MPT

Modular Precision Tooling

Modular **P**recision **T**ooling (MPT) di TaeguTec è un sistema completo per barenatura, fresatura, foratura e filettatura. Il sistema è stato sviluppato per garantire eccellenti risultati nei centri di tornitura, centri di lavoro e nei sistemi di produzione.

Il sistema è flessibile e di semplice utilizzo. E' rinomato per la sua rigidità e la capacità di serraggio di alta precisione. In particolare, il sistema **MPT** offre il massimo in rigidità e concentricità, grazie all'innesto conico e al bullone ad espansione radiale, che genera un forte bloccaggio. Tutto il sistema MPT incorpora l'adduzione del refrigerante all'interno.

TaeguTec
Member IMC Group

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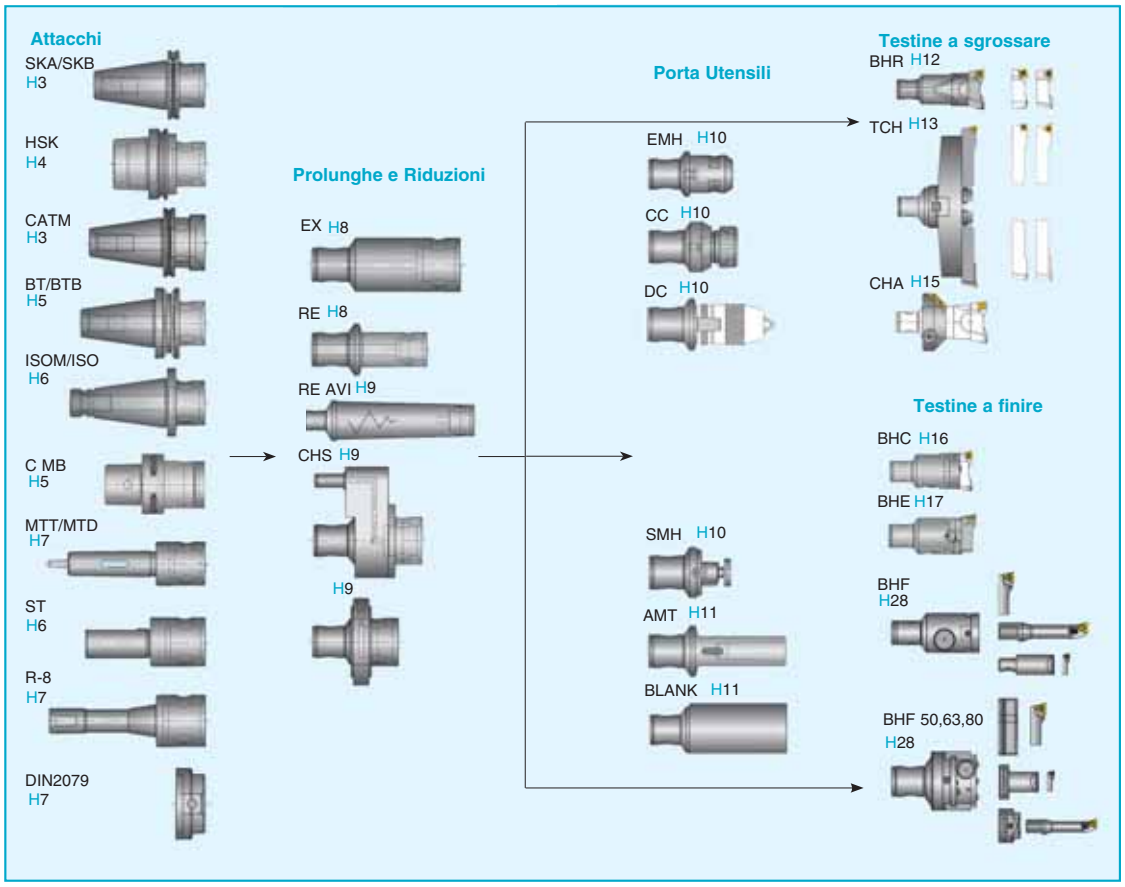
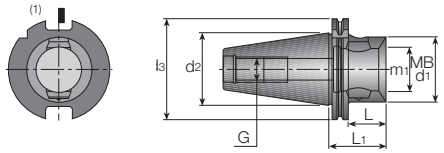
Sistema MPT



