
TORNITURA

TURNING / DREHEN / TOURNAGE / TORNEADO



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



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



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



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



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



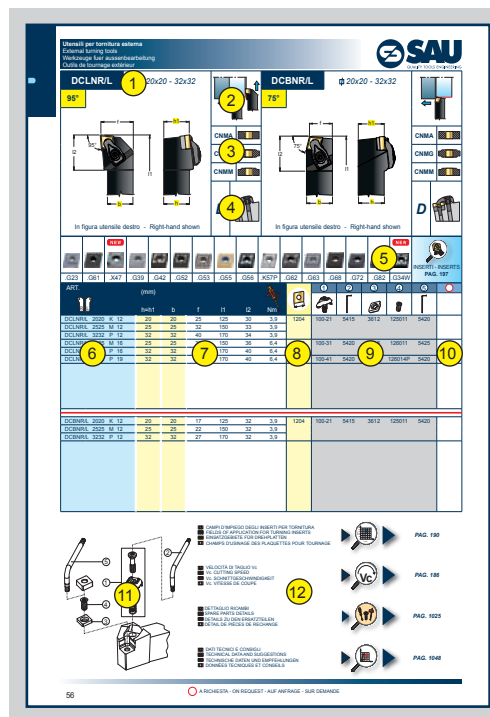
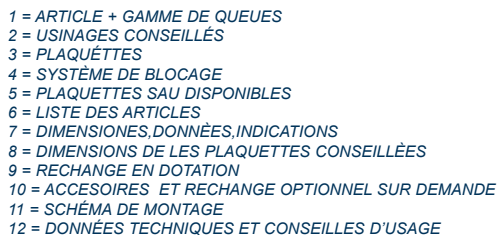
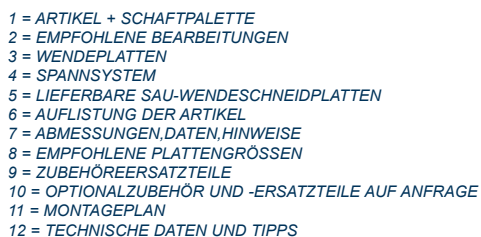
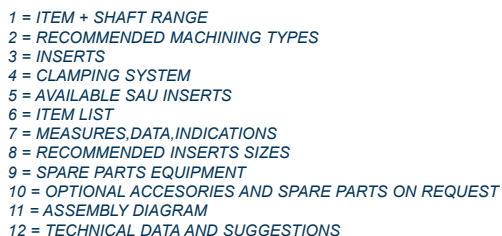
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	INSERTI PER SCANALATURA
	GROOVING INSERTS
	WENDEPLATTEN ZUM NUTENDREHEN
	PLAQUÉTTES DE GORGES
	PLAQUITAS DE RANURAS



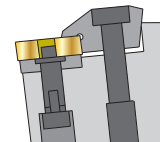
Pag. 211

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



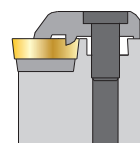
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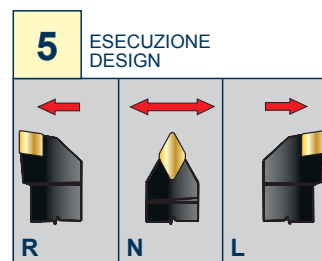
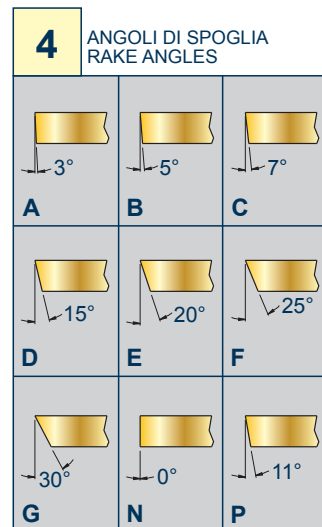
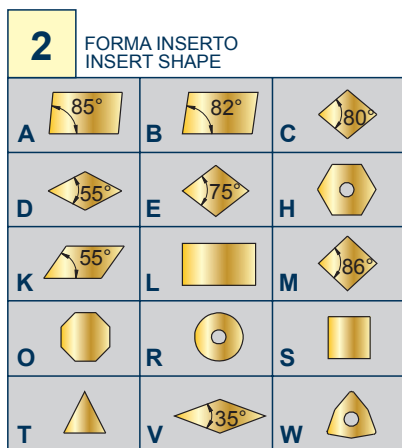
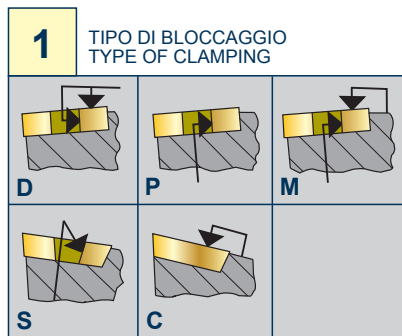
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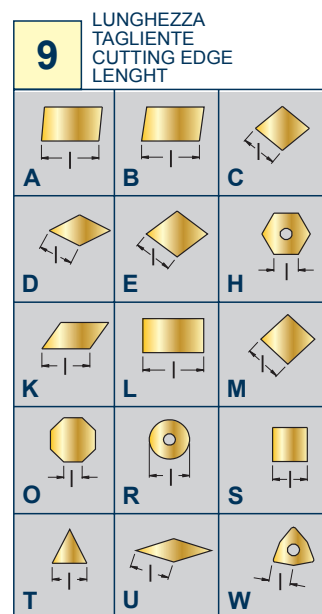
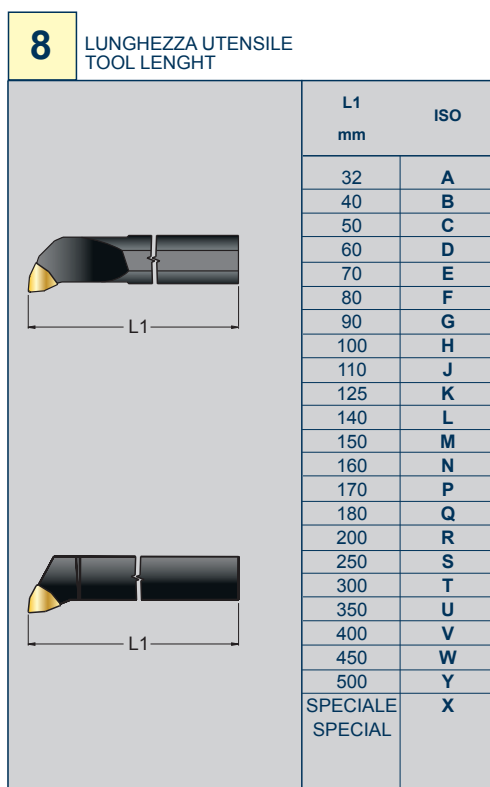
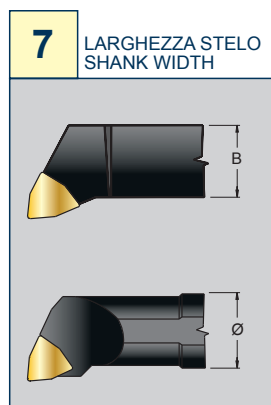
C

C





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



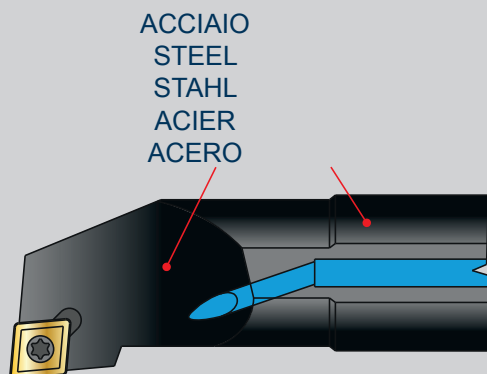
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11	7	8	1	2	3	4	5	9	10

11 STELO SHANK

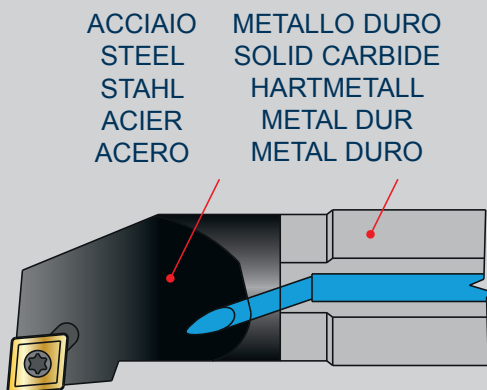
S = Stelo in acciaio
A = Stelo in acciaio + foro refrigerante
B = Stelo in acciaio + dispositivo antivibrante
C = Stelo in metallo duro con testa in acciaio
D = Stelo in acciaio + dispositivo antivibrante + foro refrigerante
E = Stelo in metallo duro con testa in acciaio + foro refrigerante
F = Stelo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

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

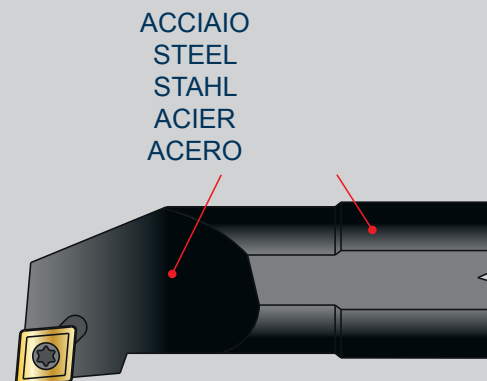
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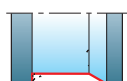


E...



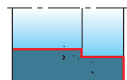
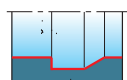
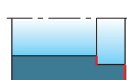
S...



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

● FORMA CONSIGLIATA - RECOMMENDED SHAPE

○ FORMA POSSIBILE - POSSIBLE SHAPE

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

● FORMA CONSIGLIATA - RECOMMENDED SHAPE

○ FORMA POSSIBILE - POSSIBLE SHAPE



UTENSILI PER TORNITURA ESTERNA



EXTERNAL TURNING TOOLS



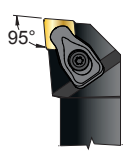
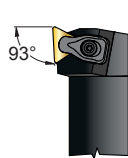
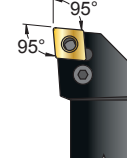
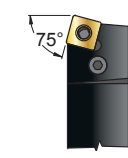
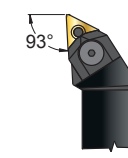
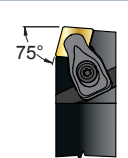
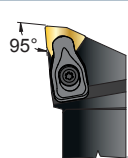
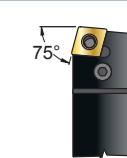
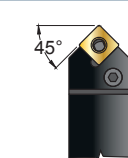
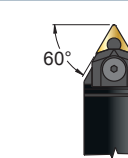
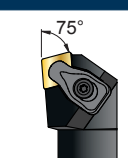
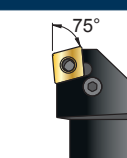
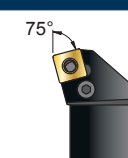
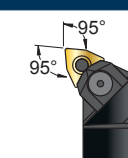
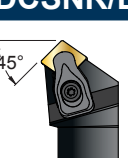
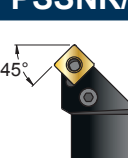
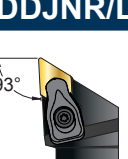
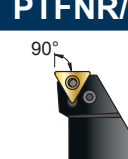
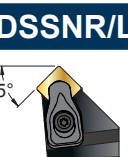
WERKZEUGE FÜR AUSSENBEARBEITUNG



OUTILS DE TOURNAGE EXTÉRIEUR



UTENSILIOS PARA TORNEADO EXTERIOR

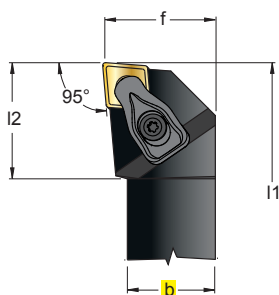
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DCLNR/L Pag.56	 CNM. 1204.. 1606.. 1906.. □ 20x20 - 32x32	DTJNR/L Pag.60	 TNM. 1604.. 2204.. □ 20x20 - 32x32	PCLNR/L Pag.62	 CNM. 0903.. 1204.. 1606.. 1906.. □ 16x16 - 40x40	PSBNR/L Pag.65	 SNM. 1204.. 1506.. 1906.. □ 20x20 - 40x40	MTJNR/L Pag.69	 TNM. 1604.. 2204.. □ 20x20 - 32x32
DCBNR/L Pag.56	 CNM. 1204.. □ 20x20 - 32x32	DWLNR/L Pag.61	 WNM. 0804.. □ 20x20 - 25x25	PCBNR/L Pag.62	 CNM. 1204.. 1606.. 1906.. □ 20x20 - 40x40	PSDNN Pag.65	 SNM. 1204.. 1506.. 1906.. □ 16x16 - 32x32	MTENN Pag.69	 TNM. 1604.. 2204.. □ 20x20 - 32x32
DCKNR/L Pag.57	 CNM. 1204.. □ 20x20 - 32x32			PCKNR/L Pag.63	 CNM. 1204.. 1606.. 1906.. □ 20x20 - 40x40	PSKNR/L Pag.66	 SNM. 1204.. 1506.. 1906.. □ 20x20 - 40x40	MWLNR/L Pag.70	 WNM. 0604.. 0804.. □ 20x20 - 32x32
DCSNR/L Pag.57	 CNM. 1204.. □ 20x20 - 32x32			PCSNR/L Pag.63	 CNM. 1204.. 1606.. 1906.. □ 20x20 - 32x32	PSSNR/L Pag.66	 SNM. 1204.. 1506.. 1906.. □ 16x16 - 40x40		
DDJNR/L Pag.58	 DNM. 1506.. □ 20x20 - 25x25			PDJNR/L Pag.64	 DNM. 1104.. 1506.. □ 16x16 - 32x32	PTFNR/L Pag.67	 TNM. 1604.. 2204.. □ 20x20 - 32x32		
DSKNR/L Pag.59	 SNM. 1204.. 1506.. □ 20x20 - 32x32			PDNNR/L Pag.64	 DNM. 1104.. 1506.. □ 16x16 - 32x32	PTGNR/L Pag.67	 TNM. 1604.. 2204.. □ 20x20 - 32x32		
DSSNR/L Pag.59	 SNM. 1204.. □ 20x20 - 25x25					PWLNR/L Pag.68	 WNM. 0604.. 0804.. □ 16x16 - 32x32		

M		M		S		S		S	
MCLNR/L Pag.71		MVJNR/L Pag.74		SCLCR/L Pag.76		STFCR/L Pag.81		SVVBN Pag.84	
 95° 95° □ 20x20 - 32x32	 CNM. 1204.. 1606.. 1906..	 93° □ 20x20 - 32x25	 VNM. 1604..	 95° 95° □ 08x08 - 25x25	 CC.. 0602.. 09T3.. 1204..	 90° □ 08x08 - 25x25	 TC.. 0902.. 1102.. 16T3..	 72.5° □ 20x20 - 32x25	 VB.. 1604..
MDJNR/L Pag.72		MVVNN Pag.74		SCRCR/L Pag.76		STGCR/L Pag.81		C CKJNR/L Pag.85	
 93° □ 20x20 - 32x32	 DNM. 1506..	 72.5° □ 20x20 - 32x25	 VNM. 1604..	 75° □ 08x08 - 25x25	 CC.. 0602.. 09T3.. 1204..	 90° □ 08x08 - 25x25	 TC.. 0902.. 1102.. 16T3..		
MDQNR/L Pag.72		MVPCR/L Pag.75		SDHCR/L Pag.77		SVHCR/L Pag.82		 93° □ 20x20 - 32x32 KNUX 1604..	
 107,5° □ 25x25	 DNM. 1506..	 117,5° □ 20x20 - 32x32	 VNM. 1604..	 107,5° □ 10x10 - 25x25	 DC.. 0702.. 11T3..	 107,5° □ 16x16 - 32x25	 VC.. 1103.. 1604..		
MSSNR/L Pag.73				SDJCR/L Pag.77		SVJCR/L Pag.82		 95° 95° □ 20x20 - 32x32 CNM. 1204..	
 45° □ 20x20 - 40x40	 SNM. 1204.. 1906..			 93° □ 08x08 - 25x25	 DC.. 0702.. 11T3..	 93° □ 12x12 - 32x25	 VC.. 1103.. 1604..		
MSBNR/L Pag.73				SDNCN Pag.78		SVXCR/L Pag.83		 93° □ 20x20 - 32x32 DNM. 1506..	
 75° □ 32x32 - 40x40	 SNM. 1906..			 63° □ 08x08 - 25x25	 DC.. 0702.. 11T3..	 113° □ 20x20 - 25x25	 VC.. 1604..		
				SRDCN Pag.79		SVVCN Pag.83		 95° 95° □ 20x20 - 25x25 CC.. 1204..	
				 □ 12x12 - 25x25	 RC.. 0602M0.. 0803M0.. 1003M0..	 72.5° □ 16x16 - 32x25	 VC.. 1103.. 1604..		
				SSSCR/L Pag.80		SVJBR/L Pag.84		 93° □ 20x20 - 25x25 DC.. 11T3..	
				 45° □ 12x12 - 32x25	 SC.. 09T3.. 1204..	 93° □ 16x16 - 32x25	 VB.. 1604..		

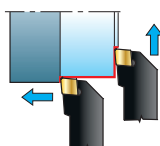
TTS - TOOLS

□ 20x20 - 32x32

95°



In figura utensile destro - Right-hand shown



CNMA



CNMG

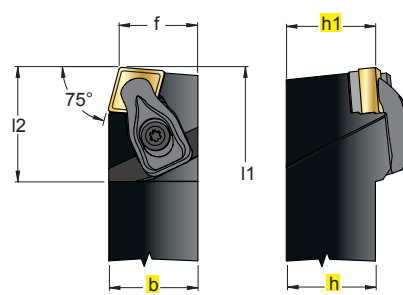


CNMM

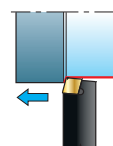


□ 20x20 - 32x32

75°



In figura utensile destro - Right-hand shown



CNMA



CNMG

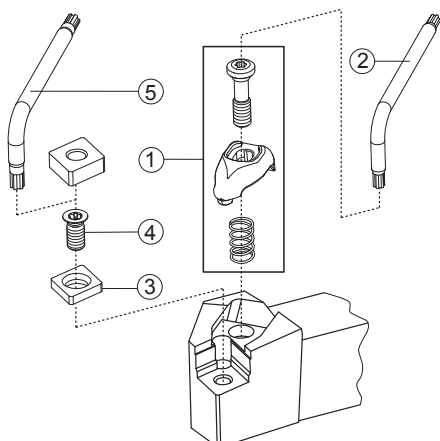


CNMM



INSERTI - INSERTS
PAG. 197

ART.									R L (mm) </					
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-  CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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

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

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



PAG. 190



PAG. 186

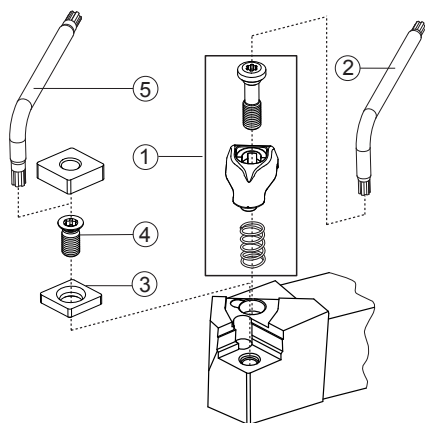


PAG. 1025



PAG. 1048

DCKNR/L $\varnothing 20 \times 20 - 32 \times 32$										DCSNR/L $\varnothing 20 \times 20 - 32 \times 32$									
75°										45°									
CNMA										CNMA									
CNMG										CNMG									
CNMM										CNMM									
D										D									
In figura utensile destro - Right-hand shown										In figura utensile destro - Right-hand shown									
.G23 .G61 .X47 .G39 .G42 .G52 .G53 .G55 .G56 .K57P .G62 .G63 .G68 .G72 .G82 .G34W										NEW									
ART. (mm)										1 2 3 4 5									
h=h1 b f l1 l2 Nm																			
DCKNR/L 2020 K 12										1204 100-21 5415 3612 125011 5420									
DCKNR/L 2525 M 12																			
DCKNR/L 3232 P 12																			
DCSNR/L 2020 K 12										1204 100-21 5415 3612 125011 5420									
DCSNR/L 2525 M 12																			
DCSNR/L 3232 P 12																			



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

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

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

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



PAG. 190



PAG. 186

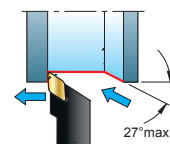


PAG. 1025



PAG. 1048

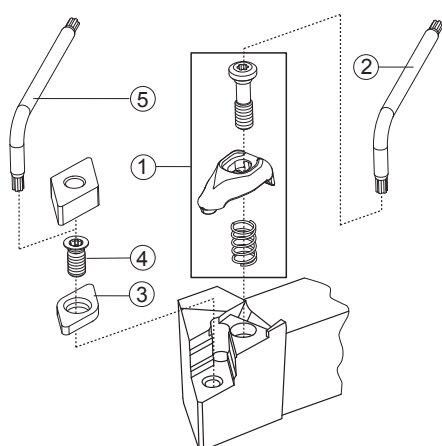
□ 20x20 - 32x32



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



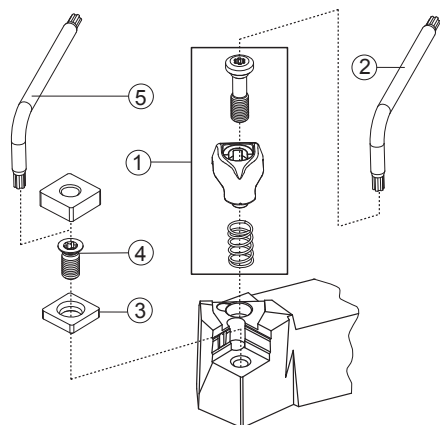
														 INSERTI - INSERTS PAG. 199			
.G23	.G39	.G42	.G52	.G53	.G55	.G56	.G62	.G63	.G68	.G72	.G34W						
ART. (mm)												①	②	③	④	⑤	
			h=h1	b	f	l1	l2	Nm									
DDJNR/L 2020 K 15			20	20	25	125	35	3,9	1506	100-21	5415	3715	125011	5420			
DDJNR/L 2525 M 15			25	25	32	150	36	3,9									
DDJNR/L 3232 P 15			32	32	40	170	40	3,9									



