.015	3500	216	0.030	3200	225	0.045	2200	230	0.050	1750	234	0.065
Aluminoium		150	13000	210	0.008	8600	225	0.013	5300	320	0.030	4000	360	0.045	3000	300	0.050	2400	310	0.065

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost



For finishing:

$a_e < 0,02 - 0,03 \times d$

$ap < 0,8 \times d$

$Vc = 1,2 \times Vc$ (Parameter List)

$Fz = 0,7 \times Fz$ (Parameter List)

CODE: 200R - 200RT - 200RL - 200RLT - 201R - 300CR - 300R - 300RT - 300RLT - 400R - 400RT - 400RLT - 401

ROUGHING - STANDARD CUTTING SPEED

MATERIAL	Steel - СТАЛЬ											
HARDNESS	< 170 HB				< 50 HRC				< 60 HRC			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
1 - 3	140	0.016	0.03 x d	0.03 x d	120	0.016	0.03 x d	0.03 x d	70	0.014	0.03 x d	0.03 x d
4	140	0.032	0.03 x d	0.03 x d	120	0.032	0.03 x d	0.03 x d	70	0.028	0.03 x d	0.03 x d
6	140	0.032	0.03 x d	0.03 x d	120	0.032	0.03 x d	0.03 x d	70	0.028	0.03 x d	0.03 x d
8	140	0.064	0.03 x d	0.03 x d	120	0.064	0.03 x d	0.03 x d	70	0.056	0.03 x d	0.03 x d
10	140	0.064	0.03 x d	0.03 x d	120	0.064	0.03 x d	0.03 x d	70	0.056	0.03 x d	0.03 x d
12 - 18	140	0.096	0.03 x d	0.03 x d	120	0.096	0.03 x d	0.03 x d	70	0.084	0.03 x d	0.03 x d
20 - 25	140	0.160	0.03 x d	0.03 x d	120	0.160	0.03 x d	0.03 x d	70	0.140	0.03 x d	0.03 x d

CODE: 200R - 200RT - 200RL - 200RLT - 201R - 300CR - 300R - 300RT - 300RLT - 400R - 400RT - 400RLT - 401

MATERIAL	Copper - МЕДЬ				Titanium - ТИТАН				Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ			
HARDNESS	< 170 HB				< 50 HRC				< 60 HRC			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
1 - 3	350	0.020	0.03 x d	0.03 x d	90	0.014	0.03 x d	0.03 x d	80	0.015	0.03 x d	0.03 x d
4	350	0.040	0.03 x d	0.03 x d	90	0.028	0.03 x d	0.03 x d	80	0.030	0.03 x d	0.03 x d
6	350	0.040	0.03 x d	0.03 x d	90	0.028	0.03 x d	0.03 x d	80	0.030	0.03 x d	0.03 x d
8	350	0.080	0.03 x d	0.03 x d	90	0.057	0.03 x d	0.03 x d	80	0.060	0.03 x d	0.03 x d
10	350	0.080	0.03 x d	0.03 x d	90	0.057	0.03 x d	0.03 x d	80	0.060	0.03 x d	0.03 x d
12 - 18	350	0.120	0.03 x d	0.03 x d	90	0.085	0.03 x d	0.03 x d	80	0.090	0.03 x d	0.03 x d
20 - 25	350	0.200	0.03 x d	0.03 x d	90	0.142	0.03 x d	0.03 x d	80	0.150	0.03 x d	0.03 x d

CODE: 200R - 200RT - 200RL - 200RLT - 201R - 300CR - 300R - 300RT - 300RLT - 400R - 400RT - 400RLT - 401

MATERIAL	Super Alloy - СУПЕР СПЛАВ				Cast Iron - ЧУГУН							
HARDNESS					Lamellaire - ЛАМЕЛАР				Nodulaire - ЧУГУН			
Ø	Vc	Fz	ae	ap	Vc	Fz	ae	ap	Vc	Fz	ae	ap
1 - 3	40	0.015	0.03 x d	0.03 x d	130	0.019	0.03 x d	0.03 x d	120	0.015	0.03 x d	0.03 x d
4	40	0.030	0.03 x d	0.03 x d	130	0.038	0.03 x d	0.03 x d	120	0.030	0.03 x d	0.03 x d
6	40	0.030	0.03 x d	0.03 x d	130	0.038	0.03 x d	0.03 x d	120	0.030	0.03 x d	0.03 x d
8	40	0.060	0.03 x d	0.03 x d	130	0.076	0.03 x d	0.03 x d	120	0.060	0.03 x d	0.03 x d
10	40	0.060	0.03 x d	0.03 x d	130	0.076	0.03 x d	0.03 x d	120	0.060	0.03 x d	0.03 x d
12 - 18	40	0.090	0.03 x d	0.03 x d	130	0.114	0.03 x d	0.03 x d	120	0.090	0.03 x d	0.03 x d
20 - 25	40	0.150	0.03 x d	0.03 x d	130	0.190	0.03 x d	0.03 x d	120	0.150	0.03 x d	0.03 x d