SKA-MB: SKA Attacco DIN 69871/A con innesto MB

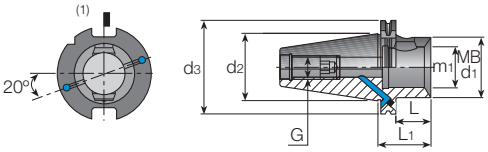


DIN 69871- A / ISO 7388/1 MB

Descrizione	Dimensioni (mm)							
	MB d_1	m_1	L	L_1	d_2	d_3	G	Kg
SKA 30-MB32	32	20	10.5	30	31.75	50.00	M12	0.4
SKA 30-MB50	50	32	41	60	31.75	50.00	M12	0.8
SKA 40-MB40	40	25	26	45	44.45	63.55	M16	0.5
SKA 40-MB50	50	32	29	48	44.45	63.55	M16	0.9
SKA 40-MB63	63	42	61	80	44.45	63.55	M16	1.5
SKA 45-MB50	50	32	29	48	57.15	82.55	M20	1.7
SKA 45-MB63	63	42	41	60	57.15	82.55	M20	1.9
SKA 45-MB80	80	42	47	66	57.15	82.55	M20	2.2
SKA 50-MB50	50	32	29	48	69.85	97.50	M24	2.7
SKA 50-MB63	63	42	37	56	69.85	97.50	M24	2.8
SKA 50-MB80	80	42	43	62	69.85	97.50	M24	3.4

• (1)Posizione tagliente

SKB-MB: SKB Attacco DIN 69871/B con innesto MB

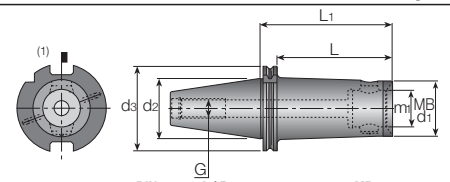


DIN 69871-FORM B MB

Descrizione	Dimensioni (mm)							
	MB d_1	m_1	L	L_1	d_2	d_3	G	Kg
SKB 40-MB50	50	32	29	48	44.45	63.55	M16	0.9
SKB 40-MB63	63	42	-	80	44.45	63.55	M16	1.5
SKB 45-MB50	50	32	29	48	57.15	82.55	M20	1.7
SKB 45-MB63	63	42	41	60	57.15	82.55	M20	1.9
SKB 50-MB50	50	32	29	48	69.85	97.50	M24	2.7
SKB 50-MB63	63	42	37	56	69.85	97.50	M24	2.8
SKB 50-MB80	80	42	43	62	69.85	97.50	M24	3.4

• (1)Posizione tagliente

SKA MB: SKA Attacco DIN 69871 A/B prolungato con innesto MB

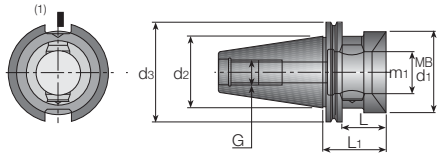


DIN 69871 A / B MB

Descrizione	Dimensioni (mm)							
	MB d_1	m_1	L_1	L	d_2	d_3	G	Kg
SKA 40 MB40X120 A/B	40	25	120	101	44.45	63.55	M16	1.7
SKA 40 MB50X120 A/B	50	32	120	101	44.45	63.55	M16	1.7
SKA 50 MB50X120 A/B	50	32	120	101	69.85	97.50	M24	3.5
SKA 50 MB63X150 A/B	63	42	150	131	69.85	97.50	M24	5
SKA 50 MB80X180 A/B	80	42	180	161	69.85	97.50	M24	6.9

• (1)Posizione tagliente

CATM-MB Attacco CAT con innesto MB

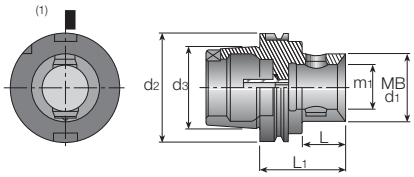


CATM MB

Descrizione	Dimensioni (mm)							
	MB d_1	m_1	L	L_1	d_2	d_3	G	Kg
CATM 40-MB50	50	32	47	66	44.45	63.55	M16	1.1
CATM 40-MB63	63	42	-	100	44.45	63.55	M16	1.9
CATM 45-MB50	50	32	29	48	57.15	82.55	M20	1.7
CATM 45-MB63	63	42	56	75	57.15	82.55	M20	2.1
CATM 45-MB80	80	42	-	80	57.15	82.55	M20	2.7
CATM 50-MB50	50	32	29	48	69.85	98.40	M24	2.9
CATM 50-MB63	63	42	37	56	69.85	98.40	M24	2.9
CATM 50-MB80	80	42	43	62	69.85	98.40	M24	3.2