► **Vc**



DSKNR/L										ϕ 20x20 - 32x32				DSSNR/L										ϕ 20x20 - 25x25															
75°														45°																									
SNMA														SNMA																									
SNMG														SNMG																									
SNMM														SNMM																									
D														D																									
In figura utensile destro - Right-hand shown														In figura utensile destro - Right-hand shown																									
.G61										.G52		.G53		.G55		.G56		.G62		.G54		.G72		.G82						INSERTI - INSERTS PAG. 200									
ART.										(mm)																													
												h=h1		b		f		l1		l2		Nm																	
DSKNR/L										2020		K		12		20		20		25		125		30		3,9		1204		100-21		5415		3512		125011		5420	
DSKNR/L										2525		M		12		25		25		32		150		26		3,9													
DSKNR/L										3232		P		12		32		32		40		170		30		3,9													
DSKNR/L										3232		P		15		32		32		40		170		30		6,4		1506		100-31		5420		3515		126011		5425	
DSSNR/L										2020		K		12		20		20		25		125		35		3,9		1204		100-21		5415		3512		125011		5420	
DSSNR/L										2525		M		12		25		25		32		150		36		3,9													

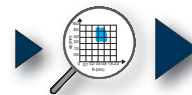


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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 Vc. SCHNITTGESCHWINDIGKEIT
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PAG. 190



PAG. 186



PAG. 1025

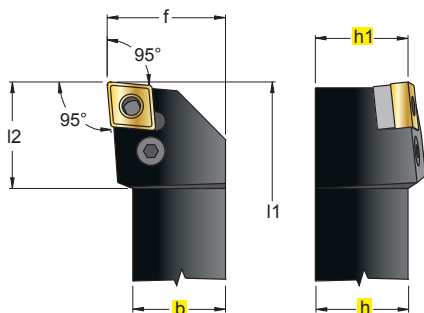


PAG. 1048

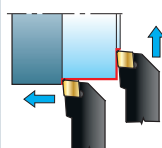
PCLNR/L

Ø 16x16 - 40x40

95°



In figura utensile destro - Right-hand shown



CNMA

CNMG

CNMM

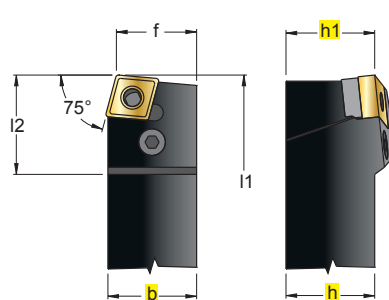
P



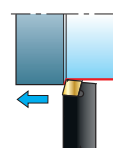
PCBNR/L

Ø 20x20 - 40x40

75°



In figura utensile destro - Right-hand shown



CNMA

CNMG

CNMM

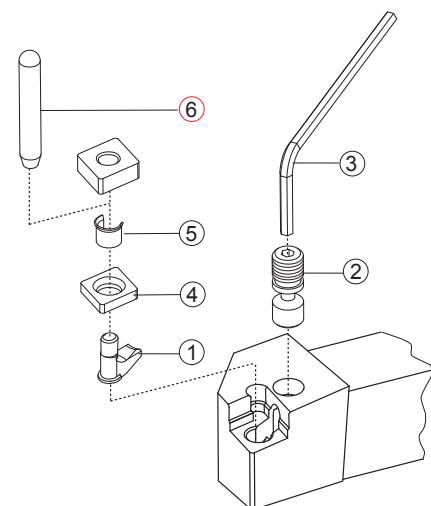
P



.G23	.G61	.X47	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82	.G34W		

INSERTI - INSERTS
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ART.	(mm)	h=h1	b	f	l1	l2		1	2	3	4	5	6
PCLNR/L 1616 H 09		16	16	20	100	22	0903	8009	1606	5025	3608	4109	0009
PCLNR/L 2020 K 09		20	20	25	125	26							
PCLNR/L 2525 M 09		25	25	32	150	25							
PCLNR/L 2020 K 12		20	20	25	125	28	1204	8012	1608	5003	3612	4112	0012
PCLNR/L 2525 M 12		25	25	32	150	33							
PCLNR/L 3225 P 12		32	25	32	170	28							
PCLNR/L 3232 P 12		32	32	40	170	30							
PCLNR/L 2525 M 16		25	25	32	150	33	1606	8016	1618	5003	3616	4115	0015
PCLNR/L 3225 P 16		32	25	32	170	33							
PCLNR/L 3232 P 16		32	32	40	170	33							
PCLNR/L 2525 M 19		25	25	32	150	36	1906	8019	1610	5004	3619	4119	0019
PCLNR/L 3232 P 19		32	32	40	170	40							
PCLNR/L 4040 S 19		40	40	50	250	40							
PCBNR/L 2020 K 12		20	20	17	125	28	1204	8012	1608	5003	3612	4112	0012
PCBNR/L 2525 M 12		25	25	22	150	29							
PCBNR/L 3225 P 12		32	25	22	170	32							
PCBNR/L 2525 M 16		25	25	22	150	29	1606	8016	1618	5003	3616	4115	0015
PCBNR/L 3225 P 16		32	25	22	170	32							
PCBNR/L 3232 P 16		32	32	27	170	35							
PCBNR/L 3232 P 19		32	32	27	170	35	1906	8019	1610	5004	3619	4119	0019
PCBNR/L 4040 S 19		40	40	35	250	37							



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
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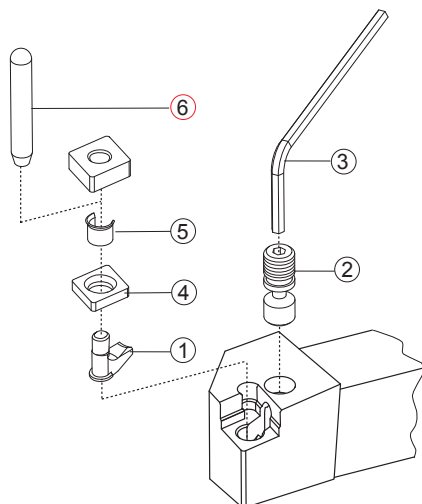


PAG. 1025



PAG. 1048

PCKNR/L										PCSNR/L									
⌀ 20x20 - 40x40										⌀ 20x20 - 32x32									
75°										45°									
CNMA										CNMA									
CNMG										CNMG									
CNMM										CNMM									
P										P									
In figura utensile destro - Right-hand shown										In figura utensile destro - Right-hand shown									
ART. (mm)										INSERTI - INSERTS PAG. 197									
h=h1 b f l1 l2																			
PCKNR/L 2020 K 12										1204 8012 1608 5003 3612 4112 0012									
PCKNR/L 2525 M 12										1606 8016 1618 5003 3616 4115 0015									
PCKNR/L 2525 M 16										1906 8019 1610 5004 3619 4119 0019									
PCKNR/L 3232 P 16																			
PCKNR/L 3232 P 19																			
PCKNR/L 4040 S 19																			



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
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PAG. 186



PAG. 1025

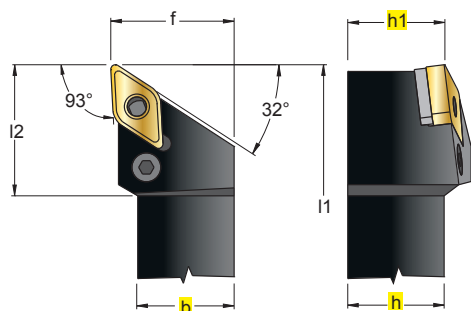


PAG. 1048

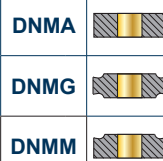
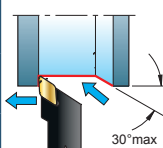
PDJNR/L

16x16 - 32x32

93°



In figura utensile destro - Right-hand shown

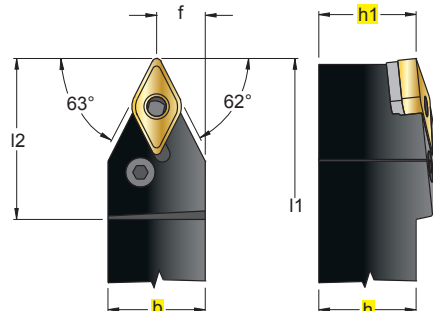


P

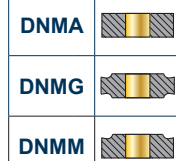
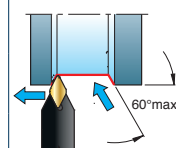
PDNNR/L

16x16 - 32x32

63°

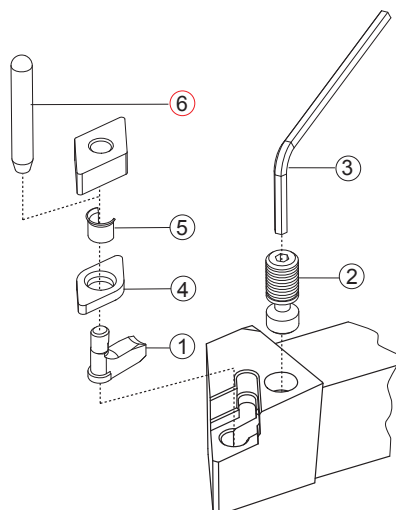


In figura utensile destro - Right-hand shown



P

																		
												INSERTI - INSERTS PAG. 199						
ART. (mm)																		
				h=h1	b	f	l1	l2										
PDJNR/L	1616	H	11	16	16	20	100	30	1104	8411	1606	5025	3710	4108	0009			
PDJNR/L	2020	K	11	20	20	25	125	30										
PDJNR/L	2525	M	11	25	25	32	150	30										
PDJNR/L	2020	K	15	20	20	25	125	35	1506	8415	1638	5003	3715	4112	0012			
PDJNR/L	2525	M	15	25	25	32	150	35										
PDJNR/L	3225	P	15	32	25	32	170	35										
PDJNR/L	3232	P	15	32	32	40	170	36										
PDNNR/L	1616	H	11	New	16	16	8,0	100	25	1104	8411	1606	5025	3710	4108	0009		
PDNNR/L	2020	K	11	New	20	20	12,0	125	25									
PDNNR/L	2525	M	11	New	25	25	12,0	150	29									
PDNNR/L	2020	K	15		20	20	12,0	125	35	1506	8415	1638	5003	3715	4112	0012		
PDNNR/L	2525	M	15		25	25	12,0	150	37									
PDNNR/L	3225	P	15		32	25	12,0	170	37									
PDNNR/L	3232	P	15		32	32	16,8	170	37									



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
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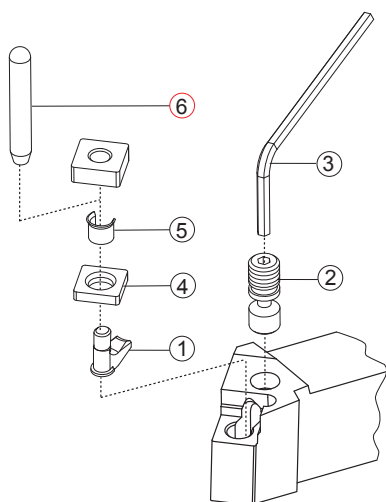


PAG. 1025



PAG. 1048

PSBNR/L $\varnothing 20 \times 20 - 40 \times 40$									PSDNN $\varnothing 16 \times 16 - 32 \times 32$								
75°									45°								
In figura utensile destro - Right-hand shown																	
									 INSERTI - INSERTS PAG. 200								
ART. (mm)																	
 h=h1 b f l1 l2									 ① ② ③ ④ ⑤ ⑥								
PSBNR/L 2020 K 12			20	20	17	125	28		1204	8012	1608	5003	3512	4112	0012		
PSBNR/L 2525 M 12			25	25	22	150	29										
PSBNR/L 2525 M 15			25	25	22	150	32		1506	8016	1618	5003	3515	4115	0015		
PSBNR/L 3232 P 15			32	32	27	170	32										
PSBNR/L 3232 P 19			32	32	27	170	39		1906	8019	1610	5004	3519	4119	0019		
PSBNR/L 4040 S 19			40	40	35	250	39										
PSDNN 1616 H 12 New			16	16	8,3	100	30		1204	8012	1608	5003	3512	4112	0012		
PSDNN 2020 K 12			20	20	10,3	125	28										
PSDNN 2525 M 12			25	25	12,8	150	29										
PSDNN 3232 P 19			32	32	16,5	170	40		1906	8019	1610	5004	3519	4119	0019		

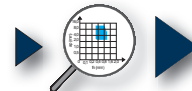


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
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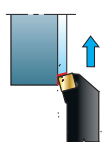
PAG. 1025



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□ 16x16 - 40x40

45°



P



Technical drawing of a 45° V-bur bit. The front view (left) shows a square shank with a 45° cutting edge, a central hole, and dimensions: f (shank width), l_1 (total length), l_2 (height to cutting edge), and b (cutting edge width). The side view (right) shows the bit's profile with dimensions: h_1 (height to cutting edge) and h (cutting edge height).

P



In figura utensile destro - Right-hand shown

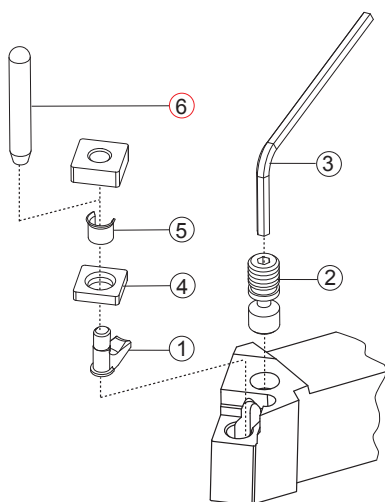


INSERTI - INSERTS
PAG. 200

(mm)



PSKNR/L	2020	K	12	20	20	25	125	26	1204	8012	1608	5003	3512	4112	0012	
PSKNR/L	2525	M	12	25	25	32	150	26								
PSKNR/L	2525	M	15	25	25	32	150	30	1506	8016	1618	5003	3515	4115	0015	
PSKNR/L	3232	P	15	32	32	40	170	34								
PSKNR/L	3232	P	19	32	32	40	170	34	1906	8019	1610	5004	3519	4119	0019	
PSKNR/L	4040	S	19	40	40	50	250	38								
PSSNR/L	1616	H	12	New	16	16	20	100	26	1204	8012	1608	5003	3512	4112	0012
PSSNR/L	2020	K	12		20	20	25	125	29							
PSSNR/L	2525	M	12		25	25	32	150	29							
PSSNR/L	3225	P	12		32	25	32	170	29							
PSSNR/L	2525	M	15		25	25	32	150	36	1506	8016	1618	5003	3515	4115	0015
PSSNR/L	3232	P	15		32	32	40	170	40							
PSSNR/L	3232	P	19		32	32	40	170	40	1906	8019	1610	5004	3519	4119	0019
PSSNR/L	4040	S	19		40	40	50	250	40							



 DATI TECNICI E CONSIGLI
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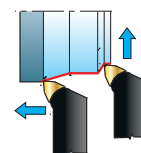


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PTFNR/L							ϕ 20x20 - 32x32				PTGNR/L							ϕ 20x20 - 32x32			
90°											90°										

□ 20x20 - 32x32

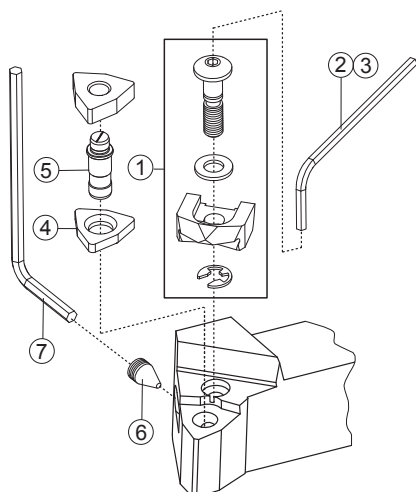
Technical drawing of a 90° elbow fitting. The front view (left) shows a 90° elbow with dimensions: f (flange width), l_2 (flange height), l_1 (total height), and b (base width). The side view (right) shows the profile with dimensions: h_1 (total height) and h (base height).



M



														 INSERTI - INSERTS PAG. 202		
.G23	.G61	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G34W						
ART. (mm)																
			h=h1	b	f	l1	l2									
MWLNRL 2020 K 06			20	20	25	125	31	0604	100-53	—	5510	3306	4188	VL03L	—	
MWLNRL 2525 M 06			25	25	32	150	25									
MWLNRL 2020 K 08N			20	20	25	125	28	0804	100-52	5025	—	3308M	4192	4196	5003	
MWLNRL 2525 M 08N			25	25	32	150	31									
MWLNRL 3232 P 08N			32	32	40	170	31									

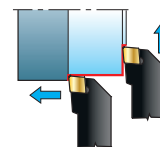
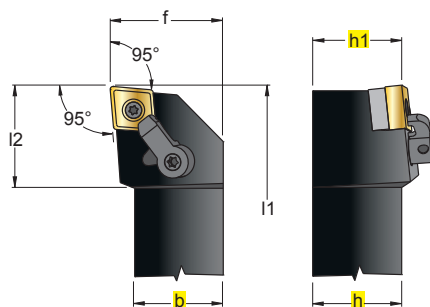


► **Vc**



□ 20x20 - 40x40

95°



M



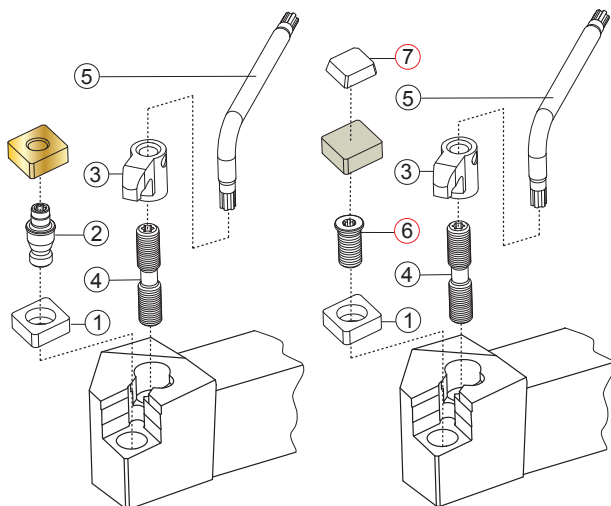
INSERTI - INSERTS
PAG. 197

[illegible]

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

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

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



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

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 DETTAGLIO RICAMBI
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 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

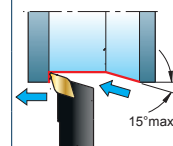
PAG. 1025

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

PAG. 1048

25x25

107.5°



In figura utensile destro - Right-hand shown



INSERTI - INSERTS
 PAG. 199

(mm)



h=h1

f

11

1



2

3

4

5

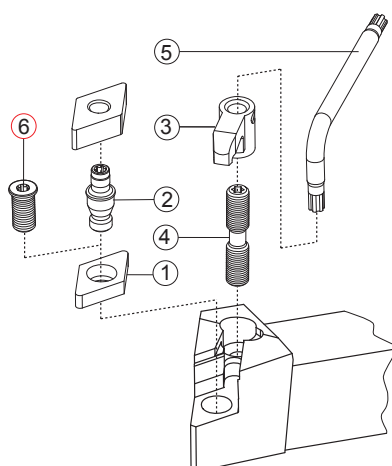
6

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

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

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

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



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

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

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

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



PAG. 190



PAG. 186



PAG. 1025



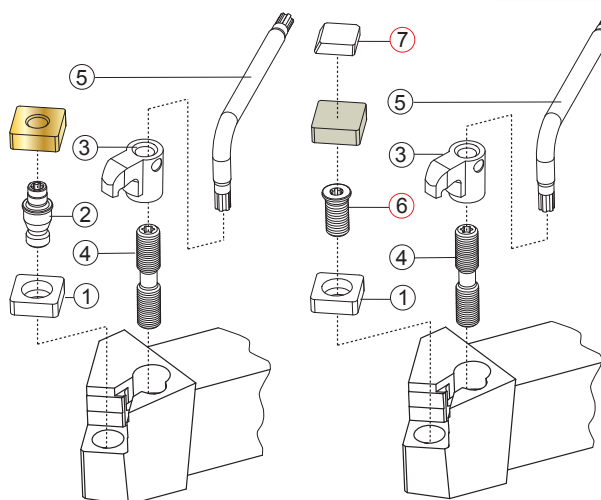
PAG. 1048

MSSNR/L $\varnothing 20 \times 20 - 40 \times 40$								MSBNR/L $\varnothing 32 \times 32 - 40 \times 40$							
45°								75°							
SNMA								SNMA							
SNMG								SNMG							
SNMM								SNMM							
M								M							
In figura utensile destro - Right-hand shown								In figura utensile destro - Right-hand shown							
.G61	.G52	.G53	.G55	.G56	.G62	.G54	.G72	.G82							
ART. (mm)															
									1	2	3	4	5	6	7
h=h1															
b															
f															
l1															
l2															
MSSNR/L 2020 K 12			20	20	25	125	32	1204	KSN433	KLM 46	CKM 21	STCM20	5415	KMS 4	RSN1225
MSSNR/L 2525 M 12			25	25	32	150	33								
MSSNR/L 3232 P 12			32	32	40	170	40								
MSSNR/L 3232 P 19			32	32	40	170	40	1906	KSN633	KLM 68	CKM 12	STCM4	5425	KMS 6	-
MSSNR/L 4040 S 19			40	40	50	250	40								
MSBNR/L 3232 P 19			32	32	27	170	39	1906	KSN633	KLM 68	CKM 12	STCM4	5425	KMS 6	-
MSBNR/L 4040 S 19			40	40	35	250	39								

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

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

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



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

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

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

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



PAG. 190



PAG. 186

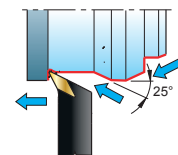


PAG. 1025



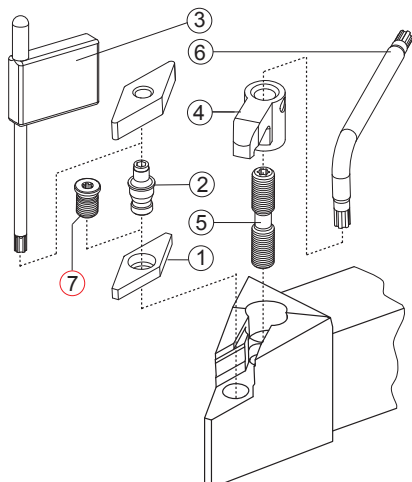
PAG. 1048

□ 20x20 - 32x32

[illegible]