HSC

= Standard Cutting Speed X 1,4

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

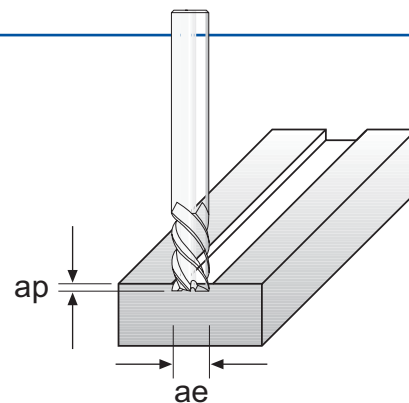
CODE: CTS60 - CTS90 - 142

MATERIAL	VC	FZ				
		Ø 3-4	Ø 6	Ø 8	Ø 10	Ø 12
Steel <500 N/mm	180	0.03	0.05	0.07	0.08	0.10
Steel <800 N/mm	150	0.01	0.03	0.05	0.06	0.08
Steel >800 N/mm	140	0.03	0.05	0.07	0.08	0.10
Stainless steel	70	0.01	0.03	0.04	0.05	0.07
Inconell	25 - 40	0.01	0.01	0.01	0.015	0.015
Titanium	20 - 40	0.01	0.01	0.01	0.015	0.015
Cast Iron	140	0.02	0.04	0.06	0.07	0.09
Tool Steel	85	0.01	0.03	0.05	0.06	0.08
Aluminium	500	0.02	0.05	0.08	0.10	0.12
Brass, Bronze, Copper, Plastic	280	0.02	0.05	0.08	0.10	0.12

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost



CODE: 201-401 SLOT MILLING

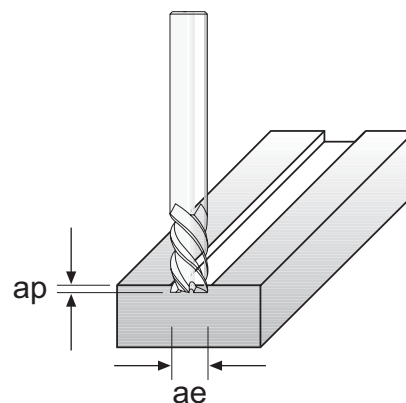
Material	Steel - СТАЛЬ																							
Hardened	<450N/mm2						450<700N/mm2						700<1200N/mm						HRC<52					
Ø	Vc (media)	Fz	n	Vf	ae	ap	Vc (media)	Fz	n	Vf	ae	ap	Vc (media)	Fz	n	Vf	ae	ap	Vc (media)	Fz	n	Vf	ae	ap
1	130	0.005	41380	415	1	1	120	0.005	38200	380	1	1	100	0.004	31830	255	1	1	50	0.002	15920	65	1	0.2
2	130	0.010	20690	415	2	2	120	0.010	19100	380	2	2	100	0.008	15920	255	2	2	50	0.004	7960	65	2	0.4
3	130	0.015	13790	415	3	3	120	0.015	12730	380	3	3	100	0.012	10610	255	3	3	50	0.006	8310	65	3	0.6
4	130	0.020	10350	415	4	4	120	0.020	9550	380	4	4	100	0.016	7960	255	4	4	50	0.008	3980	65	4	0.8
5	130	0.025	8280	415	5	5	120	0.025	7640	380	5	5	100	0.020	6370	255	5	5	50	0.010	3180	65	5	1
6	130	0.030	6900	415	6	6	120	0.030	6370	380	6	6	100	0.024	5310	255	6	6	50	0.012	2650	65	6	1.2
8	130	0.040	5170	415	8	8	120	0.040	4770	380	8	8	100	0.032	3980	255	8	8	50	0.016	1990	65	8	1.6
10	130	0.050	4140	415	10	10	120	0.050	3820	380	10	10	100	0.040	3180	255	10	10	50	0.020	1590	65	10	2
12	130	0.060	3450	415	12	12	120	0.060	3180	380	12	12	100	0.048	2650	255	12	12	50	0.024	1330	65	12	2.4
16	130	0.080	2590	415	16	16	120	0.080	2390	380	16	16	100	0.064	1990	255	16	16	50	0.032	990	65	16	3.2
20	130	0.100	2070	415	20	20	120	0.100	1910	380	20	20	100	0.080	1590	255	20	20	50	0.040	800	65	20	4