• (1)Posizione tagliente

HSK A-MB: Attacco HSK "A" con innesto MB

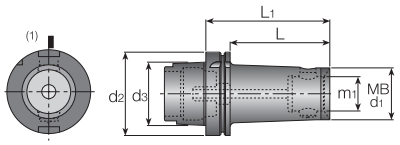


HSK DIN 69893 MB

Descrizione	Dimensioni (mm)						
	MB d_1	m_1	L	L_1	d_2	d_3	Kg
HSK A 50-MB50	50	32	-	66	50	38	0.6
HSK A 63-MB50	50	32	40	66	63	48	0.9
HSK A 63-MB63	63	42	-	75	63	48	1.1
HSK A 80-MB50	50	32	44	70	80	60	1.5
HSK A 80-MB63	63	42	54	80	80	60	1.8
HSK A 80-MB80	80	42	-	86	80	60	2.1
HSK A 100-MB50	50	32	43	72	100	75	2.0
HSK A 100-MB63	63	42	53	82	100	75	2.7
HSK A 100-MB80	80	42	59	88	100	75	3.0

• (1)Posizione tagliente

HSK A-MB: Attacco HSK "A" prolungato con innesto MB

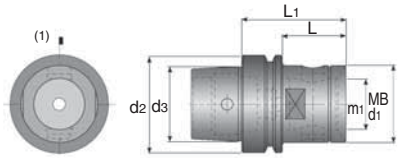


HSK DIN 69893-A MB

Descrizione	Dimensioni (mm)						
	MB d_1	m_1	L	L_1	d_2	d_3	Kg
HSK A 63 MB50X120	50	32	94	120	63	48	1.7
HSK A 100 MB50X120	50	32	91	120	100	75	3.2
HSK A 100 MB63X150	63	42	121	150	100	75	4.5
HSK A 100 MB80X180	80	42	151	180	100	75	6.5

• (1)Posizione tagliente

HSK E-MB: Attacco HSK "E" con innesto MB

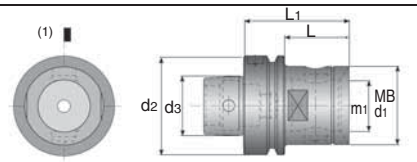


HSK DIN 69893-E MB

Descrizione	Dimensioni (mm)						
	MB d_1	m_1	L	L_1	d_2	d_3	Kg
HSK E 40 MB32	32	20	22	42	40	30	0.5
HSK E 50 MB50	50	32	-	66	50	38	0.6

• (1)Posizione tagliente

HSK F-MB: Attacco HSK "F" con innesto MB

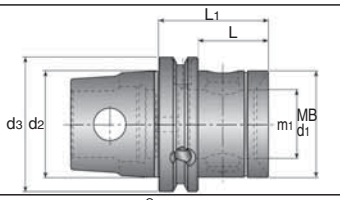


HSK DIN 69893-F MB

Descrizione	Dimensioni (mm)						
	MB d_1	m_1	L	L_1	d_2	d_3	Kg
HSK F 63 MB50	50	32	40	66	63	38	0.8

• (1)Posizione tagliente

KM XMZ MB: MB Attacco KM®(1) XMZ con innesto MB

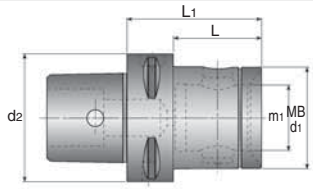


Descrizione	Dimensioni (mm)						
	MB d_1	m_1	L	L_1	d_2	d_3	Kg
KM 63 XMZ MB50	50	32	32	50	50	63	1.7
KM 63 XMZ MB63	63	42	52	70	50	63	1.9

• (1)Prodotto con KM blanks. KM® è un marchio registrato da Kennametal.

Attacchi

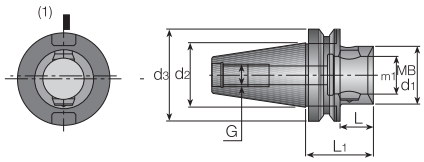
C-MB: Attacco Coromant® Capto™ (2) con innesto MB



Descrizione	Dimensioni (mm)					
	MB d_1	m_1	L	L_1	d_2	Kg
C6 MB50	50	32	45	67	63	1.9
C6 MB63	63	42	-	77	63	2.4
C8 MB63	63	42	39	70	80	2.9

• (2)Coromant Capto™ è un marchio registrato di Sandvik AB.