INSERTI - INSERTS
PAG. 201

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



PAG. 190



PAG. 186

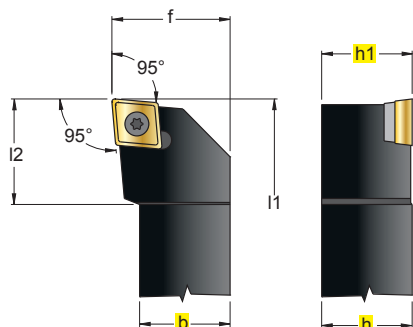
PAG. 1025

PAG. 1048

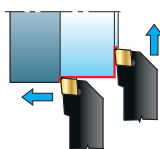
SCLCR/L

Ø 08x08 - 25x25

95°



In figura utensile destro - Right-hand shown



CC.T

CC.W

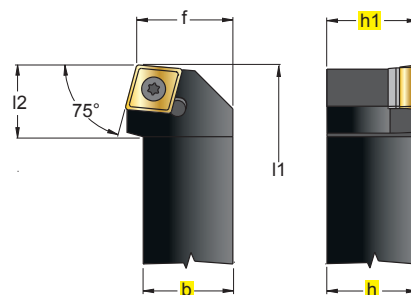
S



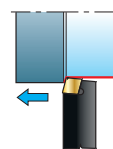
SCRCR/L

Ø 08x08 - 25x25

75°



In figura utensile destro - Right-hand shown



CC.T

CC.W

S

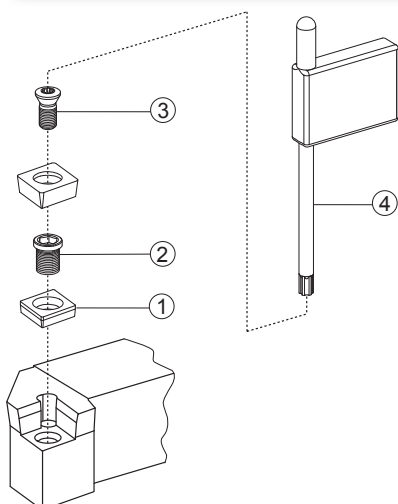


NEW								NEW								INSERTI - INSERTS PAG. 203						
																						
ART.								(mm)										1 	2 	3 	4 	
		h=h1		b	f	l1	l2	Nm														
SCLCR/L	0808	D 06	8	8	10	60	10	1,1+1,3		0602	-		-		12256P		5508P					
SCLCR/L	1010	E 06	10	10	12	70	10	1,1+1,3														
SCLCR/L	1212	F 09	12	12	16	80	15	3,8+5,0		09T3	-		-		12409P		5515P					
SCLCR/L	1616	H 09	16	16	20	100	15	3,0+3,5		09T3	3609		BCL7		123511P		5515P					
SCLCR/L	2020	K 09	20	20	25	125	17	3,0+3,5														
SCLCR/L	2525	M 09	25	25	32	150	18	3,0+3,5														
SCLCR/L	1616	H 12	16	16	20	100	20	4,0+5,0		1204	3611		BCL15		124513P		5520P					
SCLCR/L	2020	K 12	20	20	25	125	20	4,0+5,0														
SCLCR/L	2525	M 12	25	25	32	150	20	4,0+5,0														
 - PER UTENSILE R MONTARE INSERTO CCET..R.B22 , PER UTENSILE L MONTARE INSERTO CCET..L.B22  - FOR R TOOL FIT INSERT CCET..R.B22, FOR L TOOL FIT INSERT CCET..L.B22  - FÜR DAS WERKZEUG R DIE WENDEPLATTE CCET..R.B22 EINSETZEN; FÜR DAS WERKZEUG L DIE WENDEPLATTE CCET..L.B22...  - DANS LE CAS DE L'OUTIL R MONTER LA PLAQUETTE CCET..R.B22, DANS LE CAS DE L'OUTIL L MONTER LA PLAQUETTE CCET..L.B22																						

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

SCRCR/L 0808 D 06	8	8	9	60	10	1,1+1,3	0602	-	-	12256P	5508P
SCRCR/L 1010 E 06	10	10	11	70	10	1,1+1,3					
SCRCR/L 1212 F 09	12	12	13	80	15	3,8+5,0	09T3	-	-	12409P	5515P
SCRCR/L 1616 H 09	16	16	17	100	15	3,0+3,5	09T3	3609	BCL7	123511P	5515P
SCRCR/L 2020 K 09	20	20	22	125	18	3,0+3,5					
SCRCR/L 1616 H 12	16	16	17	100	20	4,0+5,0	1204	3611	BCL15	124513P	5520P
SCRCR/L 2020 K 12	20	20	22	125	20	4,0+5,0					
SCRCR/L 2525 M 12	25	25	27	150	20	4,0+5,0					

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

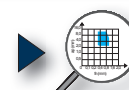


- CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
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 - EINSATZGEBIETE FÜR DREHPLATTEN
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 - Vc. CUTTING SPEED
 - Vc. SCHNITTGESCHWINDIGKEIT
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 - TECHNISCHE DATEN UND EMPFEHLUNGEN
 - DONNÉES TECHNIQUES ET CONSEILS



PAG. 190



PAG. 186

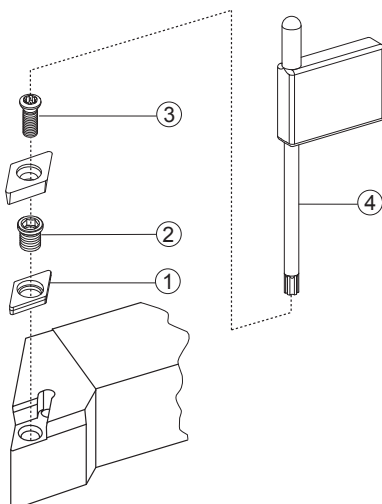


PAG. 1025



PAG. 1048

SDHCR/L $\varnothing 10 \times 10 - 25 \times 25$								SDJCR/L $\varnothing 08 \times 08 - 25 \times 25$							
107,5°								93°							
In figura utensile destro - Right-hand shown								In figura utensile destro - Right-hand shown							
NEW								NEW							
ART. (mm)															
h=h1 b f l1 l2 Nm								0702 11T3							
SDHCR/L 1010 E 07								— — 12256P 5508P							
SDHCR/L 1212 F 07								— — 12256P 5508P							
SDHCR/L 1616 H 11								3711 BCL7 123511P 5515P							
SDHCR/L 2020 K 11								3711 BCL7 123511P 5515P							
SDHCR/L 2525 M 11								3711 BCL7 123511P 5515P							
SDJCR/L 0808 D 07								— — 12256P 5508P							
SDJCR/L 1010 E 07								— — 12256P 5508P							
SDJCR/L 1212 F 07								— — 12256P 5508P							
SDJCR/L 1212 F 11								3711 BCL7 123511P 5515P							
SDJCR/L 1616 H 11								3711 BCL7 123511P 5515P							
SDJCR/L 2020 K 11								3711 BCL7 123511P 5515P							
SDJCR/L 2525 M 11								3711 BCL7 123511P 5515P							

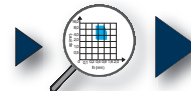


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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

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 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

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 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 190



PAG. 186

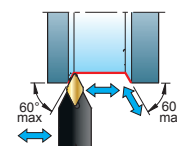


PAG. 1025



PAG. 1048

Ø 08x08 - 25x25



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

A cross-sectional diagram of a block with a tapered hole. The hole has a central cylindrical section and two tapered sections on either side. The taper angle is indicated as 7° .

S



INSERTI - INSERTS
PAG. 204

(mm)



h=h1



Nm



1

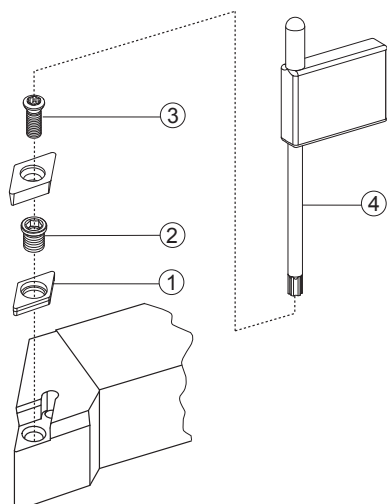
2

3

4



SDNCN	0808	D	07	8	8	4,0	60	9	1,1+1,3	0702	—	—	12256P	5508P
SDNCN	1010	E	07	10	10	5,0	70	11	1,1+1,3		—	—	12409P	5515P
SDNCN	1212	F	07	12	12	6,0	80	13	1,1+1,3		—	—	12409P	5515P
SDNCN	1212	F	11	12	12	6,0	80	12	3,8+5,0	11T3	—	—	12409P	5515P
SDNCN	1616	H	11	16	16	8,0	100	16	3,0+3,5	11T3	3711	BCL7	123511P	5515P
SDNCN	2020	K	11	20	20	10,0	125	20	3,0+3,5		—	—	12409P	5515P
SDNCN	2525	M	11	25	25	12,5	150	25	3,0+3,5		—	—	12409P	5515P



PAG. 190



PAG. 186



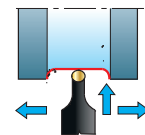
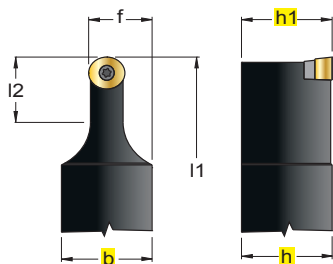
PAG. 1025



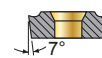
PAG. 1048

SRDCN

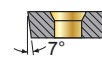
12x12 - 25x25



RC.T



RC.W



S



.Z57

.G52



INSERTI - INSERTS
PAG. 205

ART.

(mm)



h=h1

b

f

l1

l2

Nm



1

2

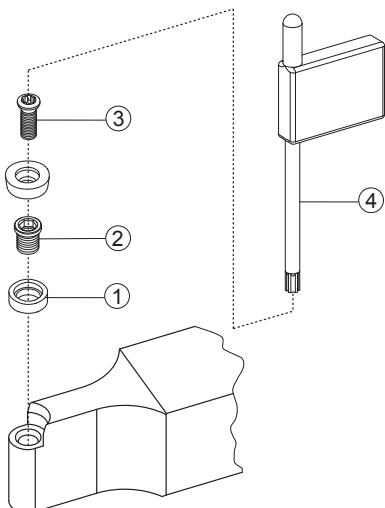
3

4

5



SRDCN	1212	F	06	12	12	9,0	80	12,5	1,1+1,3	0602M0	—	—	12256P	5508P
SRDCN	1616	H	06	16	16	11,0	100	12,5	1,1+1,3	0803M0	—	—	123008P	5508P
SRDCN	2020	K	06	20	20	13,0	125	12,5	1,1+1,3		—	—	123008P	5508P
SRDCN	2525	M	06	25	25	15,5	150	12,5	1,1+1,3		—	—	123008P	5508P
SRDCN	1616	H	08	16	16	12,0	100	16,5	1,2+1,5	1003M0	—	—	123008P	5508P
SRDCN	2020	K	08	20	20	14,0	125	16,5	1,2+1,5		—	—	123008P	5508P
SRDCN	2525	M	08	25	25	16,5	150	16,5	1,2+1,5		—	—	123008P	5508P
SRDCN	1616	H	10	16	16	13,0	100	20,5	3,0+3,5		—	—	123008P	5508P
SRDCN	2020	K	10	20	20	15,0	125	20,5	3,0+3,5	1003M0	3810	BCL7	123511P	5515P
SRDCN	2525	M	10	25	25	17,5	150	20,5	3,0+3,5		3810	BCL7	123511P	5515P



CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
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VELOCITÀ DI TAGLIO Vc
Vc. CUTTING SPEED
Vc. SCHNITTGESCHWINDIGKEIT
Vc. VITESSE DE COUPE

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

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



PAG. 190



PAG. 186



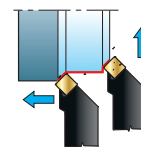
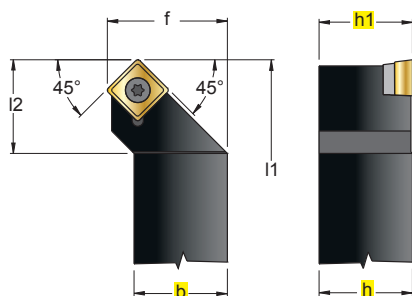
PAG. 1025



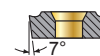
PAG. 1048

Ø 12x12 - 25x25

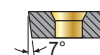
45°



SC.T



SC.W



S



INSERTI - INSERTS
PAG. 205



ART.

.G52

(mm)



Nm



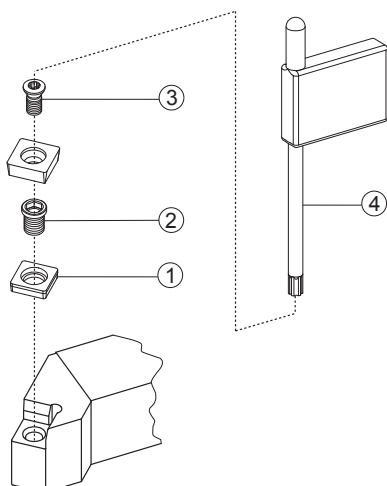
1

③

4



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



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

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

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

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



PAG. 190



PAG. 186



PAG. 1025

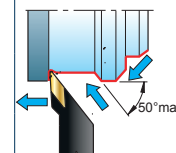


PAG. 1048

STFCR/L		ϕ 08x08 - 25x25				STGCR/L		ϕ 08x08 - 25x25			
90°						90°					
TC.T						TC.T					
TC.W						TC.W					
S						S					
In figura utensile destro - Right-hand shown						In figura utensile destro - Right-hand shown					
.G39		.G57P		.X47		.G39		.S42		.G52	
ART.		(mm)								INSERTI - INSERTS PAG. 206	
		h=h1		b		f		l1		l2	
Nm											
0902		8		8		10		60		10	
STFCR/L 0808 D 09		10		10		12		70		10	
STFCR/L 1010 E 09		12		12		16		80		14	
STFCR/L 1212 F 11		16		16		20		100		15	
STFCR/L 1616 H 11		16		16		20		100		20	
STFCR/L 1616 H 16		20		20		25		125		23	
STFCR/L 2020 K 16		25		25		32		150		23	
STFCR/L 2525 M 16											

Ø 12x12 - 32x25

93°



In figura utensile destro - Right-hand shown



INSERTI - INSERTS
PAG. 207

(mm)



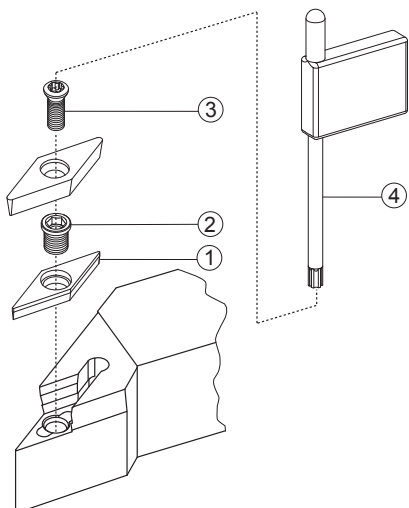
Nm

③

4

SVHCR/L 1616 H 11	16	16	20	100	15	1,1+1,3	1103	—	—	12256P	5508P
SVHCR/L 2020 K 11	20	20	25	125	18	1,1+1,3					
SVHCR/L 2525 M 11	25	25	32	150	25	1,1+1,3					
SVHCR/L 2020 K 16	20	20	25	125	17	3,0+3,5	1604	3716	BCL7	123511P	5515P
SVHCR/L 2525 M 16	25	25	32	150	23	3,0+3,5					
SVHCR/L 3225 P 16	32	25	32	170	23	3,0+3,5					

SVJCR/L 1212 F 11	12	12	16	80	21	1,1+1,3	1103	—	—	12256P	5508P
SVJCR/L 1616 H 11	16	16	20	100	24	1,1+1,3					
SVJCR/L 2020 K 11	20	20	25	125	23	1,1+1,3					
SVJCR/L 2525 M 11	25	25	32	150	27	1,1+1,3					
SVJCR/L 2020 K 16	20	20	25	125	30	3,0+3,5	1604	3716	BCL7	123511P	5515P
SVJCR/L 2525 M 16	25	25	32	150	33	3,0+3,5					
SVJCR/L 3225 P 16	32	25	32	170	33	3,0+3,5					



PAG. 190



PAG. 186



PAG. 1025



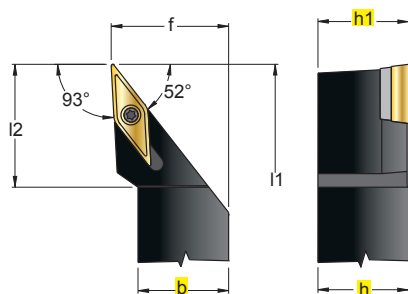
PAG. 1048

SVXCR/L		Ø 20x20 - 25x25		SVVCN		Ø 16x16 - 32x25	
VC.T		VC.W		VC.T		VC.W	
S		S		S		S	
In figura utensile destro - Right-hand shown							
.G13 .G57P .X47 .G42 .G52							
ART. (mm)							
h=h1 b f l1 l2 Nm							
SVXCR/L 2020 K 16 20 20 25 125 25 3,0÷3,5 1604							
SVXCR/L 2525 M 16 25 25 32 150 25 3,0÷3,5							

SVJBR/L

16x16 - 32x25

93°

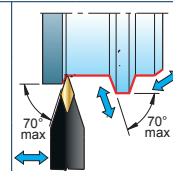
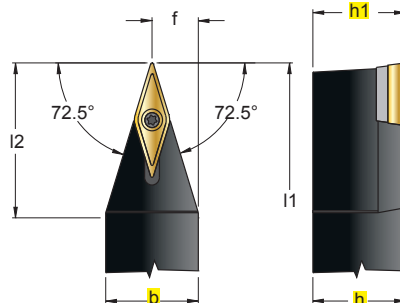


In figura utensile destro - Right-hand shown

SVVBN

20x20 - 32x25

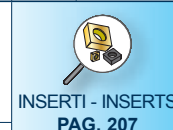
72,5°



NEW



.X47 .G42 .G52 .G58



INSERTI - INSERTS
PAG. 207

ART.

(mm)



h=h1

b

f

l1

l2

Nm



1

2

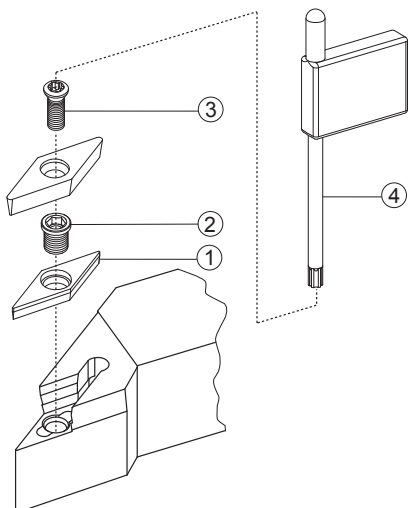
3

4

5

SVJBR/L	1616	H	16	16	16	20	100	30	3,0+3,5	1604	3716	BCL7	123511P	5515P
SVJBR/L	2020	K	16	20	20	25	125	30	3,0+3,5					
SVJBR/L	2525	M	16	25	25	32	150	33	3,0+3,5					
SVJBR/L	3225	P	16	32	25	32	170	33	3,0+3,5					

SVVBN	2020	K	16	20	20	10,0	125	34	3,0+3,5	1604	3716	BCL7	123511P	5515P
SVVBN	2525	M	16	25	25	12,5	150	42	3,0+3,5					
SVVBN	3225	P	16	32	25	12,5	170	42	3,0+3,5					

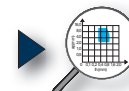


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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

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

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



PAG. 190



PAG. 186



PAG. 1025

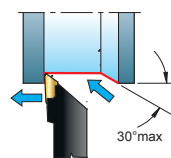
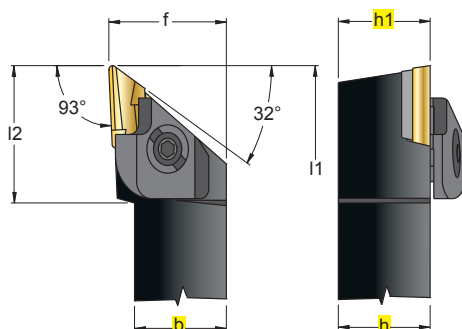


PAG. 1048

CKJNR/L

Ø 20x20 - 32x32

93°



KNUX



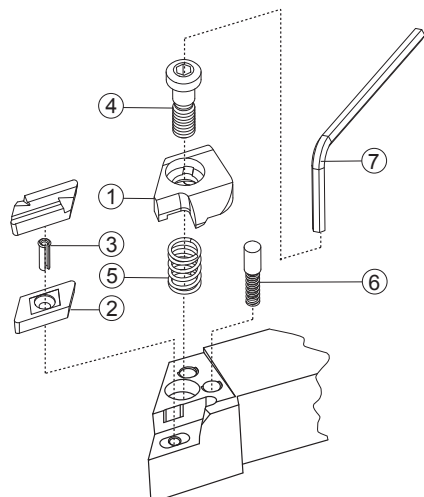
C



In figura utensile destro - Right-hand shown

ART. (mm)										INSERTI - INSERTS PAG. 200						
										1	2	3	4	5	6	7
CKJNR	2020	K	16	20	20	30	125	32	1604...-R	2316	3226	4012	1614	4295	4204	5004
CKJNR	2525	M	16	25	25	32	150	32								
CKJNR	3232	P	16	32	32	40	170	32								
CKJNL	2020	K	16	20	20	30	125	32	1604...-L	2326	3236	4012	1614	4295	4204	5004
CKJNL	2525	M	16	25	25	32	150	32								
CKJNL	3232	P	16	32	32	40	170	32								

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



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

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

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

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



PAG. 190



PAG. 186



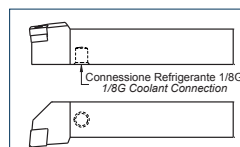
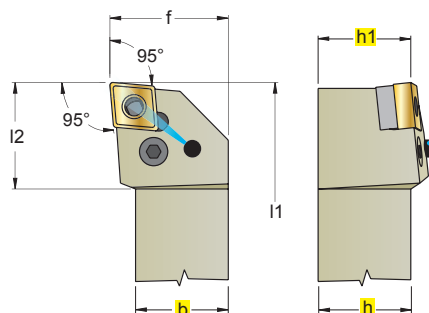
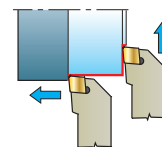
PAG. 1025