CODE: 201-401 SLOT MILLING

Material	Stainless Steel - НЕРЖАВЕЮЩАЯ СТАЛЬ												Cast Iron - ЧУГУН						Steel - СТАЛЬ					
Hardened	Hard						Soft																	
Ø	Vc (media)	Fz	n	Vf	ae	ap	Vc (media)	Fz	n	Vf	ae	ap	Vc (media)	Fz	n	Vf	ae	ap	Vc (media)	Fz	n	Vf	ae	ap
1	80	0.005	24460	255	1	0.8	50	0.005	15920	160	1	0.6	130	0.005	41380	415	1	0.8	400	0.006	127320	1530	1	0.4
2	80	0.010	12730	255	2	1.6	50	0.010	7960	160	2	1.2	130	0.010	20690	415	2	1.6	400	0.012	63660	1530	2	0.8
3	80	0.015	8490	255	3	2.4	50	0.015	5310	160	3	1.8	130	0.015	13790	415	3	2.4	400	0.018	42440	1530	3	1.2
4	80	0.020	6370	255	4	3.2	50	0.020	3980	160	4	2.4	130	0.020	10350	415	4	3.2	400	0.024	31830	1530	4	1.6
5	80	0.025	5090	255	5	4.0	50	0.025	3180	160	5	3.0	130	0.025	8280	415	5	4.0	400	0.030	24460	1530	5	2.0
6	80	0.030	4240	255	6	4.8	50	0.030	2650	160	6	3.6	130	0.030	6900	415	6	4.8	400	0.036	21220	1530	6	2.4
8	80	0.040	3180	255	8	6.4	50	0.040	1990	160	8	4.8	130	0.040	5170	415	8	6.4	400	0.048	15920	1530	8	3.2
10	80	0.050	2550	255	10	8.0	50	0.050	1590	160	10	6.0	130	0.050	4140	415	10	8.0	400	0.060	12730	1530	10	4.0
12	80	0.060	2120	255	12	9.6	50	0.060	1330	160	12	7.2	130	0.060	3450	415	12	9.6	400	0.072	10610	1530	12	4.8
16	80	0.080	1590	255	16	12.8	50	0.080	990	160	16	9.6	130	0.080	2590	415	16	12.8	400	0.096	7960	1530	16	6.4
20	80	0.100	1270	255	20	16.0	50	0.100	800	160	20	12.0	130	0.100	2070	415	20	16.0	400	0.120	6370	1530	20	8.0

CODE: 201-401 SLOT MILLING

Material	Titanium - ТИТАН						Aluminum-Plastic					
Hardened	Hard						Soft					
Ø	Vc (media)	Fz	n	Vf	ae	ap	Vc (media)	Fz	n	Vf	ae	ap
1	70	0.004	22280	180	1	0.6	400	0.006	127320	1530	1	0.4
2	70	0.008	11140	180	2	1.2	400	0.012	63660	1530	2	0.8
3	70	0.012	7430	180	3	1.8	400	0.018	42440	1530	3	1.2
4	70	0.016	5570	180	4	2.4	400	0.024	31830	1530	4	1.6
5	70	0.020	4460	180	5	3.0	400	0.030	25460	1530	5	2
6	70	0.024	3710	180	6	3.6	400	0.036	21220	1530	6	2.4
8	70	0.032	2790	180	8	4.8	400	0.048	15920	1530	8	3.2
10	70	0.040	2230	180	10	6.0	400	0.060	12730	1530	10	4
12	70	0.048	1860	180	12	7.2	400	0.072	10610	1530	12	4.8
16	70	0.064	1390	180	16	9.6	400	0.069	7960	1530	16	6.4
20	70	0.080	1110	180	20	12.0	400	0.120	6370	1530	20	8



Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: 120 - 122T - 122TL - 130 - 140 - 190