BT-MB Attacco BT con innesto MB

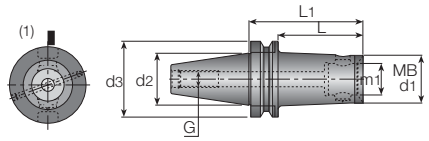


BT MAS-403 MB

Descrizione	Dimensioni (mm)							
	MB d_1	m_1	L	L_1	d_2	d_3	G	Kg
BT30-MB32	32	20	10.6	32	31.75	46	M12	0.5
BT30-MB50	50	32	-	60	31.75	46	M12	0.7
BT35-MB50	50	32	36	60	38.10	53	M12	0.8
BT40-MB40	40	25	18	45	44.45	63	M16	0.6
BT40-MB50	50	32	21	48	44.45	63	M16	0.9
BT40-MB63	63	42	-	66	44.45	63	M16	1.2
BT45-MB50	50	32	29	62	57.15	85	M20	1.7
BT45-MB63	63	42	37	70	57.15	85	M20	2.3
BT45-MB80	80	42	37	70	57.15	85	M20	2.7
BT50-MB50	50	32	28	66	69.85	100	M24	3.5
BT50-MB63	63	42	37	75	69.85	100	M24	3.7
BT50-MB80	80	42	37	75	69.85	100	M24	4.0

• (1)Posizione tagliente

BT-MB: Attacco BT A/B prolungato con innesto MB

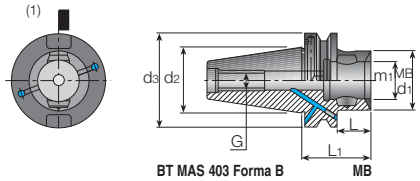


BT MAS 403 Form A/B MB

Descrizione	Dimensioni (mm)							
	MB d_1	m_1	L	L_1	d_2	d_3	G	Kg
BT40 MB40X120 A/B	40	25	120	93	44.45	63	M16	0.9
BT40 MB50X120 A/B	50	32	120	93	44.45	63	M16	1.9
BT50 MB50X120 A/B	50	32	120	82	69.85	100	M24	4.2
BT50 MB63X150 A/B	63	42	150	112	69.85	100	M24	5.8
BT50 MB80X180 A/B	80	42	180	142	69.85	100	M24	7.5

• (1)Posizione tagliente

BTB-MB Attacco BT "B" con innesto MB



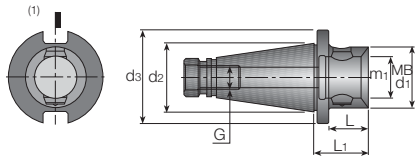
BT MAS 403 Forma B MB

Descrizione	Dimensioni (mm)							
	MB d_1	m_1	L	L_1	d_2	d_3	G	Kg
BTB 40-MB50	50	32	21	48	44.50	63	M16	0.9
BTB 40-MB63	63	42	-	66	44.50	63	M16	1.2
BTB 50-MB50	50	32	28	66	69.85	100	M24	3.5
BTB 50-MB63	63	42	37	75	69.85	100	M24	3.7
BTB 50-MB80	80	42	37	75	69.85	100	M24	4.0

• (1)Posizione tagliente

Attacchi

ISOM-MB: Attacco ISOM con innesto MB

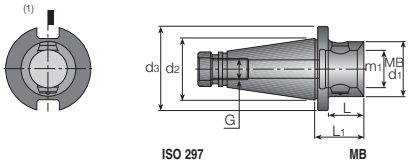


DIN 2080-A MB

Descrizione	Dimensioni (mm)							
	MB d_1	m_1	L	L_1	d_2	d_3	G	Kg
ISOM 30-MB50	50	32	-	58	31.75	50	M12	0.6
ISOM 40-MB50	50	32	36	48	44.45	63	M16	0.9
ISOM 40-MB63	63	42	-	60	44.45	63	M16	1.2
ISOM 45-MB50	50	32	33	48	57.15	80	M20	1.6
ISOM 45-MB63	63	42	45	60	57.15	80	M20	1.9
ISOM 45-MB80	80	42	-	66	57.15	80	M20	2.2
ISOM 50-MB50	50	32	33	48	69.85	97.5	M24	2.6
ISOM 50-MB63	63	42	41	56	69.85	97.5	M24	2.7
ISOM 50-MB80	80	42	45	60	69.85	97.5	M24	3.2