PAG. 1048

□ 20x20 - 32x32

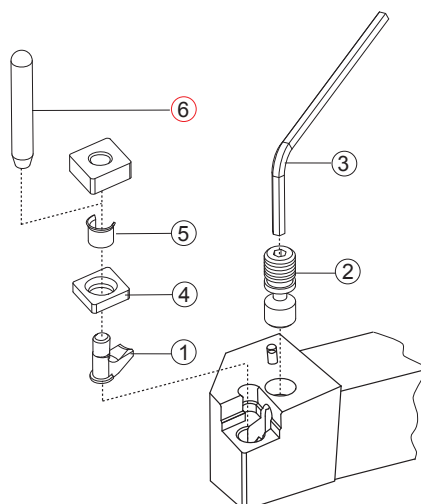
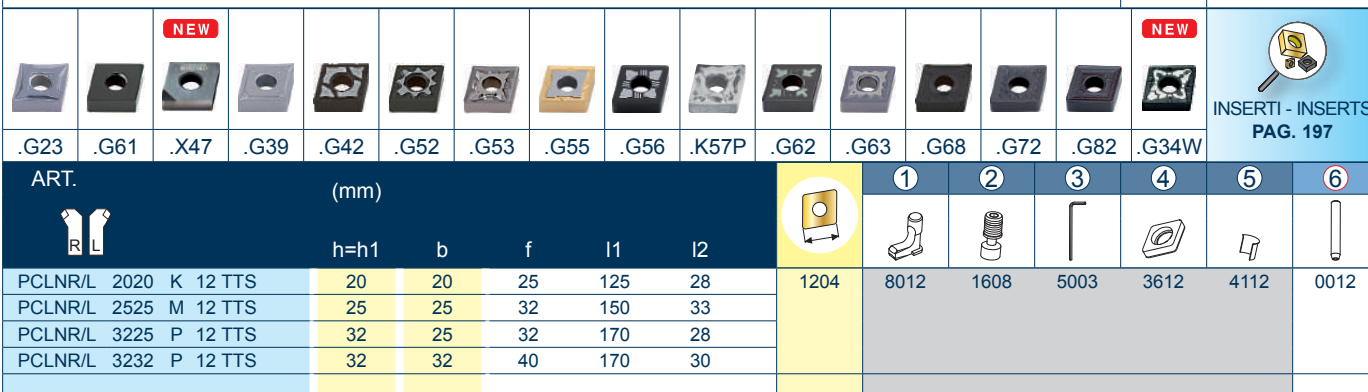
**RANGE DI
UTILIZZO**
15÷80 bar
APPLICATION
RANGE
15÷80 bar



P



INSERTI - INSERTS
PAG. 197



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



PAG. 190



PAG. 186



PAG. 1025

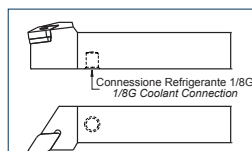
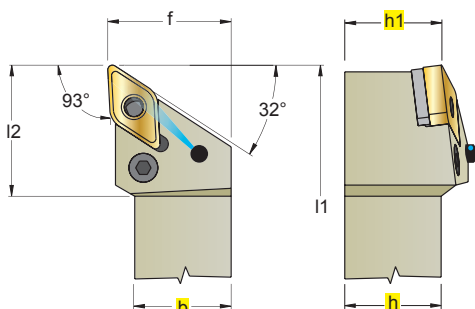
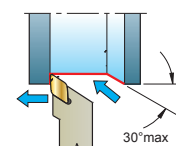


PAG. 1048

20x20 - 32x32



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



DNMA



DNMG



DNMM

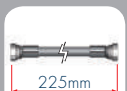


P

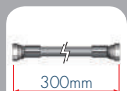


150mm

PAG. 1022



PAG. 1022



PAG. 1022



PAG. 1023



PAG. 1022



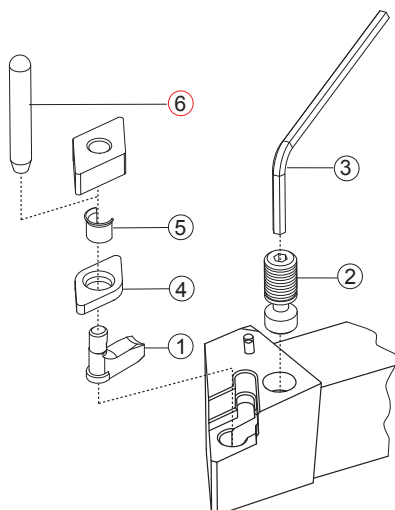
PAG. 1022



PAG. 1023



PAG. 1023



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

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

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 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 190



PAG. 186



PAG. 1025

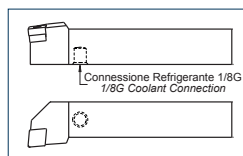
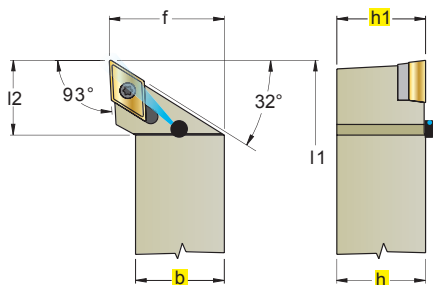
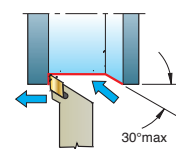


PAG. 1048

20x20 - 25x25



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



DC.T



DC.W



S



INSERTI - INSERTS
PAG. 204

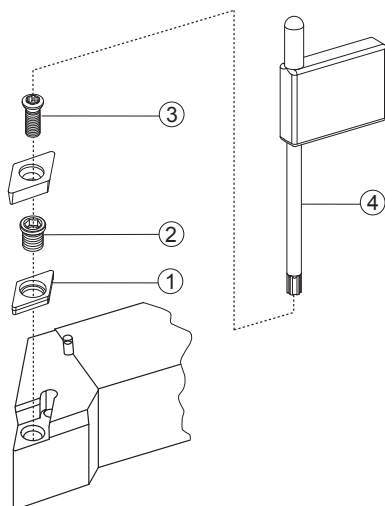
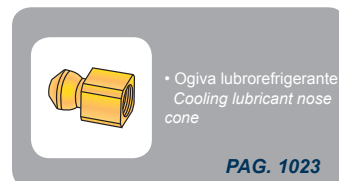
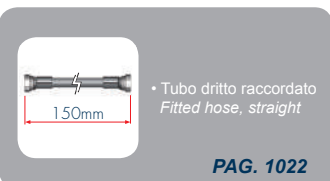
ART.																						
(mm)																						
R L																						
h=h1																						
b																						
f																						
l1																						
l2																						
Nm																						
SDJCR/L 2020 K 11 TTS											20	20	25	125	23	3,0+3,5	11T3	1	2	3	4	
SDJCR/L 2525 M 11 TTS											25	25	32	150	27	3,0+3,5						

• Tubo dritto raccordato
Fitted hose, straight
150mm
PAG. 1022

• Tubo dritto raccordato
Fitted hose, straight
225mm
PAG. 1022

• Tubo dritto raccordato
Fitted hose, straight
300mm
PAG. 1022

• Ogiva lubrorefrigerante
Cooling lubricant nose cone
PAG. 1023

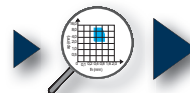


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
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 DATI TECNICI E CONSIGLI
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 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES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



PAG. 190



PAG. 186

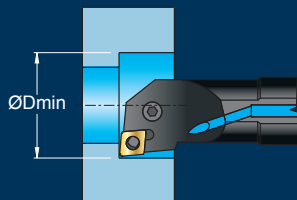


PAG. 1025



PAG. 1048

90

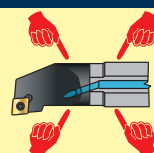


UTENSILI CON STELO IN METALLO DURO

TOOLS WITH CARBIDE SHAFT

WERKZEUGE MIT HM-SCHAFT

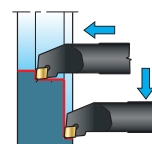
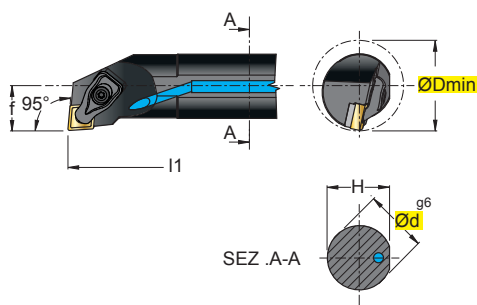
OUTILS AVEC QUEUE EN METAL DUR



S	S	S	S	S
A..SCLCR/L Pag.107	A..SDUCR/L Pag.111	A..SDQCR/L Pag.116	A..SVOCR/L Pag.121	A..SSKCR/L Pag.125
ØDmin 8,5	ØDmin 12,5	ØDmin 16,0	ØDmin 16,0	ØDmin 20,0
CC.. 0602..	DC.. 0702..	DC.. 0702.. 11T3..	VC.. 1103.. 1604..	SC.. 09T3.. 1204..
S..SCLCR/L Pag.107	S..SDUCR/L Pag.111	E..SDQCR/L Pag.116	A..SVUCR/L Pag.122	
ØDmin 8,5	ØDmin 12,5	ØDmin 12,0	ØDmin 21,0	
CC.. 0602..	DC.. 0702..	DC.. 0702.. 11T3..	VC.. 1103.. 1604..	
A..SCLCR/L Pag.108	A..SDUCR/L Pag.112	A..SDNCR/L Pag.117	E..SVUCR/L Pag.122	
ØDmin 10,0	ØDmin 13,0	ØDmin 20,0	ØDmin 21,0	
CC.. 0602.. 09T3.. 1204..	DC.. 0702.. 11T3..	DC.. 0702.. 11T3..	VC.. 1103..	
E..SCLCR/L Pag.109	E..SDUCR/L Pag.113	A..SDXCR/L Pag.118	A..SVXCR/L Pag.123	
ØDmin 11,0	ØDmin 12,0	ØDmin 16,0	ØDmin 20,0	
CC.. 0602.. 09T3.. 1204..	DC.. 0702.. 11T3..	DC.. 0702.. 11T3..	VC.. 1103.. 1604..	
B..SCLCR/L Pag.110	B..SDUCR/L Pag.114	A..STUCR/L Pag.119	A..SVQCR/L Pag.123	
ØDmin 09,0	ØDmin 13,0	ØDmin 16,0	ØDmin 20,0	
CC.. 0602.. 09T3..	DC.. 0702.. 11T3..	TC.. 1102.. 16T3..	VC.. 1103.. 1604..	
	A..SDQCR/L Pag.115	A..STFCR/L Pag.119	A..SVQBR/L Pag.124	
	ØDmin 12,5	ØDmin 12,0	ØDmin 32,0	
	DC.. 0702..	TC.. 0902.. 1102.. 16T3..	VB.. 1604..	
	S..SDQCR/L Pag.115	E..STFCR/L Pag.120	A..SVJBR/L Pag.124	
	ØDmin 12,5	ØDmin 14,0	ØDmin 32,0	
	DC.. 0702..	TC.. 0902.. 1102.. 16T3..	VB.. 1604..	

Ø25 - Ø50

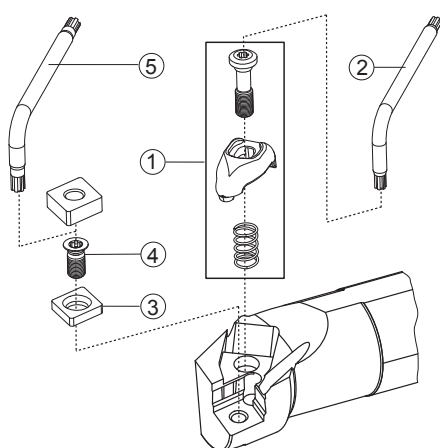
95°



D



																		
NEW NEW																	 INSERTI - INSERTS PAG. 197	
ART.	(mm)									①	②	③	④	⑤				
	ØDmin	Ød	f	H	l1	Nm												
A25R DCLNR/L 12	32	25	17	24	200	3,9	1204	100-21	5415	3612	125009	5420						
A32S DCLNR/L 12	40	32	22	31	250	3,9	1204	100-21	5415	3612	125011	5420						
A40T DCLNR/L 12	50	40	27	38	300	3,9												
A50U DCLNR/L 12	63	50	35	48	350	3,9												
A50U DCLNR/L 16	63	50	35	48	350	6,4	1606	100-31	5420	3616	126011	5425						



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

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



PAG. 190



PAG. 186



PAG. 1025

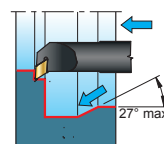
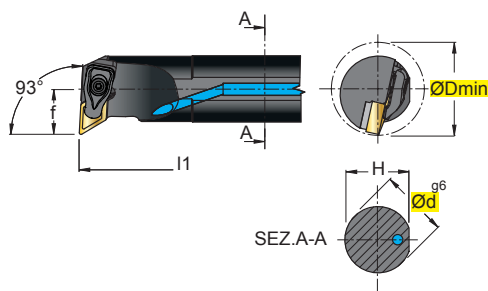


PAG. 1048

A..DDUNR/L

Ø32 - Ø50

93°



DNMA



DNMG



DNMM

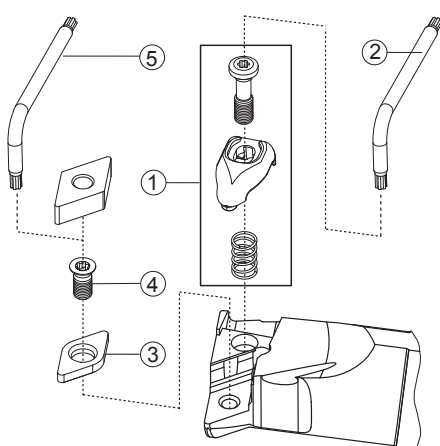


D



in figura utensile destro - right-hand shown

												NEW			 INSERTI - INSERTS PAG. 199	
.G23	.G39	.G42	.G52	.G53	.G55	.G56	.G62	.G63	.G68	.G72	.G34W					
ART.		(mm)														
				ØDmin	Ød	f	H	L1	Nm							
A32S	DDUNR/L	15		40	32	22	31,0	250	3,9	1506	100-21	5415	3715	125011	5420	
A40T	DDUNR/L	15		50	40	27	38,5	300	3,9							
A50U	DDUNR/L	15		63	50	35	48,0	350	3,9							



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

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

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

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



PAG. 190



PAG. 186



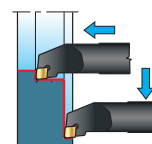
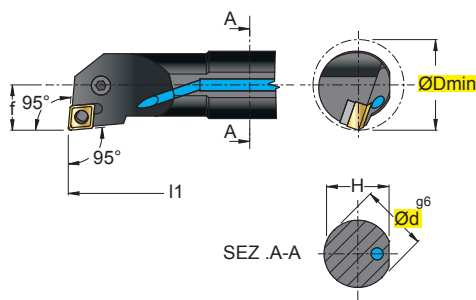
PAG. 1025



PAG. 1048

Ø20 - Ø50

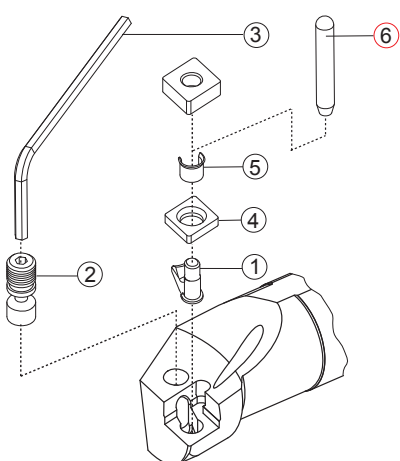
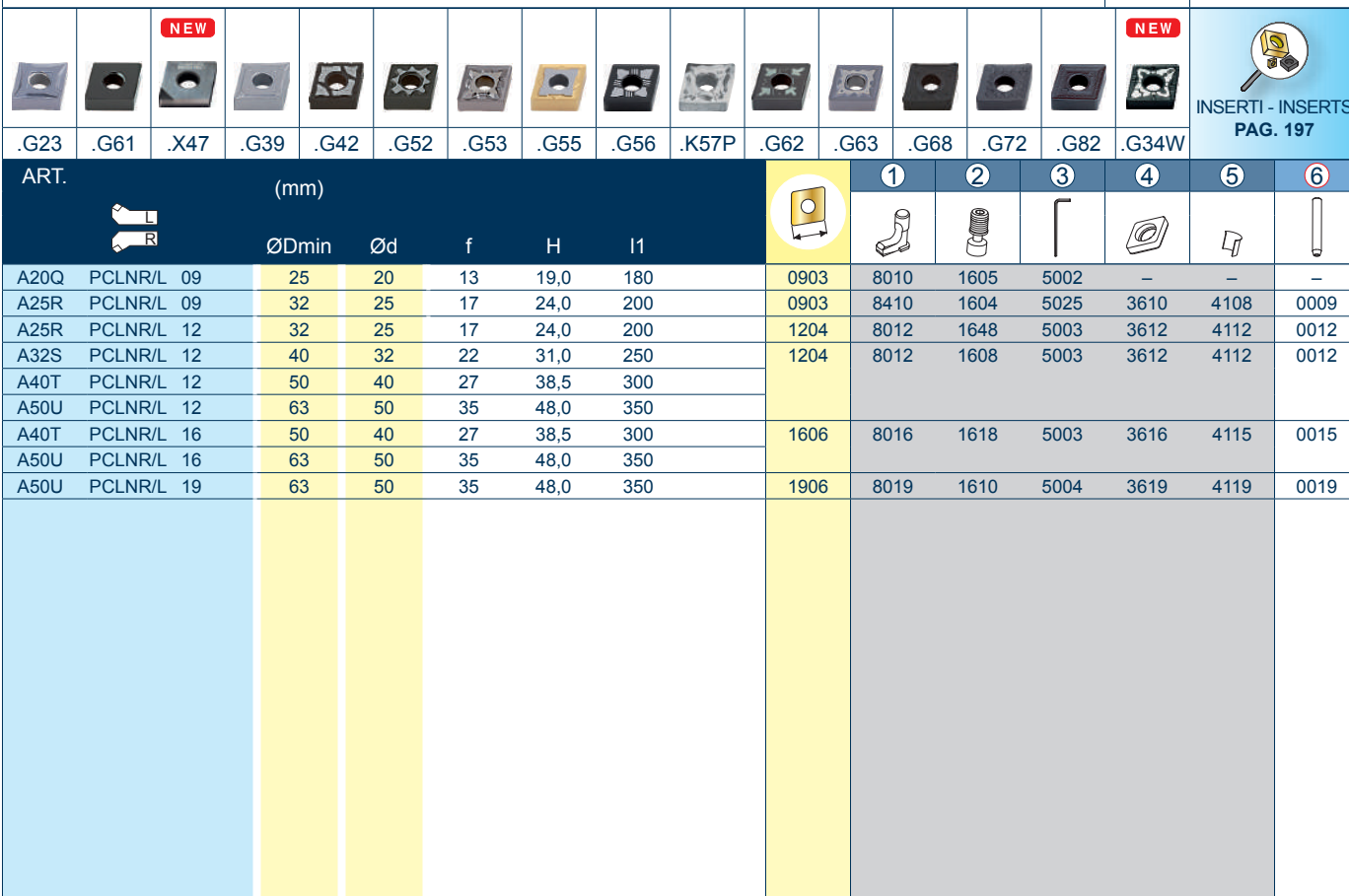
95°



P



in figura utensile destro - right-hand shown



PAG. 190

► **Vc**

PAG. 186



PAG. 1025

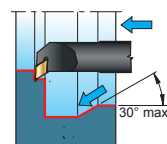
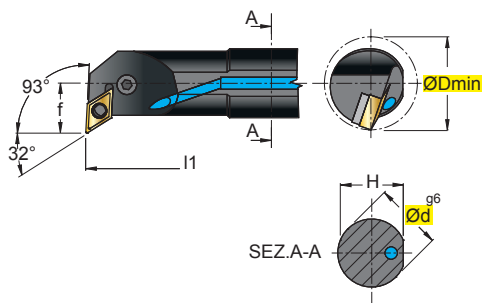


PAG. 1048

A..PDUNR/L

Ø20 - Ø50

93°



DNMA



DNMG



DNMM

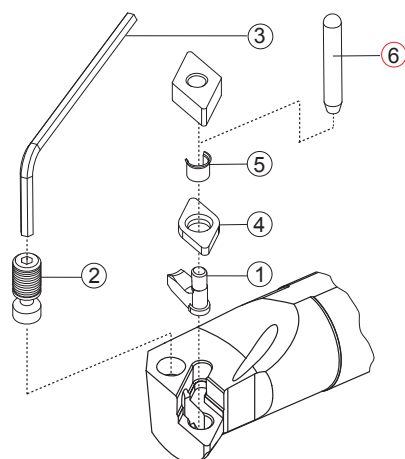


P



In figura utensile destro - Right-hand shown

												NEW			 INSERTI - INSERTS PAG. 199	
.G23	.G39	.G42	.G52	.G53	.G55	.G56	.G62	.G63	.G68	.G72	.G34W					
ART.										①	②	③	④	⑤	⑥	
		(mm)														
ØDmin		Ød		f	H	l1										
A20Q	PDUNR/L	11	27	20	16	18,0	180		1104	8410	1604	5025	—	—	—	
A25R	PDUNR/L	11	32	25	17	23,0	200		1104	8411	1606	5025	3710	4108	0009	
A32S	PDUNR/L	11	40	32	22	31,0	250		1506	8415	1638	5003	3715	4112	0012	
A32S	PDUNR/L	15	40	32	22	31,0	250									
A40T	PDUNR/L	15	50	40	27	38,5	300									
A50U	PDUNR/L	15	63	50	35	48,0	350									



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

VELOCITÀ DI TAGLIO Vc
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 Vc. SCHNITTGESCHWINDIGKEIT
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DATI TECNICI E CONSIGLI
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 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS



PAG. 190



PAG. 186



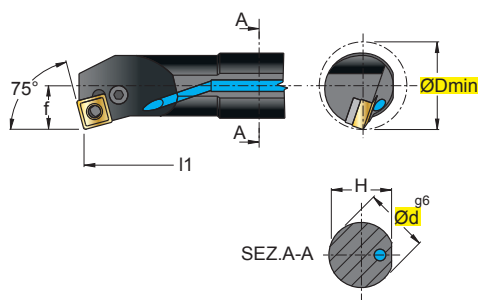
PAG. 1025



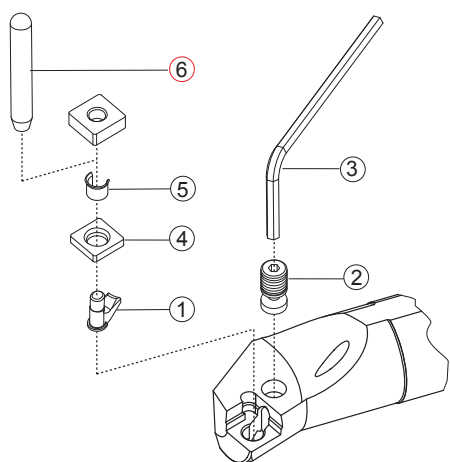
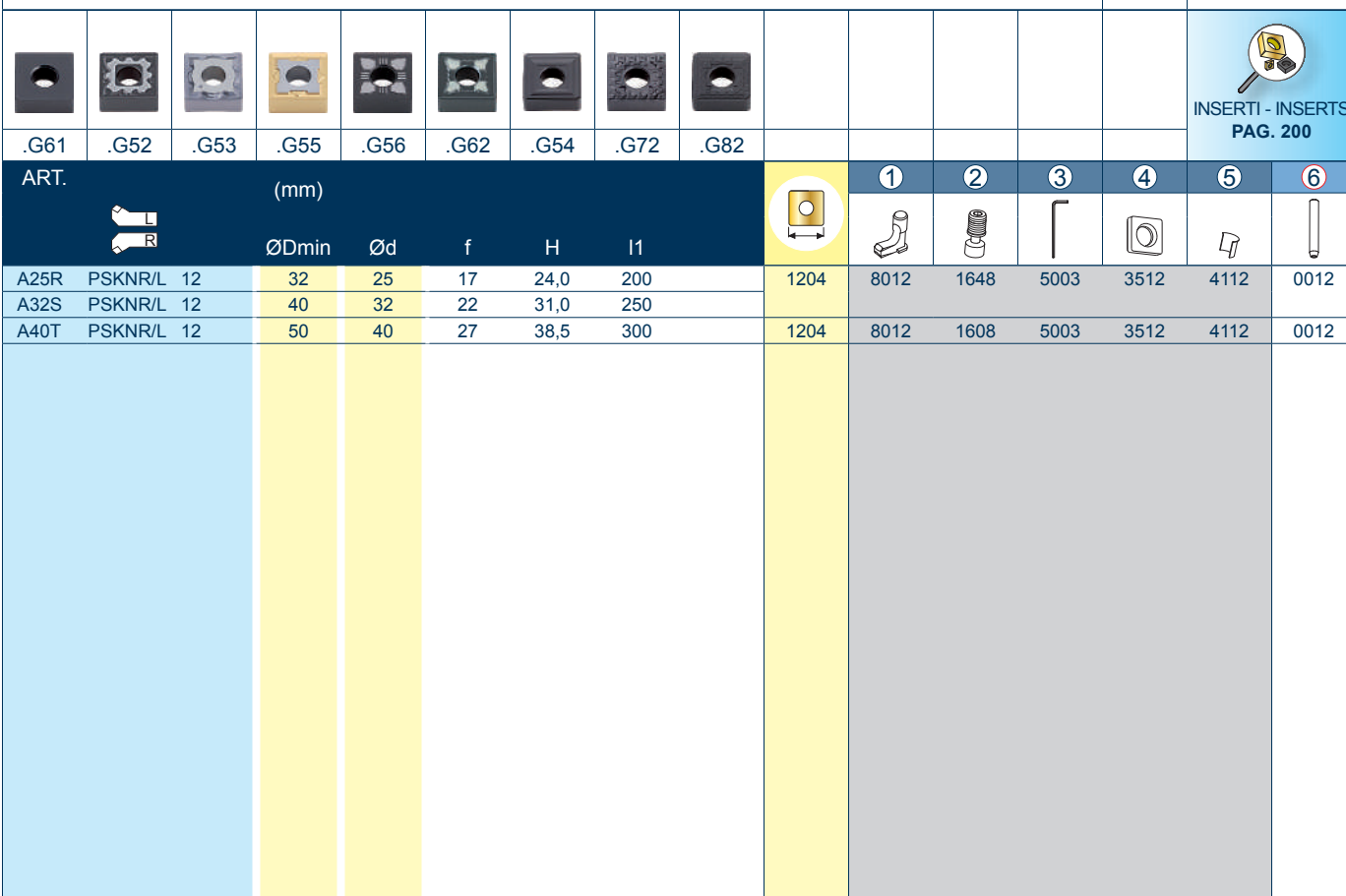
PAG. 1048

Ø25 - Ø40

75°



SNMA	
SNMG	
SNMM	
P	



PAG. 190

PAG. 186



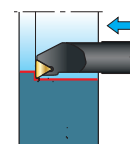
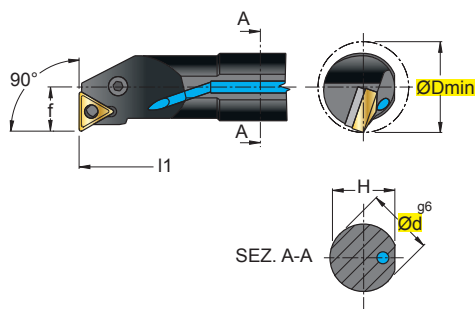
PAG. 1025

PAG. 1048

A..PTFNR/L

Ø16 - Ø40

90°



TNMA



TNMG



TNMM

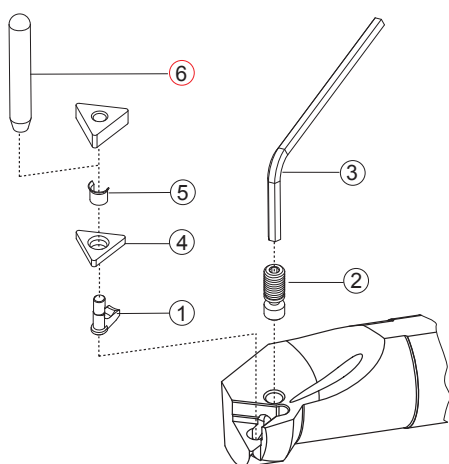


P



In figura utensile destro - Right-hand shown

																				
.G61	.G52	.G53	.G55	.G56	.G62	.G63									INSERTI - INSERTS PAG. 201					
ART.							(mm)													
A16M	PTFNR/L	11	21	16	11	15,25	150	1103	8008	1603	5002	—	—	—						
A20Q	PTFNR/L	11	25	20	13	19,0	180	1604	8009	1606	5025	3416	4109	0009						
A25R	PTFNR/L	16	32	25	17	24,0	200													
A32S	PTFNR/L	16	40	32	22	31,0	250													
A32S	PTFNR/L	22 New	40	32	22	31,0	250	2204	8012	1608	5003	3422	4112	0012						
A40T	PTFNR/L	22	50	40	27	38,5	300													



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



PAG. 190



PAG. 186



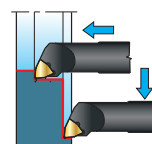
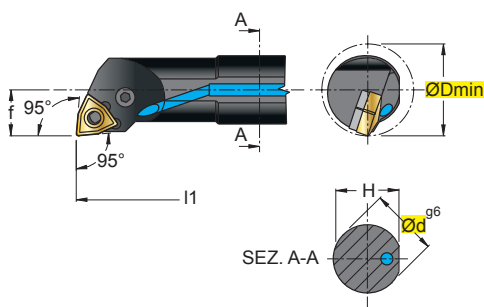
PAG. 1025



PAG. 1048

Ø16 - Ø40

95°



P

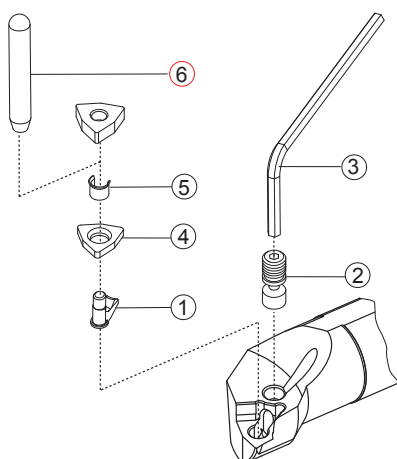


In figura utensile destro - Right-hand shown



INSERTI - INSERTS
PAG. 202

ART.		(mm)						①	②	③	④	⑤	⑥	
		ØDmin	Ød	f	H	l1								
A16M	PWLNR/L 06	21	16	11	15,25	150	0604	8216	1605	5002	—	—	—	
A20Q	PWLNR/L 06	25	20	13	19,0	180		0604	8009	1606	5025	3306	4109	0009
A25R	PWLNR/L 06	32	25	17	24,0	200			0804	8012	1648	5003	3308M	4112
A32S	PWLNR/L 06	40	32	22	31,0	250	0804			8012	1608	5003	3308M	4112
A25R	PWLNR/L 08	32	25	17	24,0	200		0804		8012	1608	5003	3308M	4112
A32S	PWLNR/L 08	40	32	22	31,0	250			0804	8012	1608	5003	3308M	4112
A40T	PWLNR/L 08	50	40	27	38,5	300	0804			8012	1608	5003	3308M	4112
								0804		8012	1608	5003	3308M	4112
									0804	8012	1608	5003	3308M	4112
							0804			8012	1608	5003	3308M	4112



PAG. 190

► **Vc**

PAG. 186



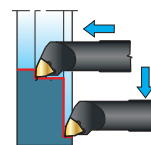
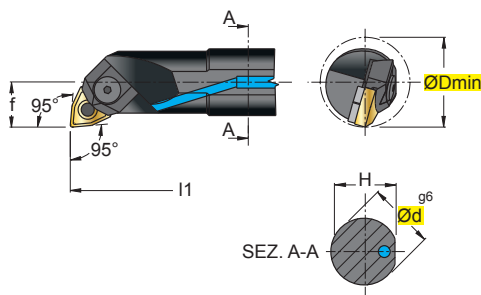
PAG. 1025



PAG. 1048

Ø20 - Ø50

95°



M

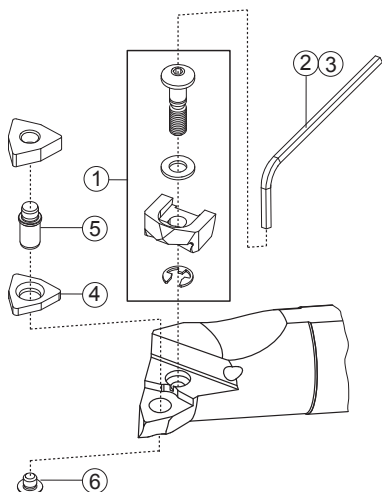


In figura utensile destro - Right-hand shown



INSERTI - INSERTS
PAG. 202

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



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

PAG. 190

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

PAG. 186

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

PAG. 1025

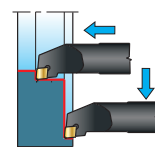
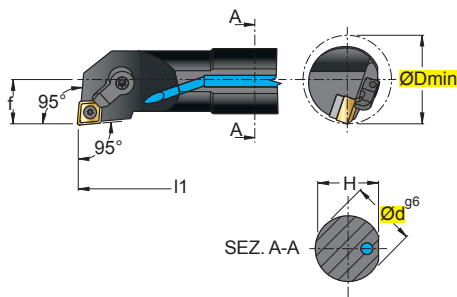
 DATI TECNICI E CONSIGLI
 TECHNICAL DATA AND SUGGESTIONS
 TECHNISCHE DATEN UND EMPFEHLUNGEN
 DONNÉES TECHNIQUES ET CONSEILS

PAG. 1048

A..MCLNR/L

Ø25 - Ø50

95°



CNMA



CNMG



CNMM



M



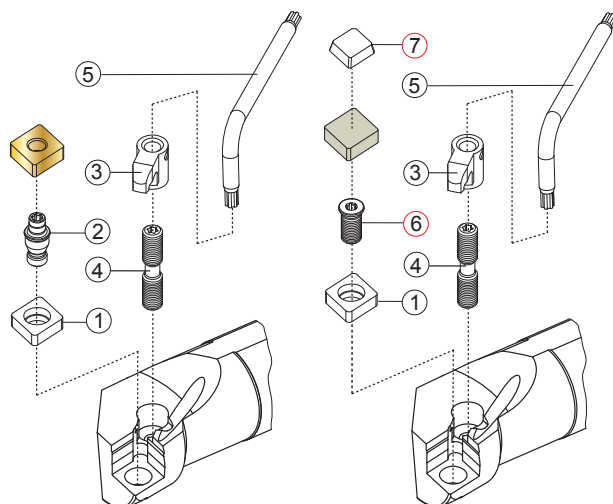
In figura utensile destro - Right-hand shown

																																	
.G23	.G61	.X47	.G39	.G42	.G52	.G53	.G55	.G56	.K57P	.G62	.G63	.G68	.G72	.G82	.G34W		INSERTI - INSERTS PAG. 197																
ART.									(mm)																								
					ØDmin	Ød	f	H	l1																								
A25R	MCLNR/L	12			32	25	17	24,0	200	1204	—							KLM 44	CKM 21	STCM 20	5415	—		—									
A32S	MCLNR/L	12			40	32	22	31,0	250	1204	KCN 433							KLM 46	CKM 21	STCM 20	5415	KMS 4		RCN1225									
A40T	MCLNR/L	12			50	40	27	38,5	300	1204																							
A50U	MCLNR/L	12			63	50	35	48,0	350																								
A40T	MCLNR/L	16			50	40	27	38,5	300																								
A50U	MCLNR/L	16			63	50	35	48,0	350																								
A50U	MCLNR/L	16			50	40	27	38,5	300	1606	KCN 533							KLM 58	CKM 21	STCM 20	5415	KMS 5		—									
A50U	MCLNR/L	16			63	50	35	48,0	350	1606																							
A50U	MCLNR/L	19			63	50	35	48,0	350		1906	KCN 633							KLM 68	CKM 12	STCM 4	5425	KMS 6		—								

ART.	DIMENSIONI MEASURES ABMESSUNGEN DIMENSIONES	INSERTO INSERT WENDEPLATTEN PLAQUETTES
RCN 1225		

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

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



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

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

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

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



PAG. 190



PAG. 186

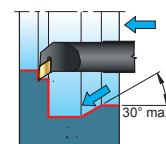


PAG. 1025



PAG. 1048

Ø25 - Ø40



M

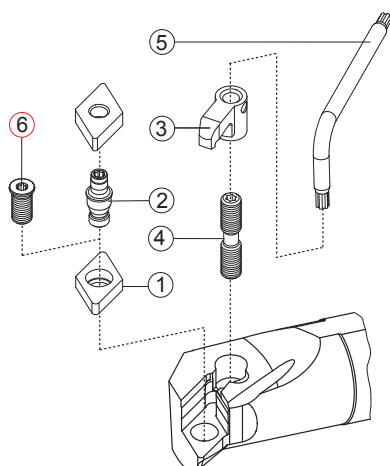


														 INSERTI - INSERTS PAG. 199							
.G23	.G39	.G42	.G52	.G53	.G55	.G56	.G62	.G63	.G68	.G72	.G34W										
ART.										(mm)											
 				ØDmin	Ød	f	H	l1	h												
A25R	MDUNR/L	15	32	25	17	24,0	200	1,5	1506	KDN433	KLM 46	CKM 22	STCM20	5415	KMS 4						
A32S	MDUNR/L	15	40	32	22	31,0	250	1,5	1506	KDN433	KLM 46L	CKM 22	STCM20	5415	KMS 4						
A40T	MDUNR/L	15	50	40	27	38,5	300	0													

INSERTI - INSERTS
PAG. 199

[illegible]

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



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

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



PAG. 190



PAG. 186



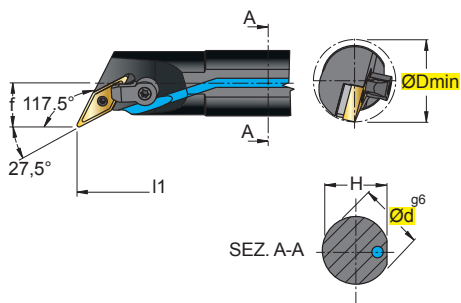
PAG. 1025



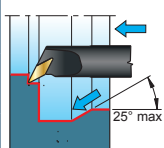
PAG. 1048

A..MVPNR/L

Ø25 - Ø40



In figura utensile destro - Right-hand shown



VNMG

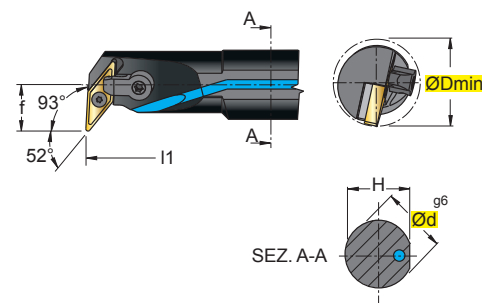


M

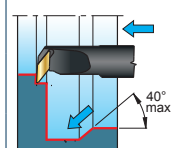
A..MVUNR/L

Ø25 - Ø40

93°



In figura utensile destro - Right-hand shown



VNMG



M



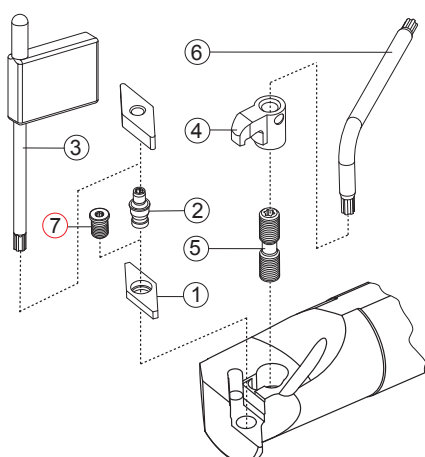
INSERTI - INSERTS
PAG. 201

ART.	(mm)	ØDmin	Ød	f	H	l1		1	2	3	4	5	6	7
A25R	MVPNR/L 16	32	25	17	24,0	200	1604	KVN323	KLM34L	5508	CKM21	STCM25	5415	KMS3
A32S	MVPNR/L 16	40	32	22	31,0	250	1604	KVN323	KLM34L	5508	CKM22	STCM25	5415	KMS3
A40T	MVPNR/L 16	50	40	27	38,5	300	1604	KVN323	KLM34L	5508	CKM22	STCM20	5415	KMS3

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

A25R	MVUNR/L 16	32	25	17	24,0	200	1604	KVN323	KLM34L	5508	CKM21	STCM25	5415	KMS3
A32S	MVUNR/L 16	40	32	22	31,0	250	1604	KVN323	KLM34L	5508	CKM21	STCM25	5415	KMS3
A40T	MVUNR/L 16	50	40	27	38,5	300	1604	KVN323	KLM34L	5508	CKM21	STCM20	5415	KMS3

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

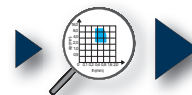


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

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

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

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



PAG. 190



PAG. 186

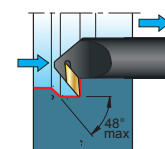
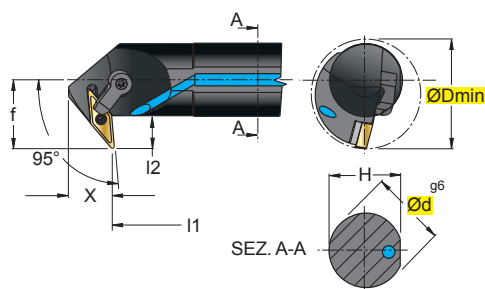


PAG. 1025



PAG. 1048

Ø32 - Ø40

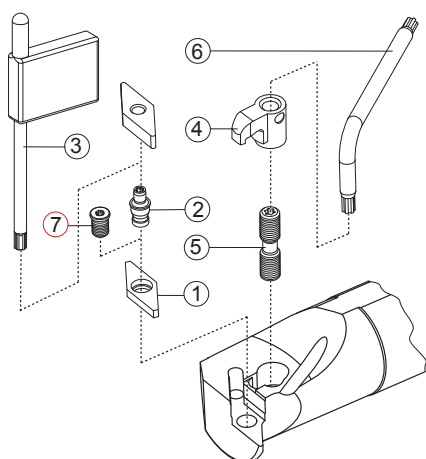
**VNMG**

M



INSERTI - INSERTS
PAG. 201

																	
.G23	.G42	.G52	.G53	.G55													INSERTI - INSERTS PAG. 201
ART. (mm)																	
		ØDmin	Ød	f	H	l1	l2	X									
A32S	MVZNR/L 16	48	32	30	31,0	250	14	18	1604	KVN323	KLM34L	5508	CKM22	STCM25	5415	KMS3	
A40T	MVZNR/L 16	57	40	35	38,5	300	15	20									



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

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

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

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



PAG. 190



PAG. 186

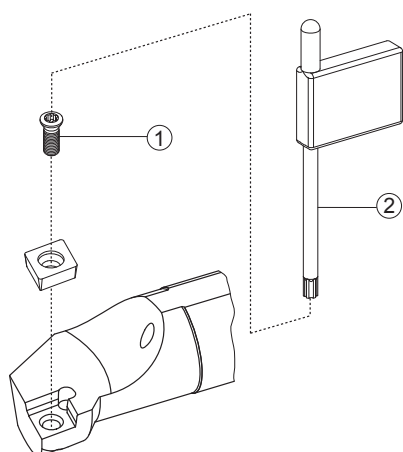


PAG. 1025



PAG. 1048

A..SCUPR/L				Ø8 - Ø16				E..SCUPR/L				Ø8 - Ø16			
93°								93°							
CP.T								CP.T							
CP.W								CP.W							
S								S							
In figura utensile destro - Right-hand shown								In figura utensile destro - Right-hand shown							
.D34															
.D42															
.E42															
ART.				(mm)											
				ØDmin				Ød				ØB			
				f				H				l1			
				l2				Nm							
A0608H				SCUPR/L 05				8,0				8			
A0810J				SCUPR/L 05				10,5				10			
A1012K				SCUPR/L 05				12,5				12			
A1216M				SCUPR/L 05				15,5				16			

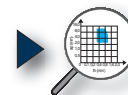


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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

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

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



PAG. 190



PAG. 186



PAG. 1025

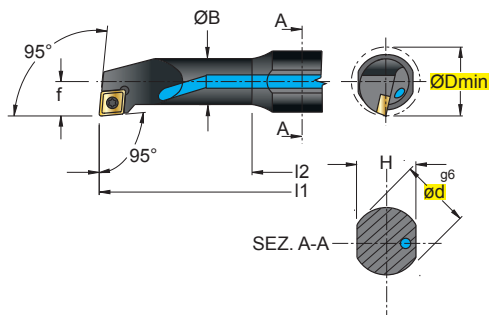


PAG. 1048

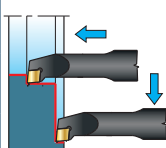
A..SCLCR/L

Ø8 - Ø16

95°



In figura utensile destro - Right-hand shown



CC.T

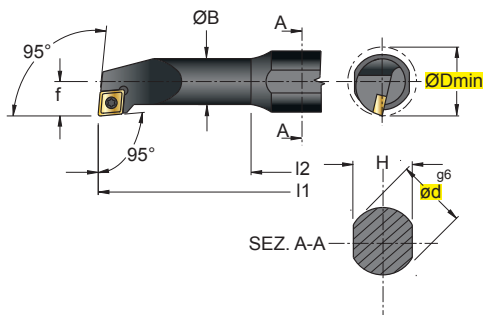
CC.W

S

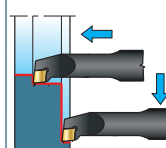
S..SCLCR/L

Ø8 - Ø16

95°



In figura utensile destro - Right-hand shown



CC.T

CC.W

S



INSERTI - INSERTS
PAG. 203

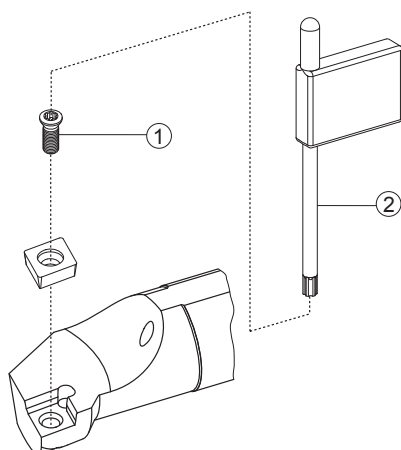
ART.	(mm)	ØDmin	Ød	ØB	f	H	l1	l2	Nm	1	2
A0608H SCLCR/L 06		8,5	8	6	4	7	100	20	1,0+1,2	0602	12254P 5507P
A0810J SCLCR/L 06		10,5	10	8	6	9	110	26	1,0+1,2		
A1012K SCLCR/L 06		12,5	12	10	7	11	125	32	1,0+1,2		
A1216M SCLCR/L 06		15,5	16	12	9	15	150	40	1,0+1,2		