MATERIAL	HARDNESS	Type	VC	Ø				
				Ø 3-5	Ø 5.1-8	Ø 8.1-12	Ø 12.1-16	Ø 16.1-20
				FZ	FZ	FZ	FZ	FZ
Stainless Steel ЛИТАЯ СТАЛЬ			20 ÷ 30	0.04 ÷ 0.10	0.05 ÷ 0.15	0.05 ÷ 0.18	0.08 ÷ 0.20	0.10 ÷ 0.20
Cast steel	< 600 N/mm	GS 38	30 - 60	0.05 - 0.15	0.05 - 0.20	0.10 - 0.22	0.10 - 0.25	0.10 - 0.25
	< 700 N/mm	GS 52	25 - 50	0.04 - 0.10	0.05 - 0.15	0.05 - 0.18	0.08 - 0.20	0.10 - 0.20
	> 700 N/mm	GS 62	20 - 45	0.04 - 0.10	0.05 - 0.15	0.10 - 0.18	0.08 - 0.20	0.10 - 0.20
Cast Iron ЧУГУН	< 200 N/mm	GG 20 GGG 40 GTS 45	70 - 110	0.10 - 0.25	0.15 - 0.30	0.20 - 0.40	0.25 - 0.45	0.30 - 0.50
	< 250 N/mm	GG 30 GGG 50 GTS 40	60 - 95	0.10 - 0.20	0.12 - 0.25	0.15 - 0.35	0.20 - 0.40	0.25 - 0.45
	> 250 N/mm	GG 40 GGG 70 GTS 70	50 - 80	0.10 - 0.20	0.12 - 0.25	0.15 - 0.35	0.20 - 0.40	0.25 - 0.45
	350 HB 450 HB		20 - 55	0.04 - 0.10	0.06 - 0.12	0.08 - 0.15	0.08 - 0.15	0.10 - 0.18
Copper - Bronze - Brass МЕДЬ - БРОНЗА - ЛАТУНЬ			60 - 220	0.07 - 0.18	0.12 - 0.25	0.20 - 0.35	0.25 - 0.45	0.30 - 0.50
Aluminium АЛЮМИНИЙ		< 10% Si	80 - 200	0.10 - 0.25	0.15 - 0.35	0.25 - 0.45	0.30 - 0.50	0.35 - 0.55
		> 10% Si	70 - 200	0.10 - 0.25	0.15 - 0.35	0.25 - 0.45	0.30 - 0.50	0.35 - 0.55
Titanium Титан			15 - 40	0.02 - 0.07	0.04 - 0.10	0.06 - 0.12	0.08 - 0.15	0.08 - 0.15
Inconel ИНКОНЕЛЬ			10 - 30	0.02 - 0.07	0.04 - 0.10	0.06 - 0.12	0.08 - 0.15	0.08 - 0.15