• (1)Posizione tagliente

ISO-MB: Attacco ISO con innesto MB

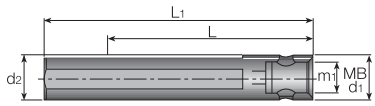


ISO 297 MB

Descrizione	Dimensioni (mm)							
	MB d_1	m_1	L	L_1	d_2	d_3	G	Kg
ISO 40-MB50	50	32	36	48	44.5	63	UNC 5/8"-11	0.9
ISO 40-MB63	63	42	-	60	44.5	63	UNC 5/8"-11	1.2
ISO 50-MB50	50	32	33	48	69.85	97.5	UNC 1"-8	2.6
ISO 50-MB63	63	42	41	56	69.85	97.5	UNC 1"-8	2.7
ISO 50-MB80	80	42	45	60	69.85	97.5	UNC 1"-8	3.2

• (1)Posizione tagliente

ST-MB: Attacco cilindrico con innesto MB

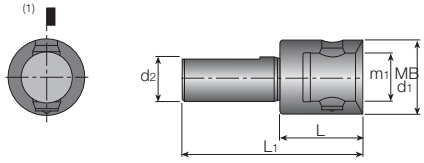


ST MB

Descrizione	Dimensioni (mm)					
	MB d_1	m_1	L (1)	L_1	d_2	Kg
ST 16-MB16	16	10	66	100	16	0.15
ST 20-MB20	20	13	85	125	20	0.30

• (1)Max. overhang

ST-MB: Attacco cilindrico con innesto MB

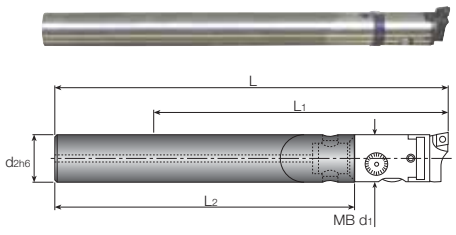


ST MB

Descrizione	Dimensioni (mm)					
	MB d_1	m_1	L_1	L	d_2	Kg
ST 25-MB32	32	20	35	100	25	0.7
ST 32-MB50	50	32	60	140	32	1.0

• (1)Posizione tagliente

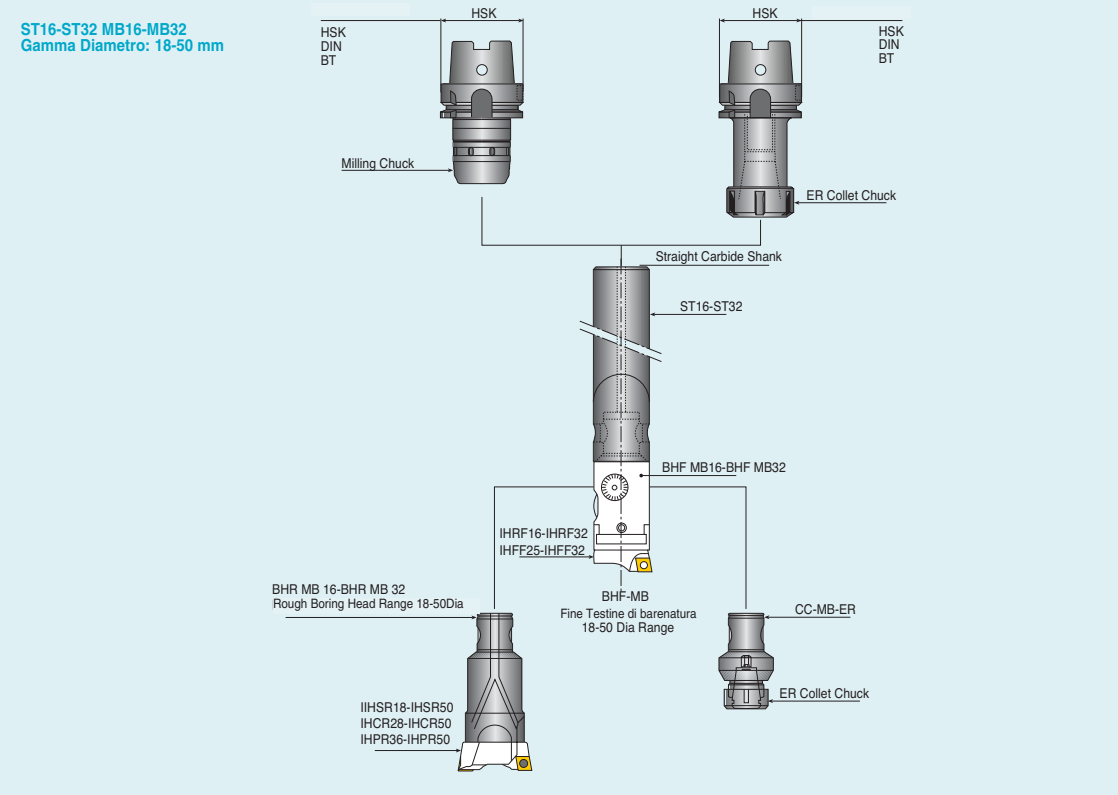
ST-MB: Attacco cilindrico in metallo duro con innesto MB