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

S0608H SCLCR/L 06		8,5	8	6	4	7	100	20	1,0+1,2	0602	12254P 5507P
S0810J SCLCR/L 06		10,5	10	8	6	9	110	26	1,0+1,2		
S1012K SCLCR/L 06		12,5	12	10	7	11	125	32	1,0+1,2		
S1216M SCLCR/L 06		15,5	16	12	9	15	150	40	1,0+1,2		

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

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



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

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

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

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



PAG. 190



PAG. 186



PAG. 1025

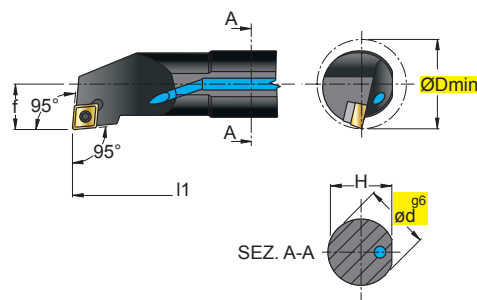


PAG. 1048

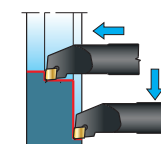
A..SCLCR/L

Ø8 - Ø40

95°



In figura utensile destro - Right-hand shown



CC.T



CC.W



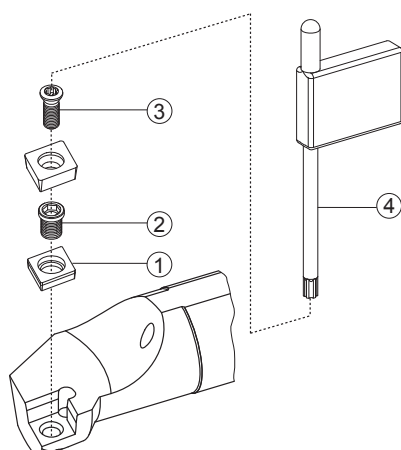
S



INSERTI - INSERTS
PAG. 203

																
.B22	.G13	.G57P	.X47	.G39	.G42	.G52	.G32W									INSERTI - INSERTS PAG. 203
ART.		(mm)														
		ØDmin	Ød	f	H	l1	Nm									
A08F	SCLCR/L 06	10	8	5	7,60	80	1,0÷1,2	0602	—	—	12254P	5507P				
A10H	SCLCR/L 06	12	10	7	9,50	100	1,1÷1,3	0602	—	—	12256P	5508P				
A12K	SCLCR/L 06	16	12	9	11,50	125	1,1÷1,3									
A16M	SCLCR/L 09	20	16	11	15,25	150	3,8÷5,0	09T3	—	—	12409P	5515P				
A20Q	SCLCR/L 09	25	20	13	19,00	180	3,8÷5,0									
A25R	SCLCR/L 09	32	25	17	24,00	200	3,8÷5,0	09T3	—	—	1240P	5515P				
A25R	SCLCR/L 12	32	25	17	24,00	200	4,0÷5,0	1204	—	—	124510P	5520P				
A32S	SCLCR/L 12	40	32	22	31,00	250	4,0÷5,0	1204	3611	BCL15	124513P	5520P				
A40T	SCLCR/L 12	50	40	27	38,50	300	4,0÷5,0									

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

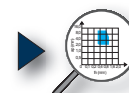


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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

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

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



PAG. 190



PAG. 186



PAG. 1025

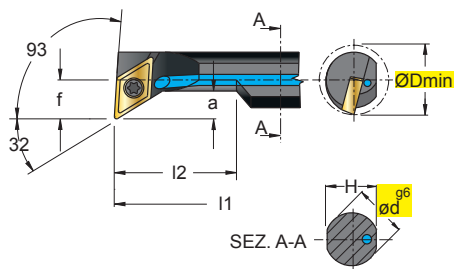


PAG. 1048

A..SDUCR/L

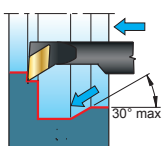
Ø10 - Ø16

93°



SEZ. A-A

in figura utensile destro - right-hand shown



DC.T



DC.W



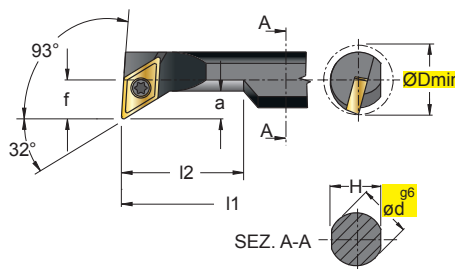
S



S..SDUCR/L

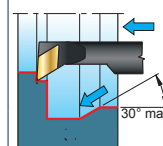
Ø10 - Ø16

93°



SEZ. A-A

In figura utensile destro - Right-hand shown



DC.T



DC.W



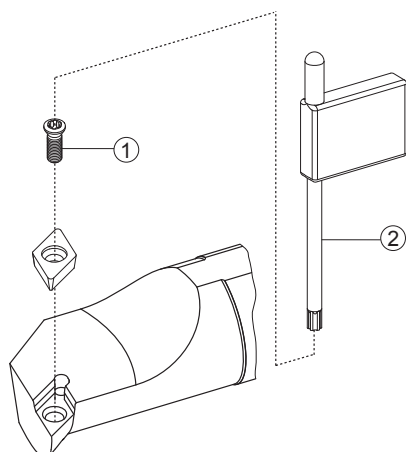
S



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

S0810H SDUCR/L 07		12,5	10	7	4	9	100	22	1,0+1,2	0702	12254P 5507P
S1012K SDUCR/L 07		15,5	12	9	5	11	125	28	1,0+1,2		
S1216M SDUCR/L 07		19,5	16	11	5	15	150	36	1,0+1,2		

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

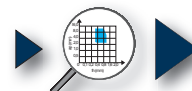


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
 CHAMPS D'USINAGE DES PLAQUETTES POUR TOURNAGE

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

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

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



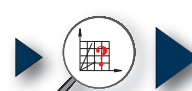
PAG. 190



PAG. 186



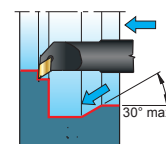
PAG. 1025



PAG. 1048

Ø10 - Ø40

Technical drawing of a tapered roller bearing. The main view shows the bearing with dimensions: 93° for the taper angle, 32° for the contact angle, f for the face width, A for the outer diameter, and l_1 for the length. A section view labeled **SEZ. A-A** shows the internal structure with dimensions H for the height, g_6 for the gap, and $\varnothing d$ for the inner diameter. A detail view shows the outer ring with a dimension $\varnothing D_{min}$.



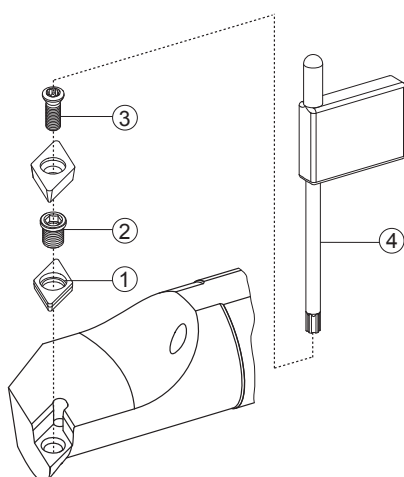
A cross-sectional diagram of a dovetail joint. It shows a yellow rectangular pin being inserted into a grey rectangular slot. The slot has a dovetail shape with a 7-degree angle, indicated by an arc and the text "7°".

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

S

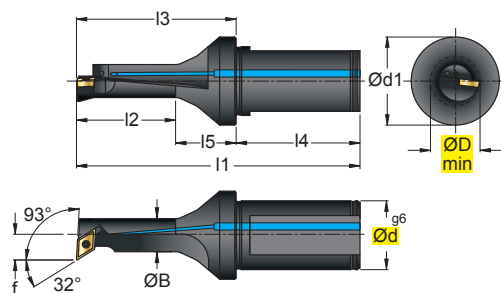


															 INSERTI - INSERTS PAG. 204
.G13	.B53	.G57P	.X47	.G39	.G42	.G52	.G32W								
ART.		(mm)									①	②	②	④	
			ØDmin	Ød	f	H	l1	Nm							
A10H	SDUCR/L 07	13	10	8	9,50	100	1,1÷1,3	0702	—	—	12256P	5508P			
A12K	SDUCR/L 07	16	12	9	11,50	125	1,1÷1,3								
A16M	SDUCR/L 07	20	16	11	15,25	150	1,1÷1,3								
A20Q	SDUCR/L 07	25	20	13	19,00	180	1,1÷1,3								
A20Q	SDUCR/L 11	25	20	13	19,00	180	3,8÷5,0	11T3	—	—	12409P	5515P			
A25R	SDUCR/L 11	32	25	17	24,00	200	3,8÷5,0	11T3	—	—	1240P	5515P			
A32S	SDUCR/L 11	40	32	22	31,00	250	3,0÷3,5	11T3	3711	BCL7	123511P	5515P			
A40T	SDUCR/L 11	49	40	27	38,50	300	3,0÷3,5								

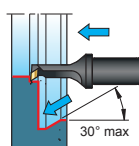


Ø20 - Ø32

93°



In figura utensile destro - Right-hand shown



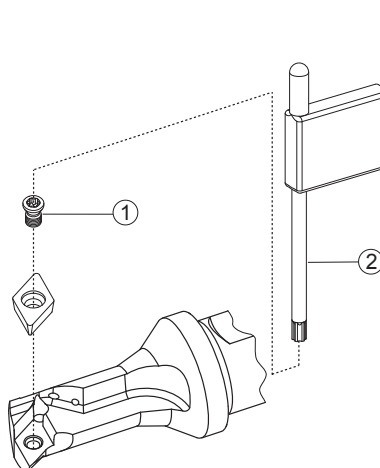
DC.T



DC.W



S



PAG. 190



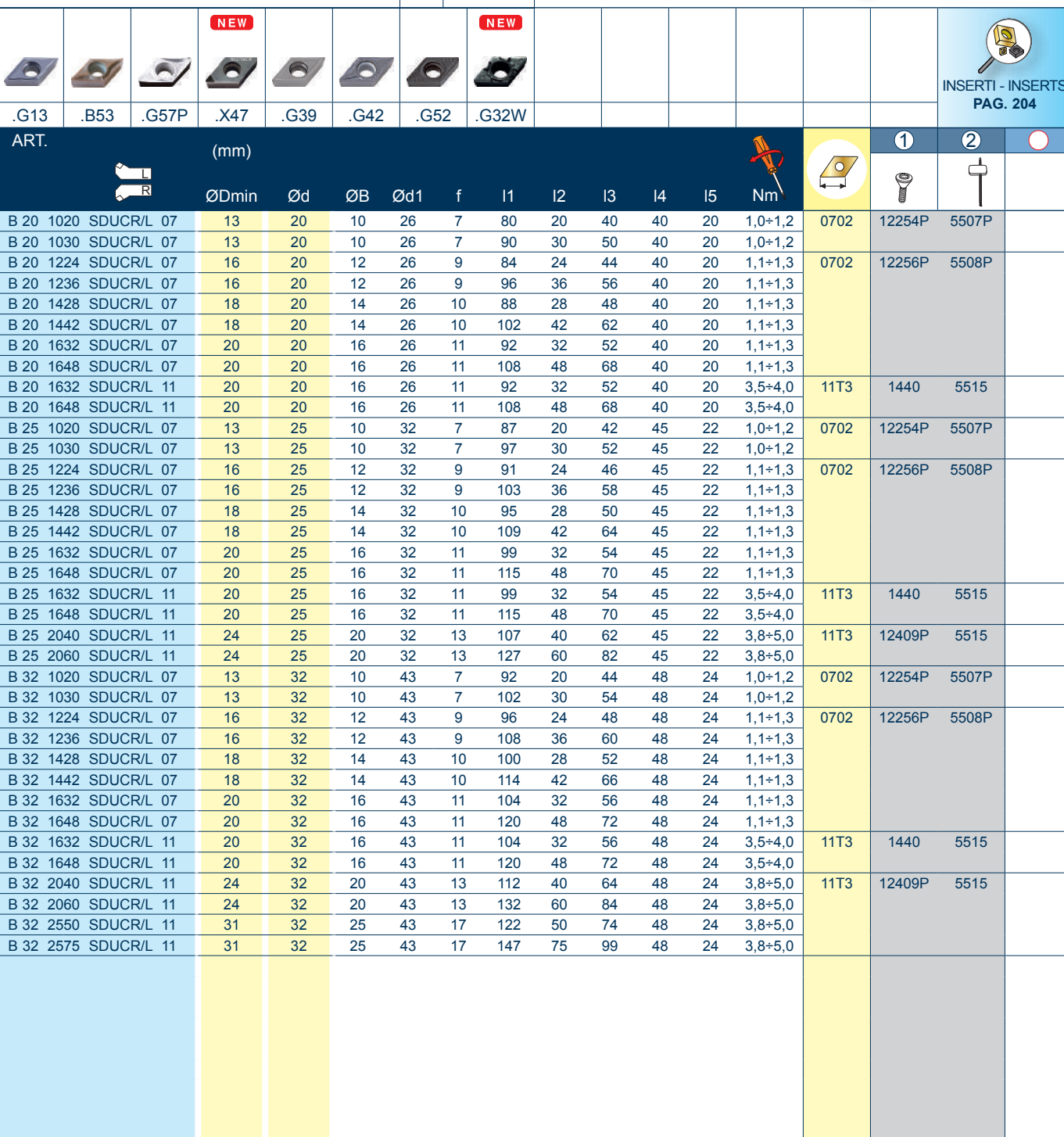
PAG. 186



PAG. 1025



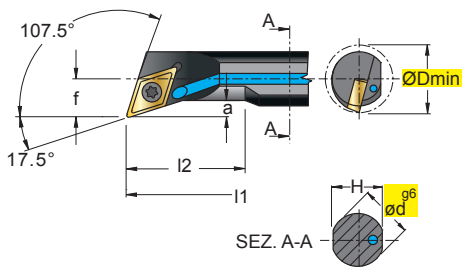
PAG. 1048



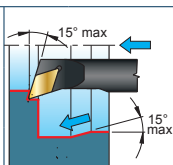
A..SDQCR/L

Ø10 - Ø16

107,5°



In figura utensile destro - Right-hand shown



DC.T

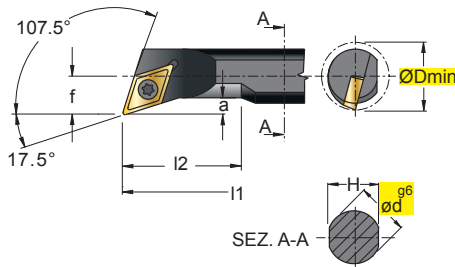
DC.W

S

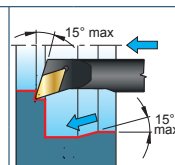
S..SDQCR/L

Ø10 - Ø16

107,5°



In figura utensile destro - Right-hand shown



DC.T

DC.W

S



ART.	(mm)	ØDmin	Ød	f	a	H	l1	l2	Nm	1	2
A0810H SDQCR/L 07		12,5	10	7	3	9	100	22	1,0+1,2	0702	12254P 5507P
A1012K SDQCR/L 07		15,5	12	9	4	11	125	28	1,0+1,2		
A1216M SDQCR/L 07		19,5	16	11	5	15	150	36	1,0+1,2		

S0810H SDQCR/L 07		12,5	10	7	3	9	100	22	1,0+1,2	0702	12254P 5507P
S1012K SDQCR/L 07		15,5	12	9	4	11	125	28	1,0+1,2		
S1216M SDQCR/L 07		19,5	16	11	5	15	150	36	1,0+1,2		

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



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

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

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

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



PAG. 190



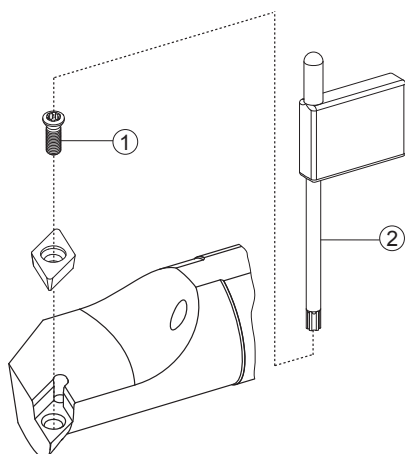
PAG. 186



PAG. 1025

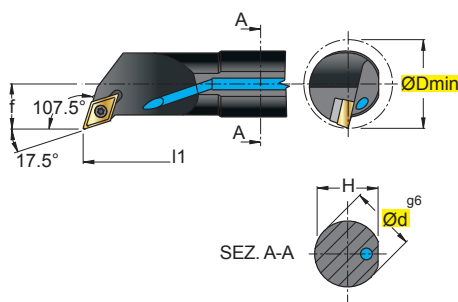


PAG. 1048



Ø12 - Ø32

107,5°



DC.T



DC.W

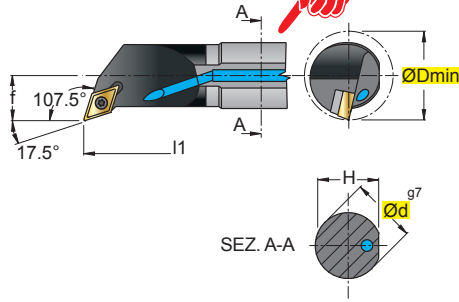


S

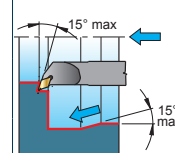


Ø10 - Ø20

107,5°



In figura utensile destro - Right-hand shown



DC.T



DC.W



S



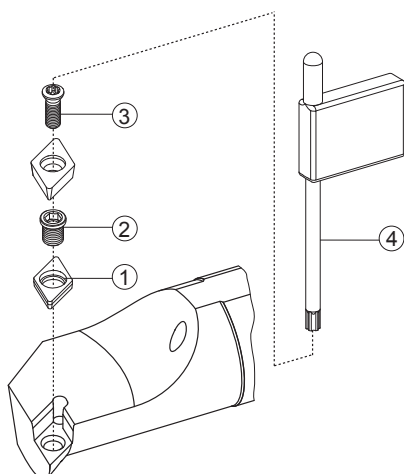
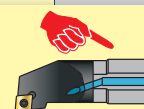
INSERTI - INSERTS
PAG. 204

[illegible]

E10K	SDQCR/L	07	12	10	7	9,50	125	1,1+1,3	0702	-	-	12256P	5508P	
E12M	SDQCR/L	07	15	12	9	11,50	150	1,1+1,3						
E16R	SDQCR/L	07	19	16	11	15,00	200	1,1+1,3						
E20S	SDQCR/L	11	23	20	13	19,00	250	3,8+5,0	11T3	-	-	12409P	5515P	



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



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

PAG. 190

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

PAG. 186

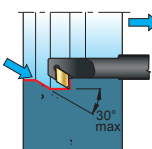
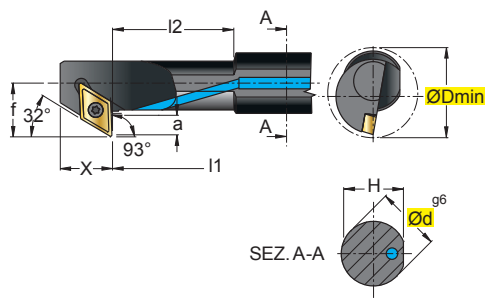
 DETTAGLIO RICAMBI
 SPARE PARTS DETAILS
 DETAILS ZU DEN ERSATZTEILEN
 DÉTAIL DE PIÈCES DE RECHANGE

PAG. 1025

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

PAG. 1048

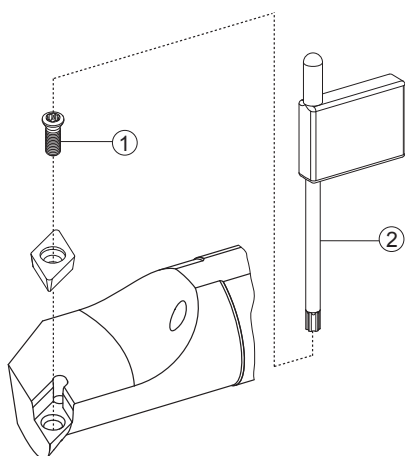
Ø12 - Ø25



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

A cross-sectional diagram of a tapered hole in a grey block. The hole is yellow and has a central cylindrical section and two tapered sections. The taper angle is indicated as 7° with arrows pointing to the sloped surfaces.