CORRECTION FACTORS - УТОЧНЯЮЩИЕ ДАННЫЕ

5 x d = x 0,8

8 x d = x 0,7

Code 120 = x 0,7

Code 130 = x 0,7

Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: 122F - 122FL - 122FALX

MATERIAL	HARDNESS	Type	VC	Ø				
				Ø 3 - 5	Ø 5 - 8	Ø 8.1 - 12	Ø 12.1 - 16	Ø 16.1 - 20
				FZ	FZ	FZ	FZ	FZ
Steel СТАЛЬ	< 500 N/mm ²		70 - 90	0.001	0.012	0.015	0.020	0.025
	< 800 N/mm ²		50 - 80	0.010	0.012	0.015	0.020	0.025
	< 1000 N/mm ²		45 - 60	0.010	0.012	0.013	0.017	0.020
	< 1300 N/mm ²		40 - 55	0.010	0.012	0.013	0.017	0.020
Stainless Steel НЕРЖАВЕЮЩАЯ СТАЛЬ			25 ÷ 55	0.04 ÷ 0.10	0.05 ÷ 0.15	0.05 ÷ 0.18	0.08 ÷ 0.20	0.10 ÷ 0.20
Cast steel ЛИТАЯ СТАЛЬ	< 600 N/mm	GS 38	40 - 70	0.05 - 0.15	0.05 - 0.20	0.10 - 0.22	0.10 - 0.25	0.10 - 0.25
	< 700 N/mm	GS 52	30 - 50	0.04 - 0.10	0.05 - 0.15	0.05 - 0.18	0.08 - 0.20	0.10 - 0.20
	> 700 N/mm	GS 62	25 - 55	0.04 - 0.10	0.05 - 0.15	0.10 - 0.18	0.08 - 0.20	0.10 - 0.20
Cast Iron ЧУГУН	< 200 N/mm	GG 20 GGG 40 GTS 45	80 - 130	0.10 - 0.25	0.15 - 0.30	0.20 - 0.40	0.25 - 0.45	0.30 - 0.50
	< 250 N/mm	GG 30 GGG 50 GTS 40	70 - 115	0.10 - 0.20	0.12 - 0.25	0.15 - 0.35	0.20 - 0.40	0.25 - 0.45
	> 250 N/mm	GG 40 GGG 70 GTS 70	60 - 100	0.10 - 0.20	0.12 - 0.25	0.15 - 0.35	0.20 - 0.40	0.25 - 0.45
	350 HB 450 HB		25 - 65	0.04 - 0.10	0.06 - 0.12	0.08 - 0.15	0.08 - 0.15	0.10 - 0.18
Copper - Bronze - Brass МЕДЬ - БРОНЗА - ЛАТУНЬ			70 - 300	0.07 - 0.18	0.12 - 0.25	0.20 - 0.35	0.25 - 0.45	0.30 - 0.50
Aluminium АЛЮМИНИЙ		> 10 % Si	90 - 300	0.10 - 0.25	0.15 - 0.35	0.25 - 0.45	0.30 - 0.50	0.35 - 0.55
		< 10 % Si	100 - 400	0.10 - 0.25	0.15 - 0.35	0.25 - 0.45	0.30 - 0.50	0.35 - 0.55
Titanium ТИТАН			15 - 45	0.02 - 0.07	0.04 - 0.10	0.06 - 0.12	0.08 - 0.15	0.08 - 0.15
Inconel ИНКОНЕЛЬ		Inconel	15 - 35	0.02 - 0.07	0.04 - 0.10	0.06 - 0.12	0.08 - 0.15	0.08 - 0.15

CORRECTION FACTORS - УТОЧНЯЮЩИЕ ДАННЫЕ

5 x d = x 0,8

8 x d = x 0,7

CODE: CTM

MATERIAL	HARDNESS	VC	Ø			
			Ø 1 - 2	Ø 3-4	Ø 6 - 8	Ø 10 - 12
			FZ	FZ	FZ	FZ
Steel СТАЛЬ	< 500 N/mm ²	70 - 90	0.001	0.012	0.015	0.02
	< 800 N/mm ²	50 - 80	0.01	0.012	0.015	0.02
	< 1000 N/mm ²	45 - 60	0.01	0.012	0.013	0.017
	< 1300 N/mm ²	40 - 50	0.01	0.012	0.013	0.017
Stainless Steel-Steel НЕРЖАВЕЮЩАЯ СТАЛЬ	< 1300 N/mm ²	35 - 50	0.07	0.01	0.01	0.015
Cast Iron ЧУГУНn	< 180 HB	45-60	0,01	0,012	0,013	0,017
Cast Iron ЧУГУНn	< 180 HB	40-55	0,01	0,012	0,013	0,017
Inconel - Titanium ИНКОНЕЛЬ - ТИТАН		25-40	0,007	0,01	0,01	0,015
Copper - Bronze - Brass МЕДЬ - БРОНЗА - ЛАТУНЬ		60-100	0,012	0,012	0,015	0,02
Aluminium АЛЮМИНИЙ	<6% Si	80-120	0,012	0,012	0,015	0,02
	>6% Si	110-180	0,012	0,012	0,015	0,02