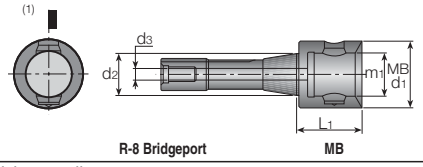
ST MB

Descrizione	Dimensioni (mm)					
	MB d_1	d_2	L	L_1	L_2	Kg
ST16 MB16X110E	16	16	144	100	110	0.3
ST16 MB16X140E	16	16	174	125	140	0.4
ST16 MB16X170E	16	16	204	160	170	0.5
ST20 MB20X135E	20	20	175	125	135	0.6
ST20 MB20X170E	20	20	210	160	170	0.75
ST20 MB20X210E	20	20	250	200	210	0.9
ST25 MB25X160E	25	25	210	160	160	1.0
ST25 MB25X205E	25	25	255	200	205	1.3
ST25 MB25X255E	25	25	305	250	255	1.6
ST32 MB32X195E	32	32	258	200	195	2.1
ST32 MB32X250E	32	32	313	250	250	2.8
ST32 MB32X315E	32	32	378	320	315	3.5

ST-MB Accessori con attacchi cilindrici in metallo duro con innesto MB ...



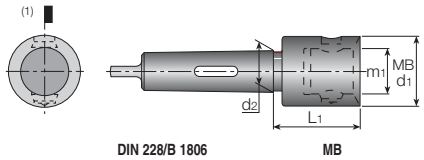
R8-MB: Attacco R8 Bridgeport con innesto MB



Descrizione	Dimensioni (mm)					
	MB d_1	m_1	L_1	d_2	d_3 inch	Kg
R8 MB50	50	32	50	31.75	UNF 7/16-20	0.8

- (1)Posizione tagliente

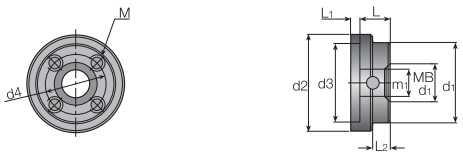
MTT-MB: Attacco MT Cono Morse con innesto MB



Descrizione	Dimensioni (mm)				
	MB d_1	m_1	L_1	d_2	Kg
MTT 5-MB63	63	42	65	44.399	0.8

- (1)Posizione tagliente

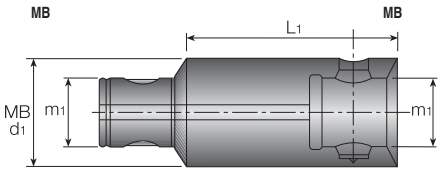
DIN 2079 MB: Anello con innesto MB



Descrizione	Dimensioni (mm)										
	MB d_1	m_1	L	L_1	L_2	d_1	d_2	d_3	d_4	M	Kg
DIN2079 MB50 40	50	32	35	10	21	90	110	88.89	66.7	M12	1.8
DIN2079 MB63 40	63	42	45	10	31	90	110	88.89	66.7	M12	2.0
DIN2079 MB63 50	63	42	45	12	31	135	150	128.57	101.6	M16	5.4
DIN2079 MB80 50	80	42	45	12	31	135	150	128.57	101.6	M16	5.3

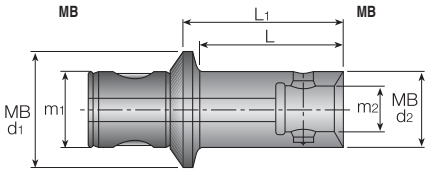
- Un anello con innesto standard si può assemblare facilmente sulla maggior parte dei centri di lavoro CNC con interfaccia DIN 2079. Questo anello con innesto permette l'utilizzo di componenti MPT con l'innesto MB utilizzando un qualsiasi adattatore con quattro viti. Viene fissato direttamente sull'attacco della macchina.