S

[illegible]

PAG. 190

► **Vc**

PAG. 186



PAG. 1025

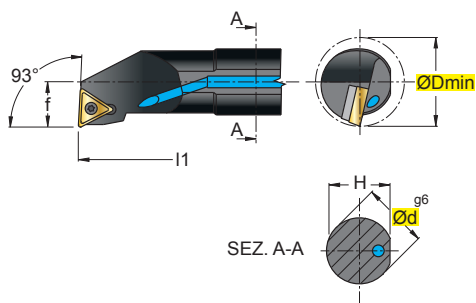


PAG. 1048

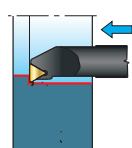
A..STUCR/L

Ø12 - Ø32

93°



In figura utensile destro - Right-hand shown



TC.T

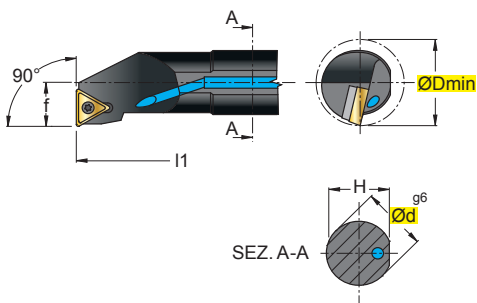
TC.W

S

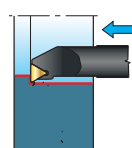
A..STFCR/L

Ø10 - Ø40

90°



In figura utensile destro - Right-hand shown



TC.T

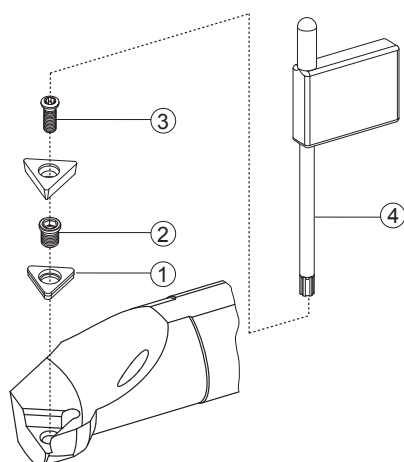
TC.W

S



INSERTI - INSERTS
PAG. 206

ART.		(mm)						Nm	1102	1	2	3	4	
		ØDmin	Ød	f	H	I1								
A12K	STUCR/L 11	16	12	9	11,50	125	1,1+1,3			—	—	12256P	5508P	
A16M	STUCR/L 16	20	16	11	15,25	150	3,8+5,0			—	—	12409P	5515P	
A20Q	STUCR/L 16	25	20	13	19,00	180	3,8+5,0			—	—	1240P	5515P	
A25R	STUCR/L 16	32	25	17	24,00	200	3,8+5,0							
A32S	STUCR/L 16	40	32	22	31,00	250	3,0+3,5			3415	BCL7	123511P	5515P	
A10H	STFCR/L 09	12	10	7	9,50	100	0,9+1,0		0902	—	—	12225P	5507P	
A10H	STFCR/L 11	12	10	7	9,50	100	1,1+1,3		1102	—	—	12256P	5508P	
A12K	STFCR/L 11	16	12	9	11,50	125	1,1+1,3							
A16M	STFCR/L 11	20	16	11	15,25	150	1,1+1,3							
A16M	STFCR/L 16	20	16	11	15,25	150	3,8+5,0		16T3	—	—	12409P	5515P	
A20Q	STFCR/L 16	25	20	13	19,00	180	3,8+5,0		16T3	—	—	1240P	5515P	
A25R	STFCR/L 16	32	25	17	24,00	200	3,8+5,0							
A32S	STFCR/L 16	40	32	22	31,00	250	3,0+3,5		16T3	3415	BCL7	123511P	5515P	
A40T	STFCR/L 16	50	40	27	38,50	300	3,0+3,5							

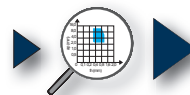


CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
FIELDS OF APPLICATION FOR TURNING INSERTS
EINSATZGEBIETE FÜR DREHPLATTEN
CHAMPS D'USINAGE DES PLAQUETTES POUR Tournage

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

DETTAGLIO RICAMBI
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DETAILS ZU DEN ERSATZTEILEN
DÉTAIL DE PIÈCES DE RECHANGE

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PAG. 190



PAG. 186



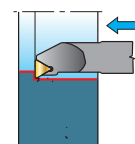
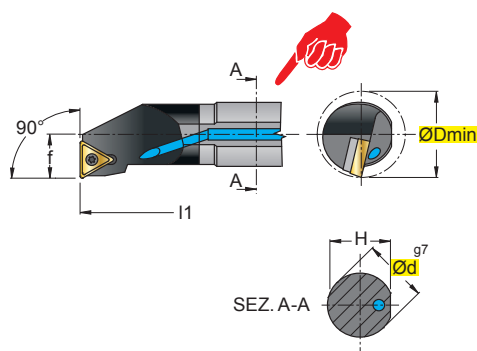
PAG. 1025



PAG. 1048

Ø10 - Ø20

90°



TC.T



TC.W



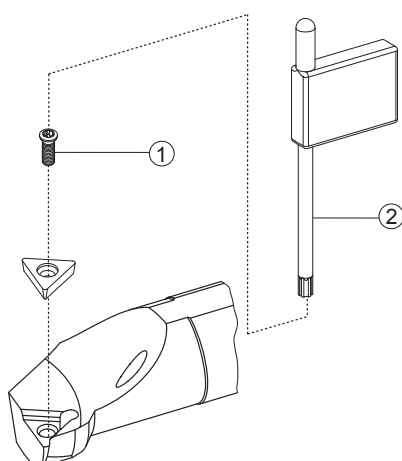
S



														 INSERTI - INSERTS PAG. 206
.G39	.G57P	.X47	.G39	.S42	.G52									
ART.		(mm)							 Nm		①	②		
		ØDmin	Ød	f	H	l1								
E10M	STFCR/L 09	13	10	7	9,50	150	0,9+1,0	0902	12225P	5507P				
E12Q	STFCR/L 11	16	12	9	11,50	180	1,1+1,3	1102	12256P	5508P				
E16R	STFCR/L 11	20	16	11	15,00	200	1,1+1,3							
E20S	STFCR/L 16	25	20	13	19,00	250	3,8+5,0	16T3	1240P	5515P				

INSERTI - INSERTS
PAG. 206

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



 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
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PAG. 190

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

PAG. 186

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

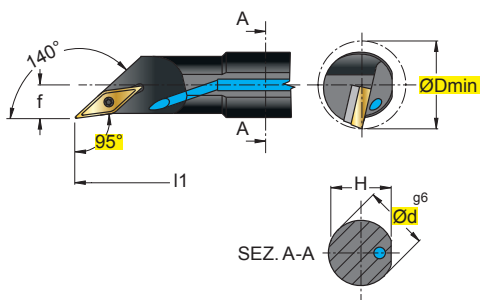
PAG. 1025

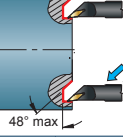
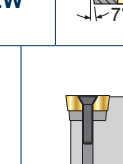
 DATI TECNICI E CONSIGLI
 **TECHNICAL DATA AND SUGGESTIONS**
 **TECHNISCHE DATEN UND EMPFEHLUNGEN**
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PAG. 1048

Ø12 - Ø25

140°



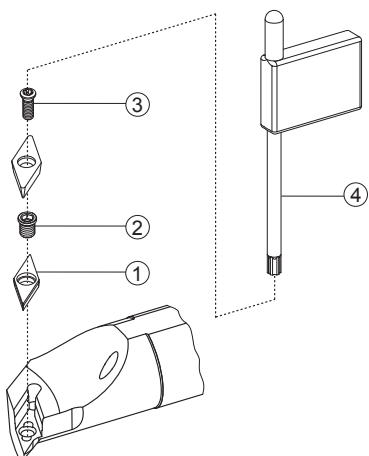
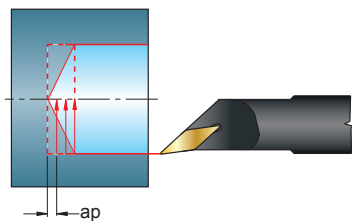
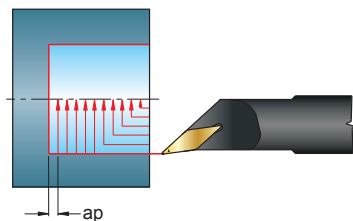
VC.T 	1 
VC.W 	2 
S 	1 



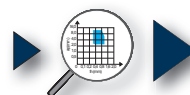
INSERTI - INSERTS
PAG. 207

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

A diagram illustrating the formation of a semi-circular stroke. A fountain pen nib is shown on the right, with red lines indicating the path of the pen tip as it moves from the center to the left, creating a semi-circular shape. The diagram includes a horizontal dashed line and a vertical dashed line. A dimension line at the bottom indicates the radius of the semi-circle, labeled as ap .



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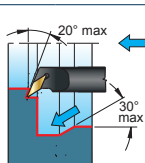


PAG. 1025



PAG. 1048

Ø16 - Ø25



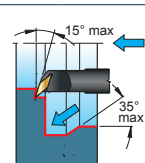
VC.T

VC.W

S

Ø16 - Ø40

107.5°



VC.T 

VC.W

S

In figura utensile destro - Right-hand shown



INSERTI - INSERTS
PAG. 207

(mm)



ØDmin

f

15

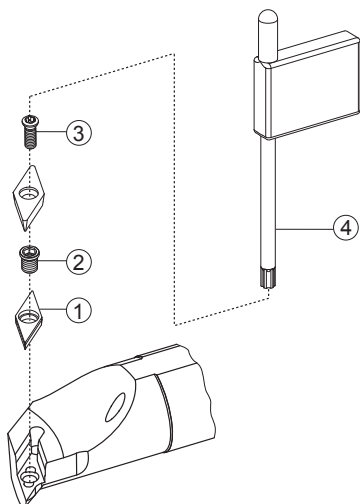


4



A16M	SVXCR/L	11	20	16	11	15,25	150	1,1+1,3	1103	–	–	12256P	5508P
A20Q	SVXCR/L	11	25	20	13	19,00	180	1,1+1,3					
A25R	SVXCR/L	16	32	25	17	24,00	200	3,0+3,5	1604	–	–	123509P	5515P

A16M	SVQCR/L	11	20	16	11	15,25	150	1,1+1,3	1103	—	—	12256P	5508P
A20Q	SVQCR/L	11	25	20	13	19,00	180	1,1+1,3					
A25R	SVQCR/L	16	32	25	17	24,00	200	3,0+3,5	1604	—	—	123509P	5515P
A32S	SVQCR/L	16	40	32	22	31,00	250	3,0+3,5	1604				
A40T	SVQCR/L	16	50	40	27	38.50	300	3,0+3,5		3716	BCL7	123511P	5515P

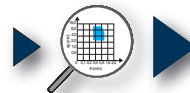


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
 FIELDS OF APPLICATION FOR TURNING INSERTS
 EINSATZGEBIETE FÜR DREHPLATTEN
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PAG. 186



PAG. 1025

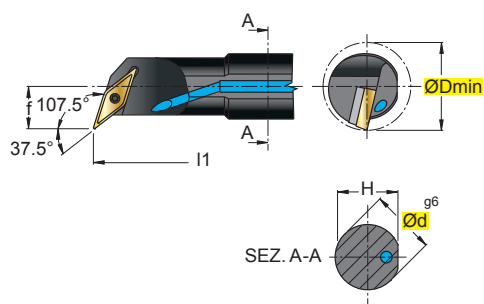


PAG. 1048

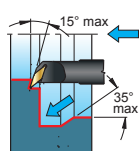
A..SVQBR/L

Ø25 - Ø40

107,5°



In figura utensile destro - Right-hand shown



VB.T



VB.W



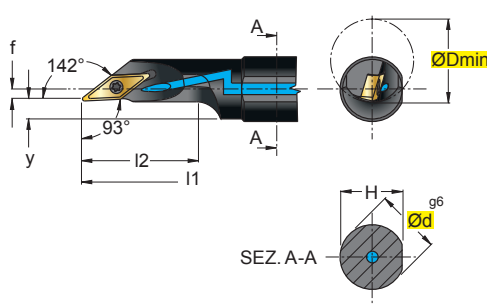
S



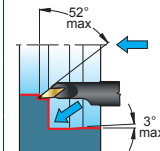
A..SVJBR/L

Ø25

142°



In figura utensile destro - Right-hand shown



VB.T



VB.W



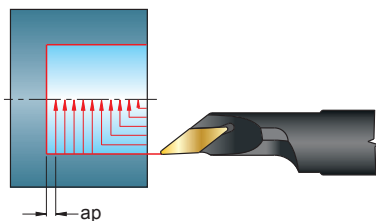
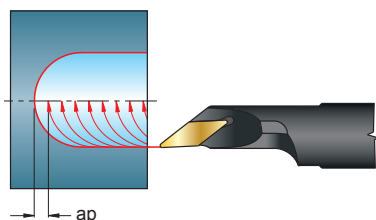
S



NEW																	
.X47	.G42	.G52	.G58											INSERTI - INSERTS PAG. 207			
ART.				(mm)										1	2	3	4
																	
A25R	SVQBR/L	16		ØDmin	Ød	f	H	L1	L2	Y	Nm	1604	—	—	123509P	5515P	
A32S	SVQBR/L	16		40	32	22	31,0	250	—	—	3,0+3,5	1604	3716	BCL7	123511P	5515P	
A40T	SVQBR/L	16		50	40	27	38,5	300	—	—	3,0+3,5						
A25R	SVJBR/L	16		32	25	4,6	24	200	44	7	1,1+1,3	1604	—	—	123509P	5515P	

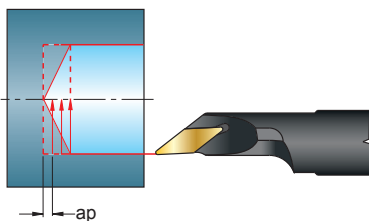
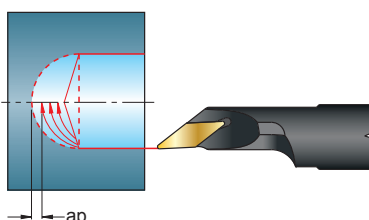
Lavorazione senza preforo

Machining a workpiece without prepared hole.



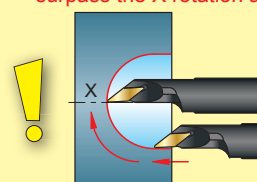
Lavorazione con preforo

Machining a workpiece with prepared hole.



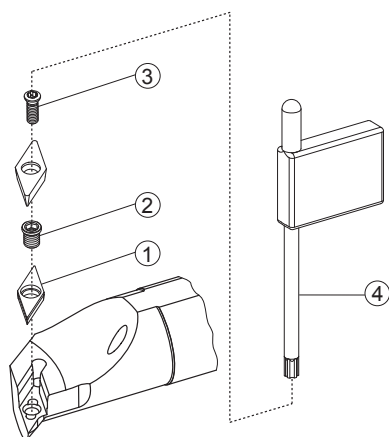
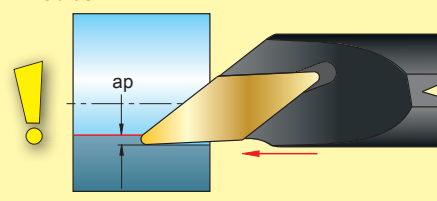
Fate attenzione che il tagliente non superi l'asse di rotazione X

Make sure the cutting edge does not surpass the X rotation axis



La profondità di passata ap deve essere inferiore al raggio inserto

Cutting depth ap must be lower than insert radius

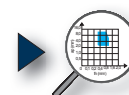


 CAMPI D'IMPIEGO DEGLI INSERTI PER TORNITURA
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PAG. 190



PAG. 186



PAG. 1025

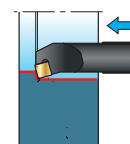
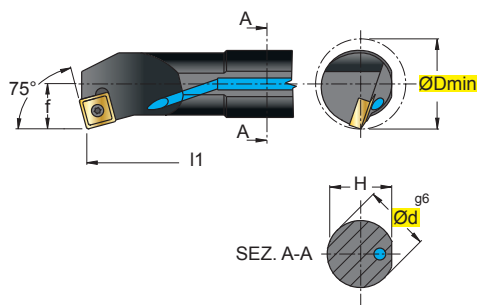


PAG. 1048

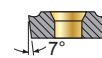
A..SSKCR/L

Ø16 - Ø25

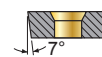
75°



SC.T



SC.W



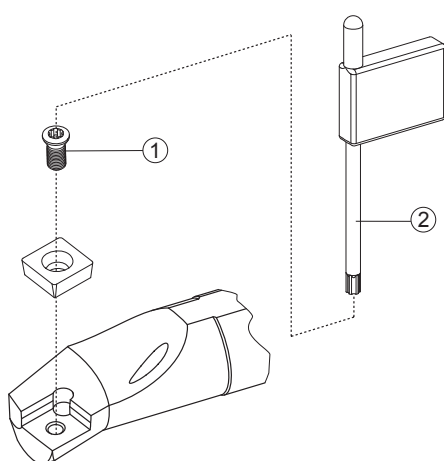
S



In figura utensile destro - Right-hand shown

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

INSERTI - INSERTS
PAG. 205



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

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

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

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



PAG. 190



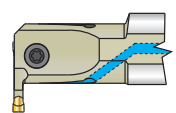
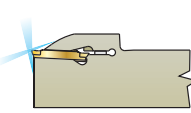
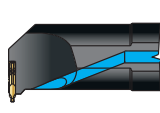
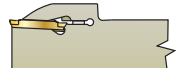
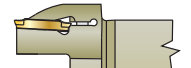
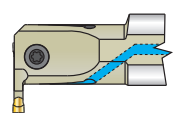
PAG. 186



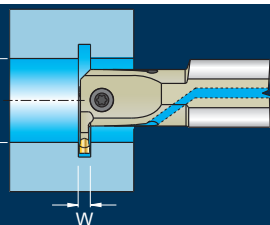
PAG. 1025



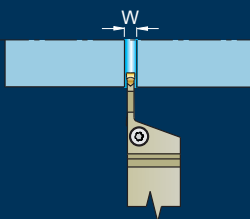
PAG. 1048

TRL Pag.128		TRCR/L Pag.130		TRWR/L Pag.134		STGR/L Pag.144			
									
ØDmax = 70 - 100		□ 16x16 - 25x25		□ 20x20 - 25x25		□ 20x20 - 25x25			
	TRL..N W=3,0-4,0		G..N14,5 W=2-4		G..N14,5 W=2-4		154.. W=1,1-4,15		
		TRIR/L Pag.130		TRWR/L Pag.136		A..STIR/L Pag.144			
									
		ØDmin = 20 - 25		□ 20x20 - 25x25		ØDmin = 20 - 40			
			G..N14,5 W=2-4		GM25 W=3		154.. W=1,1-4,15		
			G..N25 W=3-6		G..N25 W=3-6				
		TRCR/L Pag.132		TRFR/L Pag.138					
									
		□ 20x20 - 32x32		□ 25x25					
			GM25 W=3		GM25 W=3				
			G..N25 W=3-6		G..N25 W=3-6				
		TRIR/L Pag.132		TRCXR/L Pag.140					
									
		ØDmin = 32 - 57		□ 20x20 - 25x25					
			GM25 W=3						
			G..N25 W=3-6		GM25 W=3				
				TRWXR/L Pag.142					
									
				□ 20x20 - 25x25					
					GM25 W=3				

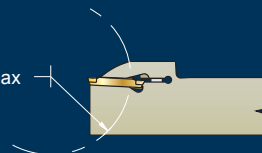
ØDmin



W



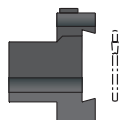
ØDmax



THE...-THS.. Pag.146

SCTFPR/L Pag.150

SGTBU Pag.152



□ 8x8 - 25x25

□ 25x25



GIE../GP
SG/GR/GW
W=0,5-3,0



TPMR 1103
TPMR 1603
W=11
W=16,5



TRL

THI.. Pag.148

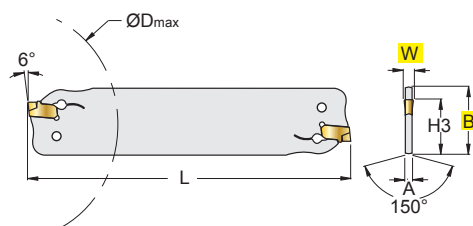
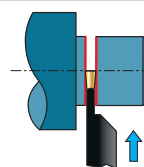


ØDmin = 38,10



GIE../GP
SG/GR/GW
W=0,5-3,0

26 - 32



TRLN..



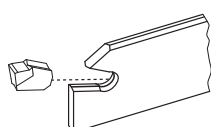
INSERTI - INSERTS
PAG. 227

[illegible]

PAG. 220



PAG. 218



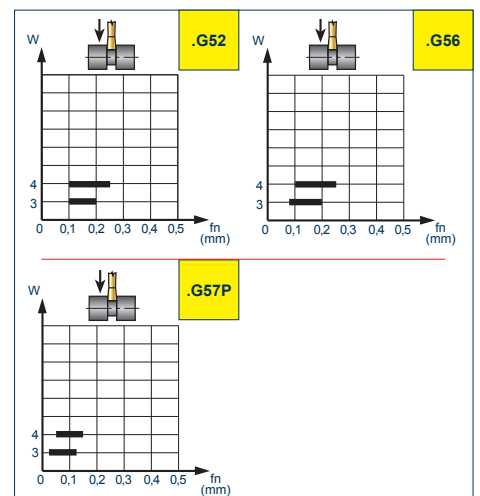
PAG. 1025



PAG. 1051

SCELTA VELOCE - QUICK PICK																		HT		HW	HC					 TRL...N							
																		CERMET	NON RIV. CEMENTED CARBIDE GRADES	RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS					W	r	a°						
																		WM2															
																		T116		F4645					T5235								

MATERIALI - MATERIALS Pag. 1119		VDI 3323 GR.	HB Rm ⁽¹⁾ HRC ⁽²⁾	Vc m/min Pag. 218			
				T116	F4645	T5235	
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300		130	150	
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350		120	140	
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325		90	130	
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240		90	115	
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230				
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260			130	
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250			120	
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230			130	
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130	600			
	RAME E SUE LEGHE - COPPER	26-28	90-110	400			
	NON METALLICI - PLASTICS	29-30	/	450			
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320				
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ⁽¹⁾				
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ⁽²⁾				



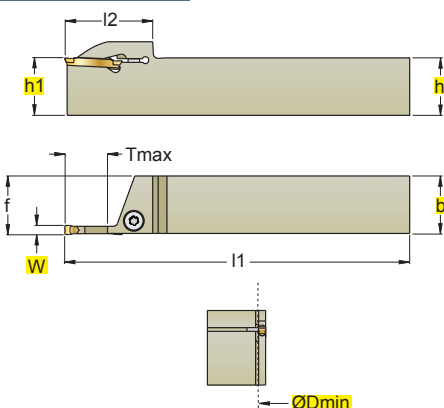
= SCANALATURA - GROOVING

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

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

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

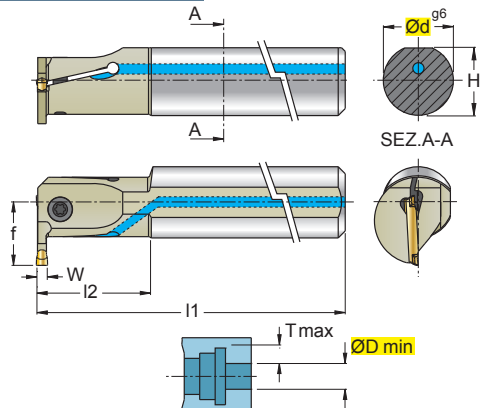
□ 16x16 - 25x25



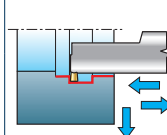
GS.N
14,5..



Ø16 - Ø20



In figura utensile destro - Right-hand shown



GS.N
14,5..