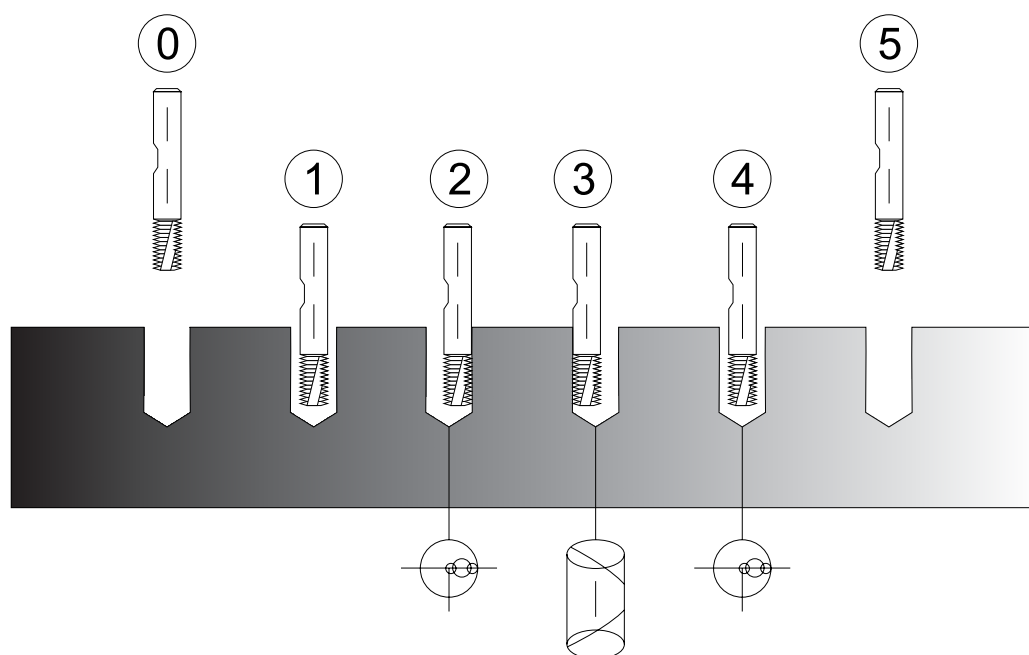
Parametri di taglio

Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: 600 - 600T

MATERIAL	HARDNESS	Vc	Ø 4-6 Fz	Ø 8.0 Fz	Ø 10.0 Fz	Ø 12.0 Fz	Ø 14.0 Fz	Ø 16.0 Fz	Ø 18.0 Fz	Ø 20.0 Fz
Steel	<700 N/mm	90-200	0.035-0.100	0.040-0.120	0.045-0.150	0.050-0.180	0.060-0.021	0.070-0.250	0.080-0.280	0.090-0.350
	<700-900 N/mm	80-160	0.030-0.090	0.035-0.100	0.040-0.130	0.045-0.150	0.050-0.180	0.060-0.210	0.070-0.250	0.080-0.300
	900-1200 N/mm	60-120	0.025-0.080	0.030-0.090	0.035-0.110	0.040-0.130	0.045-0.160	0.050-0.190	0.055-0.220	0.060-0.250
	>1200 N/mm	40-100	0.020-0.070	0.025-0.080	0.030-0.100	0.035-0.120	0.040-0.150	0.045-0.180	0.050-0.210	0.055-0.230
Stainless Steel		25-80	0.025-0.080	0.030-0.080	0.035-0.110	0.040-0.130	0.045-0.160	0.050-0.190	0.055-0.220	0.060-0.250
Stainless Steel Hard		20-65	0.020-0.070	0.025-0.070	0.030-0.100	0.035-0.120	0.040-0.150	0.045-0.180	0.050-0.210	0.055-0.230
Cast Iron		80-180	0.035-0.100	0.040-0.120	0.045-0.150	0.050-0.180	0.060-0.210	0.070-0.250	0.080-0.280	0.090-0.350
Cast Iron		65-150	0.030-0.090	0.035-0.100	0.040-0.130	0.045-0.150	0.050-0.180	0.060-0.210	0.070-0.250	0.080-0.300
Nodular Cast Iron High Hardness		50-120	0.025-0.080	0.030-0.090	0.035-0.110	0.040-0.130	0.045-0.160	0.050-0.190	0.055-0.220	0.060-0.250
Nodular Cast Hard Workability		40-100	0.020-0.070	0.025-0.080	0.030-0.100	0.035-0.120	0.040-0.150	0.045-0.180	0.050-0.210	0.055-0.210
Aluminium <15%		100-350	0.050-0.200	0.070-0.240	0.090-0.280	0.110-0.300	0.130-0.350	0.140-0.400	0.150-0.450	0.160-0.500
Aluminium >15%		80-250	0.040-0.100	0.060-0.140	0.080-0.180	0.100-0.200	0.120-0.250	0.130-0.300	0.140-0.350	0.150-0.400
Brass		80-180	0.030-0.090	0.035-0.100	0.040-0.130	0.045-0.150	0.050-0.180	0.060-0.210	0.070-0.250	0.080-0.300
Bronze		70-200	0.030-0.090	0.035-0.100	0.040-0.130	0.045-0.150	0.050-0.180	0.060-0.210	0.070-0.250	0.080-0.300
Titanium		20-60	0.020-0.070	0.025-0.080	0.030-0.100	0.035-0.120	0.040-0.150	0.045-0.180	0.050-0.210	0.055-0.230



ESEMPIO DI PROGRAMMA CNC CNC program example

M8X1.25 H hole 16.8mm CAST IRON

N0 G54 G90 G00 X0 Y0 Z2 S4244 T01 M03
Posizionamento dell'utensile sul foro
Tool positioning on the hole