EX-MB: Prolunghe con innesto MB



Descrizione	Dimensioni (mm)			
	MB d_1	m_1	L_1	Kg
EX 14X25-MB14	14	10	25	0.2
EX 16X25-MB16	16	10	25	0.4
EX 20X32-MB20	20	13	32	0.7
EX 25X25-MB25	25	16	25	0.9
EX 25X40-MB25	25	16	40	0.15
EX 32X32-MB32	32	20	32	0.2
EX 32X50-MB32	32	20	50	0.3
EX 40X40-MB40	40	25	40	0.4
EX 40X63-MB40	40	25	63	0.6
EX 50X50-MB50	50	32	50	0.7
EX 50X80-MB50	50	32	80	1.1
EX 50X100-MB50	50	32	100	1.5
EX 63X63-MB63	63	42	63	1.4
EX 63X100-MB63	63	42	100	2.2
EX 63X125-MB63	63	42	125	2.9
EX 80X80-MB80	80	42	80	3.0
EX 80X125-MB80	80	42	125	4.6
EX 80X160-MB80	80	42	160	6.1

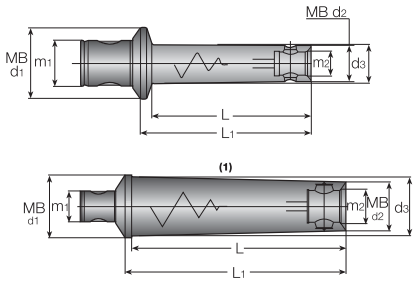
RE-MB: Riduzioni con innesto MB



Descrizione	Dimensioni (mm)						
	MB d_1	m_1	MB d_2	m_2	L	L_1	Kg
RE MB16-MB14X24	16	10	14	10	19.5	24	0.02
RE MB20-MB14X19	20	13	14	10	13.5	19	0.03
RE MB20-MB16X20	20	13	16	10	16	20	0.05
RE MB25-MB14X19	25	16	14	10	13.5	19	0.06
RE MB25-MB16X20	25	16	16	10	15	20	0.07
RE MB25-MB20X25	25	16	20	13	20	25	0.08
RE MB32-MB14X23	32	20	14	10	17	23	0.08
RE MB32-MB16X24	32	20	16	10	18	24	0.15
RE MB32-MB20X25	32	20	20	13	20	25	0.15
RE MB32-MB25X28	32	20	25	16	23	28	0.15
RE MB40-MB14X23	40	25	14	10	16	23	0.10
RE MB40-MB16X24	40	25	16	10	17	24	0.18
RE MB40-MB20X26	40	25	20	13	20	26	0.20
RE MB40-MB25X28	40	25	25	16	22	28	0.25
RE MB40-MB32X32	40	25	32	20	27	32	0.30
RE MB50-MB14X23	50	32	14	10	14.5	23	0.25
RE MB50-MB14X39	50	32	14	10	30.5	39	0.10
RE MB50-MB16X24	50	32	16	10	15	24	0.40
RE MB50-MB16X40	50	32	16	10	31	40	0.20
RE MB50-MB16X74	50	32	16	10	65	74	0.25
RE MB50-MB20X26	50	32	20	13	18	26	0.40
RE MB50-MB20X70	50	32	20	13	62	70	0.30
RE MB50-MB20X93	50	32	20	13	85	93	0.35
RE MB50-MB25X28	50	32	25	16	21	28	0.40
RE MB50-MB25X87	50	32	25	16	80	87	0.60
RE MB50-MB25X117	50	32	25	16	110	117	0.65
RE MB50-MB32X32	50	32	32	20	25	32	0.45
RE MB50-MB32X87	50	32	32	20	80	87	0.75
RE MB50-MB32X144	50	32	32	20	137	144	1.00
RE MB50-MB40X36	50	32	40	25	30	36	0.50
RE MB50-MB40X87	50	32	40	25	80	87	0.90
RE MB50-MB40X176	50	32	40	25	170	176	1.80
RE MB63-MB50X40	63	42	50	32	34	40	0.90
RE MB80-MB50X45	80	42	50	32	36	45	1.20
RE MB80-MB63X60	80	42	63	42	52	60	1.70