INSERTI - INSERTS
PAG. 225

PAG. 220



PAG. 218

PAG. 1025

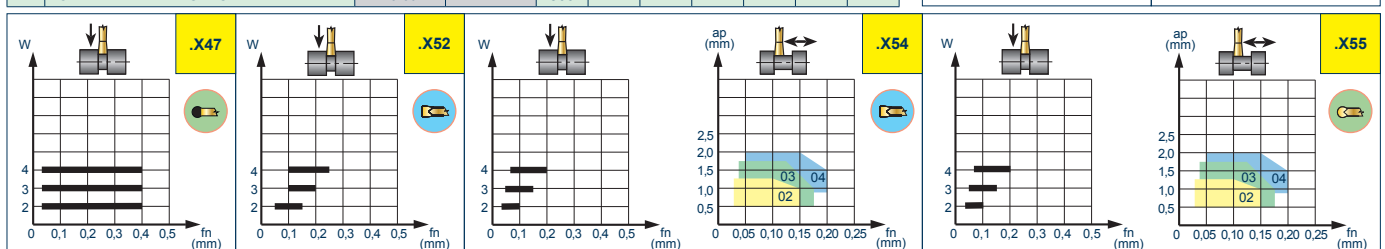
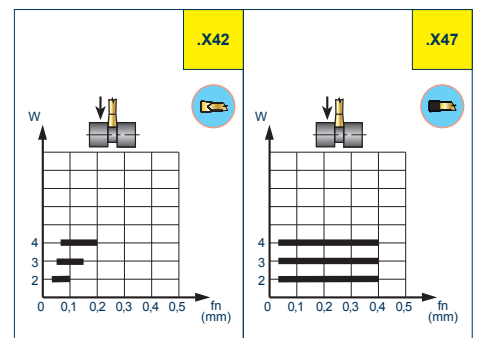
PAG. 1051

SCELTA VELOCE - QUICK PICK

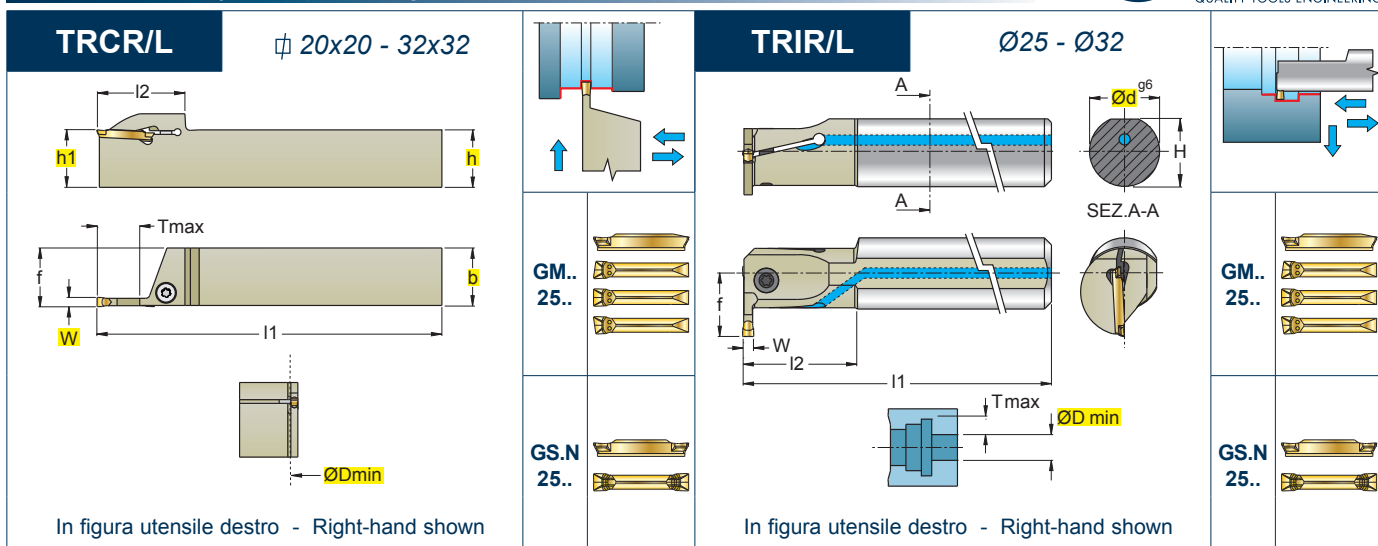


COD.	P				M				K				N				S				H				HT	HW	HC	DP					
	F	M	R		F	M	R		F	M	R		F	M	R		F	M	R		F	M	R						W	r	l	T	a°
GMGN 14.5-0.2-2 .X47																													2,0	0,2	14,5	1,5	8°
GMGN 14.5-0.2-3 .X47																													3,0	0,2	14,5	2,2	8°
GMGN 14.5-0.4-4 .X47																													4,0	0,4	14,5	3,2	8°
GMGN 14.5R1.0-2 .X47																													2,0	1,0	14,5	1,5	8°
GMGN 14.5R1.5-3 .X47																													3,0	1,5	14,5	2,2	8°
GMGN 14.5R2.0-4 .X47																													4,0	2,0	14,5	3,2	8°
GSGN 14.5-0.2-2 .X42																													2,0	0,2	14,5	1,5	10°
GSGN 14.5-0.2-3 .X42																													3,0	0,2	14,5	2,2	10°
GSGN 14.5-0.4-4 .X42																													4,0	0,4	14,5	3,2	10°
GSGN 14.5-0.2-2 .X52																													2,0	0,2	14,5	1,5	10°
GSGN 14.5-0.2-3 .X52																													3,0	0,2	14,5	2,2	10°
GSGN 14.5-0.4-4 .X52																													4,0	0,4	14,5	3,2	10°
GSTN 14.5-0.2-2 .X54																													2,0	0,2	14,5	1,5	10°
GSTN 14.5-0.2-3 .X54																													3,0	0,2	14,5	2,2	11°
GSTN 14.5-0.3-4 .X54																													4,0	0,3	14,5	3,2	11°
GSTN 14.5R1.0-2 .X55																													2,0	1,0	14,5	1,5	8°
GSTN 14.5R1.5-3 .X55																													3,0	1,5	14,5	2,2	8°
GSTN 14.5R2.0-4 .X55																													4,0	2,0	14,5	3,2	8°
CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY																																	
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY																																	

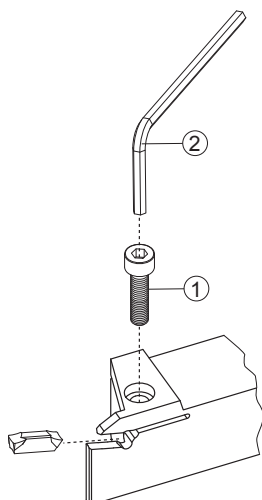
MATERIALI - MATERIALS Pag. 1119		VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	Vc m/min Pag. 218				
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	D3007	F4530	T5735	F4645	
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350		140	150	130	
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325		130	140	120	
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240		100	115	90	
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230		150	160	90	
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260		100	120	100	
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250		160	140		
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230		140	115		
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130	700				
	RAME E SUE LEGHE - COPPER	26-28	90-110	600				
	NON METALLICI - PLASTICS	29-30	/	800				



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



NEW		NEW		NEW		NEW		NEW		NEW												 INSERTI - INSERTS PAG. 226		
..L..	.X52	..N..	.X52	..R..	.X52	.X42	.X47	.X47	.X52	.X54	.X55													
ART. (mm)																								
		W	h=h1	b	ØDmin	f	Tmax	l1	l2	Nm														
TRCR/L	2020 25-3	3	20	20	1100	20,0	22	125	38,5	5,0+6,0	GS..25..-3	VTZ 0516	5425											
TRCR/L	2020 25-4	4	20	20	1100	20,0	22	125	40,5	5,0+6,0	GS..25..-4	VTZ 0516	5425											
TRCR/L	2525 25-3	3	25	25	1600	25,3	22	150	38,5	5,0+6,0	GS..25..-3	VTZ 0516	5425											
TRCR/L	2525 25-4	4	25	25	1600	25,5	22	150	38,5	5,0+6,0	GS..25..-4	VTZ 0516	5425											
TRCR/L	2525 25-5	5	25	25	1600	25,5	22	150	38,5	5,0+6,0	GS..25..-5	VTZ 0516	5425											
TRCR/L	2525 25-6	6	25	25	1600	25,6	22	150	38,5	5,0+6,0	GS..25..-6	VTZ 0516	5425											
TRCR/L	3232 25-4	4	32	32	3000	32,0	22	170	40,5	5,0+6,0	GS..25..-4	VTZ 0516	5425											
TRCR/L	3232 25-5	5	32	32	3000	32,0	22	170	40,5	5,0+6,0	GS..25..-5	VTZ 0516	5425											
TRCR/L	3232 25-6	6	32	32	3000	32,0	22	170	40,5	5,0+6,0	GS..25..-6	VTZ 0516	5425											
ART. (mm)																								
		W	Ød	ØDmin	f	H	Tmax	l1	l2	Nm														
TRIR/L	25 25-3	3	25	32	22,5	24,0	10,0	200,5	39,0	5,0+6,0	GS..25..-3	SM 522	5420											
TRIR/L	25 25-4	4	25	32	22,5	24,0	10,0	200,5	39,0	5,0+6,0	GS..25..-4	SM 522	5420											
TRIR/L	25 25-5	5	25	32	22,5	24,0	10,0	200,5	39,0	5,0+6,0	GS..25..-5	SM 522	5420											
TRIR/L	25 25-6	6	25	32	22,5	24,0	10,0	200,5	39,0	5,0+6,0	GS..25..-6	SM 522	5420											
TRIR/L	32 25-3	3	32	42	27,5	31,0	11,0	250,0	51,5	5,0+6,0	GS..25..-3	SM 522	5420											
TRIR/L	32 25-4	4	32	42	27,5	31,0	11,0	250,0	51,5	5,0+6,0	GS..25..-4	SM 522	5420											
TRIR/L	32 25-5	5	32	42	27,5	31,0	11,0	250,0	51,5	5,0+6,0	GS..25..-5	SM 522	5420											
TRIR/L	32 25-6	6	32	47	34,4	31,0	17,5	250,0	52,0	5,0+6,0	GS..25..-6	SM 522	5420											
TRIR/L	40 25-4	New	4	40	53	32,5	38,5	12,0	300,0	63,0	5,0+6,0	GS..25..-4	SM 522	5420										
TRIR/L	40 25-5	New	5	40	53	32,5	38,5	12,0	300,0	64,0	5,0+6,0	GS..25..-5	SM 522	5420										
TRIR/L	40 25-6	New	6	40	57	34,4	38,5	17,5	300,0	65,0	5,0+6,0	GS..25..-6	SM 522	5420										



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

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

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

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



PAG. 220



PAG. 218



PAG. 1025



PAG. 1051

Tenacità +
Toughness -

Pag. 210

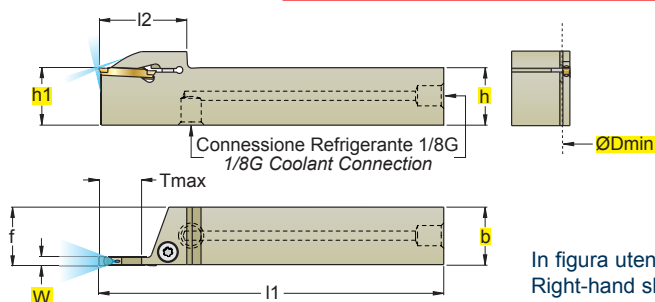
MATERIALI - MATERIALS Pag. 1119		VDI 3323 GR.	HB Rm ⁽¹⁾ HRC ⁽²⁾	Vc m/min Pag. 218				
				D3007	F4530	T5735	F4645	
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300		140	150	130	
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350		130	140	120	
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325		100	115	90	
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240		150	160	90	
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230		100	120	100	
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260		160	140		
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250		140	130		
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230		140	115		
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130	700				
	RAME E SUE LEGHE - COPPER	26-28	90-110	600				
	NON METALLICI - PLASTICS	29-30	/	800				

.X42

.X47

⌀ 20x20 - 25x25

**RANGE DI
UTILIZZO**
20÷80 bar
**APPLICATION
RANGE**
20÷80 bar



In figura utensile destro
Right-hand shown

GS.N
14,5..



 IL VANTAGGIO DI PERFORMANCE S'OTTIENE SOLO CON L'ALTA PRESSIONE DEL REFRIGERANTE 20+80 bar, LE POMPE UTILIZZATE DEVONO AVERE UN FILTRAGGIO DEL LIQUIDO DI RITORNO.

 THE PERFORMANCE ADVANTAGE CAN BE ACHIEVED ONLY WITH HIGH COOLANT PRESSURE (20+80 BAR). THE PUMPS USED MUST BE EQUIPPED WITH RETURN-FLOW FILTRATION

 DER LEISTUNGSVORTEIL IST NUR BE HOHEM KÜHLMITTELDRUCK (20+80 BAR) ERZIELBAR. DIE EINGESETZTEN PUMPEN MÜSSEN MIT EINER RÜCKLAUFFILTERUNG AUSGESTATTET SEIN

 L'AVANTAGE DE PERFORMANCE NE S'OBTIENT QUE PAR LA HAUTE PRESSION DU REFRIGERANT 20+80 bars, LES POMPES UTILISEES DOIVENT ETRE DOTEES D'UN FILTRE DU LIQUIDE DE RETOUR



INSERTI - INSERTS
PAG. 225

ART.		(mm)												①	②	③	
		W	h=h1	b	ØDmin	f	Tmax	I1	I2	Nm							
TRWR/L	2020 14-2	2	20	20	1100	20	12,5	125	35,5	5,0+6,0	GS..14.5.-2	VTZ 0516	5425	218-1814			
TRWR/L	2020 14-3	3	20	20	1100	20	12,5	125	35,5	5,0+6,0	GS..14.5.-3	VTZ 0516	5425	218-1814			
TRWR/L	2020 14-4	4	20	20	1100	20	12,5	125	35,5	5,0+6,0	GS..14.5.-4	VTZ 0516	5425	218-1814			
TRWR/L	2525 14-2	2	25	25	1600	25,3	12,5	150	36,0	5,0+6,0	GS..14.5.-2	VTZ 0516	5425	218-1814			
TRWR/L	2525 14-3	3	25	25	1600	25,5	12,5	150	36,0	5,0+6,0	GS..14.5.-3	VTZ 0516	5425	218-1814			
TRWR/L	2525 14-4	4	25	25	1600	25,5	12,5	150	36,0	5,0+6,0	GS..14.5.-4	VTZ 0516	5425	218-1814			

• Tubo dritto raccordato
Fitted hose, straight
150mm
PAG. 1022

• Tubo dritto raccordato
Fitted hose, straight
225mm
PAG. 1022

• Tubo dritto raccordato
Fitted hose, straight
300mm
PAG. 1022

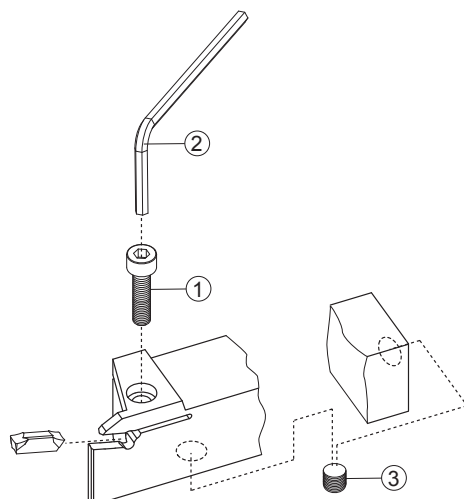
• Ogiva lubrorefrigerante
Cooling lubricant nose cone
PAG. 1023

• Raccordo dritto
Straight fitting
PAG. 1022

• Riduzione
Adapter
PAG. 1022

• Raccordo 90°
90° Fitting
PAG. 1023

• B-SEAL M10
PAG. 1023



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

PAG. 220

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

PAG. 218

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

PAG. 1025

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

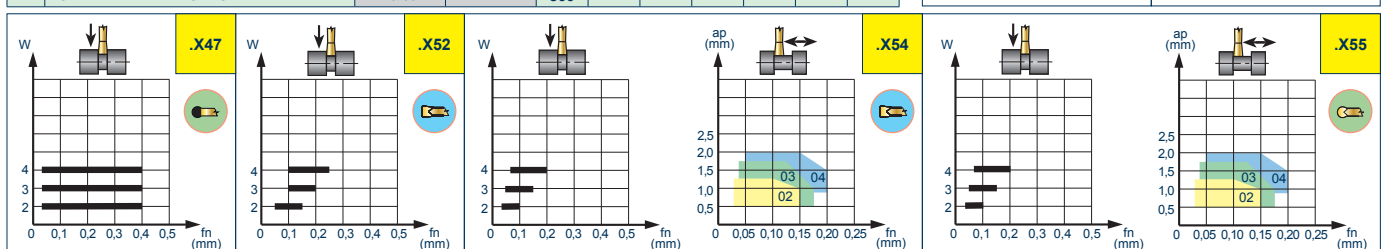
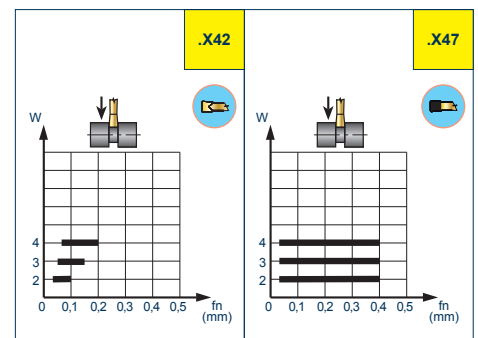
PAG. 1051

SCELTA VELOCE - QUICK PICK



HT	HW	HC	DP					
CERMET	NON RIV. CEMENTED CARBIDE GRADES	RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS	PCD					
			DP3007 ≤ m/z	W	r	l	T	a°
		F4530	■	2,0	0,2	14,5	1,5	8°
		T5735	■	3,0	0,2	14,5	2,2	8°
		F4645	■	4,0	0,4	14,5	3,2	8°
			■	2,0	1,0	14,5	1,5	8°
			■	3,0	1,5	14,5	2,2	8°
			■	4,0	2,0	14,5	3,2	8°
				2,0	0,2	14,5	1,5	10°
		■						
		■		3,0	0,2	14,5	2,2	10°
		■						
		■		4,0	0,4	14,5	3,2	10°
		■						
		■		2,0	0,2	14,5	1,5	10°
		■						
		■		3,0	0,2	14,5	2,2	11°
		■						
		■		4,0	0,3	14,5	3,2	11°
		■						
		■		2,0	1,0	14,5	1,5	8°
		■						
		■		3,0	1,5	14,5	2,2	8°
		■						
		■		4,0	2,0	14,5	3,2	8°
		■						
	●	●						
			●					

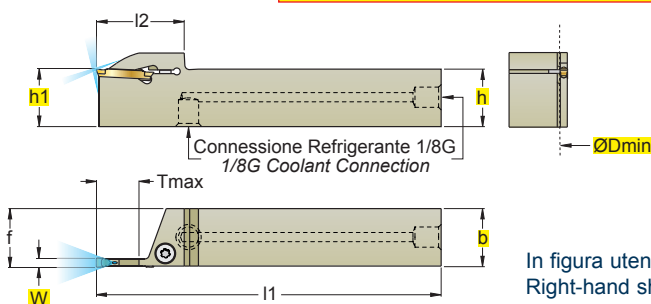
MATERIALI - MATERIALS Pag. 1119		VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	Vc m/min Pag. 218				
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	D3007	F4530	T5735	F4645	
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350		140	150	130	
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325		130	140	120	
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240		100	115	90	
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230		150	160	90	
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260		100	120	100	
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250		160	140		
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230		140	115		
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130		700			
	RAME E SUE LEGHE - COPPER	26-28	90-110		600			
	NON METALLICI - PLASTICS	29-30	/		800			



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

20x20 - 25x25

	ADDUZIONE REFRIGERANTE DIRETTA SULL'INSERTO
	DIRECT COOLANT SUPPLY TO THE INSERT
	DIREKTE ZUFÜHRUNG DES SCHMIERSTOFFS AN DIE PLATTE
	ADDUCTION REFRIGERANT DIRECTE SUR LA PLAQUETTE



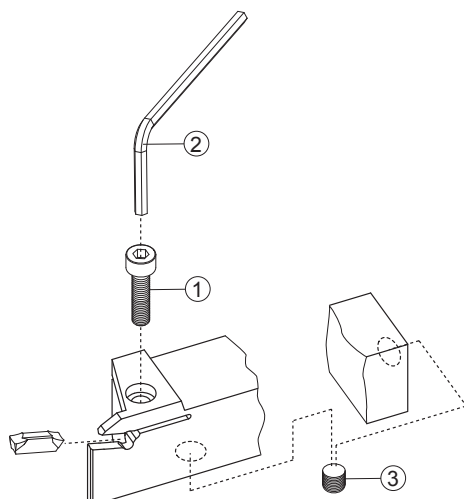
In figura utensile destro
Right-hand shown

	IL VANTAGGIO DI PERFORMANCE SI OTTIENE SOLO CON L'ALTA PRESSIONE DEL REFRIGERANTE 20+80 bar, LE POMPE UTILIZZATE DEVONO AVERE UN FILTRAGGIO DEL LIQUIDO DI RITORNO.
	THE PERFORMANCE ADVANTAGE CAN BE ACHIEVED ONLY WITH HIGH COOLANT PRESSURE (20+80 BAR). THE PUMPS USED MUST BE EQUIPPED WITH RETURN-FLOW FILTRATION
	DER LEISTUNGSVORTEIL IST NUR BEI HOHEM KÜHLMITTELDRUCK (20+80 BAR) ERZIELBAR. DIE EINGESETZTEN PUMPEN MÜSSEN MIT EINER RÜCKLAUFLITERUNG AUSGESTATTET SEIN
	L'AVANTAGE DE PERFORMANCES NE S'OBTIENT QUE PAR LA HAUTE PRESSION DU REFRIGÉRANT 20+80 bars. LES POMPES UTILISÉES DOIVENT ÊTRE DOTÉES D'UN FILTRE DU LIQUIDE DE RETOUR.



INSERTI - INSERTS
PAG. 226

ART.		(mm)												①	②	③	
		W	h=h1	b	ØDmin	f	Tmax	l1	l2	Nm							
TRWR/L	2020 25-3	3	20	20	1100	20,0	22	125	38,5	5,0+6,0	GS..25..3	VTZ 0516	5425	218-1814			
TRWR/L	2020 25-4	4	20	20	1100	20,0	22	125	40,5	5,0+6,0	GS..25..4	VTZ 0516	5425	218-1814			
TRWR/L	2525 25-3	3	25	25	1600	25,3	22	150	41,0	5,0+6,0	GS..25..3	VTZ 0516	5425	218-1814			
TRWR/L	2525 25-4	4	25	25	1600	25,5	22	150	41,0	5,0+6,0	GS..25..4	VTZ 0516	5425	218-1814			
TRWR/L	2525 25-5	5	25	25	1600	25,5	22	150	41,0	5,0+6,0	GS..25..5	VTZ 0516	5425	218-1814			
TRWR/L	2525 25-6	6	25	25	1600	25,6	22	150	41,0	5,0+6,0	GS..25..6	VTZ 0516	5425	218-1814			



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

 VELOCITÀ DI TAGLIO Vc
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PAG. 220

PAG. 218

PAG. 1025

PAG. 1051

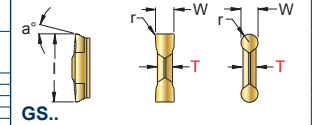
SCELTA VELOCE - QUICK PICK

Tenacità +
Toughness -



Pag. 210

HT		HW		HC		DP																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																									
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