N1 G91 Z-19.1125
Inserimento dell'utensile nel foro
Inserting the tool in the hole

N2 G01 Y0.625 F509
Allontanamento dell'utensile dal centro
Tool removal from the center

N3 G41 G01 X3.375 Y0
Scostamento dell'utensile verso
il punto di partenza
Deviating tool toward the starting point

N4 G03 X-3.375 Y3.375 Z0.3125 I-3.375 J0
Avvicinamento in entrata
Approaching on the enter

N5 G03 X0 Y0 Z1.25 I0 J-4
Fresatura a filettare
Thread milling

N6 G03 X-3.375 Y-3.375 Z0.3125 I0 J-3.375
Uscita dal filetto
Gone out to the thread

N7 G00 G40 X3.375 Y-0.625
Scostamento dell'utensile verso il centro
Tool deviation to the center

N8 G90 Z2
Uscita dell'utensile dal foro
Tool exit from the hole

Parametri di taglio

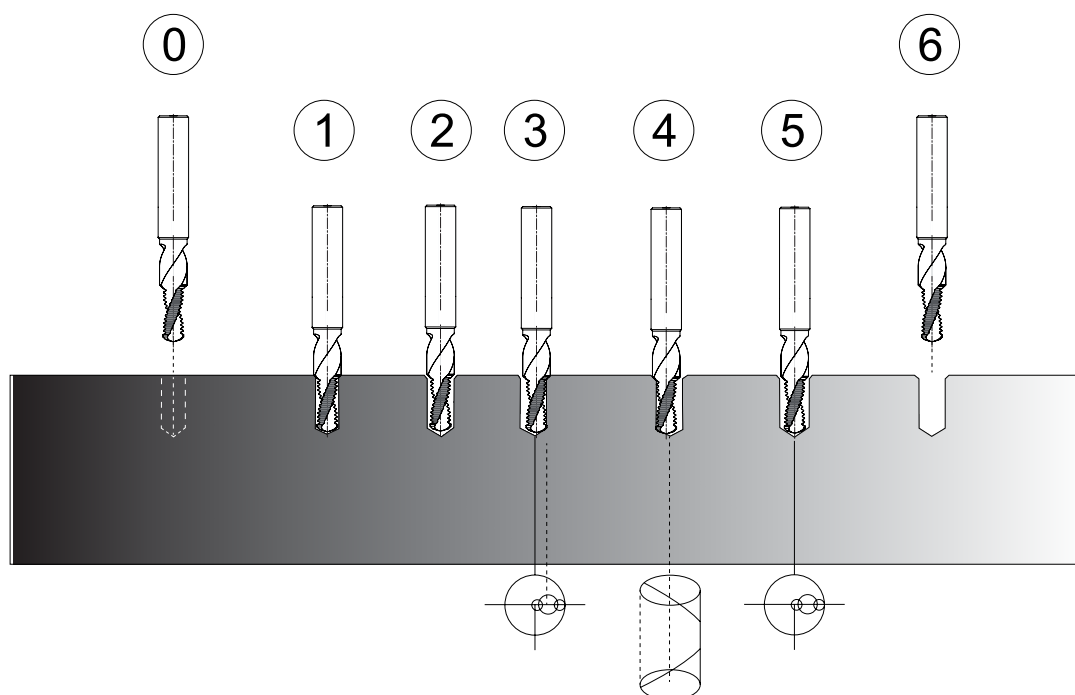
Cutting speed

Richtwerte - Paramètres - Режимы обработки - Řežná rychlost

CODE: 620FT

CODE: 620-620T-620F= -20%

MATERIAL	HARDNESS		Vc	Fb (Drilling Feed) mm/rev		Fz (Milling Feed) mm/tooth	
	N/mm2	HB		≤ Ø 6	≤ Ø 16	≤ Ø 6	≤ Ø 16
Grey Cast Iron	<500	<150	100-200	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10
Grey Cast Iron, heat treated	>500<1000	>150<300	100-200	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10
Vermicular cast iron	400-500	200-250	80-100	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10
Spheroidal graphite cast iron	<700	<200	80-120	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10
Short chip brass, bronze, red brass	<700	<200	100-200	0.10-0.30	0.15-0.10	0.03-0.06	0.06-0.10
Cu, Al, Fe alloy	<500	<470	80-160	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10
Al, Mg non alloy	<350	<100	100-400	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
Cast Aluminium Alloy <5% Si	<600	<180	100-350	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
Cast Aluminium Alloy >5% <10% Si	<600	<180	100-350	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
Cast Aluminium Alloy >10% Si	<600	<180	100-300	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
Thermoplastics			60-120	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
Thermosetting Plastics			60-100	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
Fiber reinforced plastics			60-80	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10



ESEMPIO DI PROGRAMMA CNC CNC program example

M8X1.25 H hole 18.39mm CAST IRON

N0 G54 G90 G00 X0 Z2 S4897 T01 M03
Posizionamento dell'utensile sul foro
Tool positioning on the hole

N1 G91 G01 Z-20.39 F490
Esecuzione del foro
Hole execution

N2 G01 Z0.417
Ritiro dell'utensile dal foro
Tool retraction from the hole

N3 G41 G01 X0 Y-3.25 F392
Scostamento dell'utensile verso
il punto di partenza
Tool deviation from the starting point

N4 G03 X0 Y7.25 Z0.625 10 J3.625
Avvicinamento in entrata
Approaching on the enter

N5 G03 X0 Y0 Z0.125 10 J-4
Fresatura a filettare
Thread milling

N6 G03 X0 Y-7.25 Z0.625 10 J-3.625
Uscita dal filetto
Gone out thread

N7 G00 G40 X0 Y3.25
Scostamento dell'utensile verso il centro
Tool deviation to the center

N8 G90 Z2
Uscita dell'utensile dal foro
Tool exit from the hole

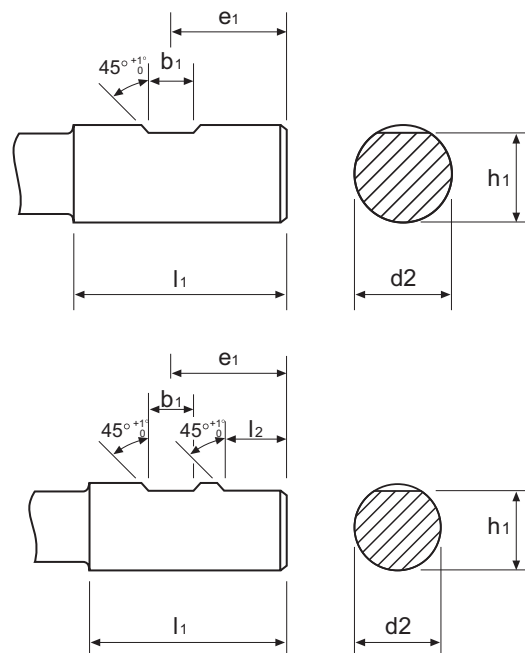
Dimensioni gambi weldon DIN 6535 HB a richiesta

Weldon shank dimentions DIN 6535 HB on request

Dimension Weldon DIN 6535 HB auf Anfrage - Dimensions queue weldon DIN 6535 HB sur demande

Хвостовик типа Weldon DIN 6535 HB

d2 mm	b1 mm	e1 mm	h1 mm	l1 mm	l2 mm
6	4.2	18.0	5.1	36	-
8	5.5	18.0	6.9	36	-
10	7.0	20.0	8.5	40	-
12	8.0	22.5	10.4	45	-
14	8.0	22.5	12.7	45	-
16	10.0	24.0	14.2	48	-
18	10.0	24.0	16.2	48	-
20	11.0	25.0	18.2	50	-
25	12.0	32.0	23.0	56	17
32	14.0	36.0	30.0	60	19



Dimensioni gambi flat DIN 6535 HE a richiesta

Whistle notch shank dimentions DIN 6535 HE on request

Dimension spannfläche DIN 6535 HE auf anfrage - Dimensions queue flat DIN 6535 HE sur demande

Хвостовик типа HEWeldon DIN 6535

d2 mm	b1 mm	b2 mm	h2 mm	h1 mm	l1 mm	l3 mm	l2 mm	r mm
6	3.5	4.8	5.4	4.8	36	25	18	1.2
8	4.7	6.1	7.2	6.6	36	25	18	1.2
10	5.7	7.3	9.1	8.4	40	28	20	1.2
12	6.0	8.2	11.2	10.4	45	33	22.5	1.2
16	7.6	10.1	15.0	14.2	48	36	24	1.6
20	8.4	11.5	19.1	18.2	50	38	25	1.6
25	9.3	13.6	24.1	23.0	56	44	32	1.6
32	9.4	15.5	31.2	30.0	60	48	35	1.6