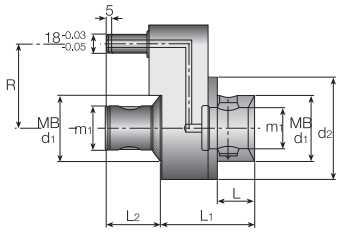
Estensioni e Riduzioni

RE-AVI: Riduzioni antivibranti con innesto MB



Descrizione	Dimensioni (mm)							
	MB d_1	m_1	MB d_2	m_2	d_3	L	L_1	Kg
RE MB50-MB16x74-AVI	50	32	16	10	17.5	65	74	0.4
RE MB50-MB20x93-AVI	50	32	20	13	21.5	85	93	0.5
RE MB50-MB25x117-AVI	50	32	25	16	27.0	110	117	0.8
RE MB50-MB32x144-AVI	50	32	32	20	35.0	138	144	1.4
RE MB50-MB40x176-AVI	50	32	40	25	47.0	170	176	2.5
RE MB63-MB50x220-AVI	63	42	50	32	60.0	214	220	5.6
RE MB80-MB63x280-AVI(1)	80	42	63	42	77.0	272	280	10.6

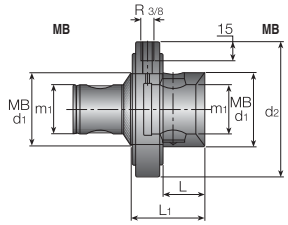
CHS MB: Aduttori del lubrificante con innesto MB



Descrizione	Dimensioni (mm)									
	MB d_1	m_1	R	d_2	L	L_1	L_2	RPM max	Bar	Kg
CHS MB50-R65	50	32	65	80	28.5	72	43	7000	5-10	1.9
CHS MB50-R80	50	32	80	80	28.5	72	43	7000	5-10	2.5
CHS MB63-R80	63	42	80	100	37.0	88	51	5600	5-10	5.0

• Utilizzare un blocchetto di fermo (non incluso)
*Importante: Far partire il flusso del lubrorefrigerante prima di far girare il mandrino, per non danneggiare le guarnizioni OR.

CHR-MB: Prolunga con aduttore del lubrificante con innesto MB



Descrizione	Dimensioni (mm)									
	MB d_1	m_1	R	d_2	L	L_1	L_2	RPM max	Bar	Kg
CHR MB63	63	42	115	35	63	3500	5	2.	5-10	5.0

• Utilizzare con blocchetto di fermo (non incluso)
*Importante: Far partire il flusso del lubrorefrigerante prima di far girare il mandrino, per non danneggiare le guarnizioni OR.

EMH-MB: Mandrino Weldon con innesto MB

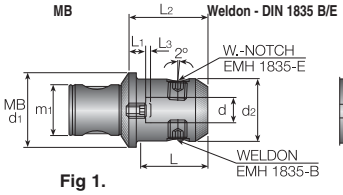
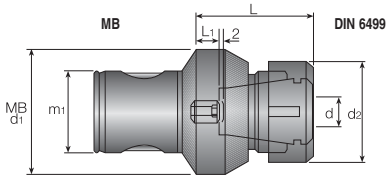


Fig 1.

Fig 2.

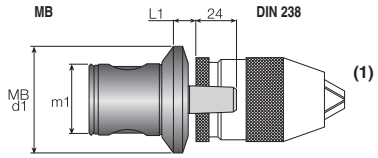
Descrizione	Dimensioni (mm)									
	MB d_1	m_1	d (H5)	d_2	L	L_1	L_2	L_3	Fig.	Kg
EMH MB 50-8	50	32	8	28	33	7	44	2	1	0.5
EMH MB 50-10	50	32	10	35	42	11	52	3	1	0.7
EMH MB 50-12	50	32	12	42	48	11	57	3	1	0.8
EMH MB 50-14	50	32	14	42	48	11	57	3	1	0.8
EMH MB 50-16	50	32	16	48	61	17	67	4	1	1.1
EMH MB 50-20	50	32	20	51	-	16	67	4	1	1.2
EMH MB 63-16	63	42	16	48	53	14	64	4	1	1.4
EMH MB 63-20	63	42	20	52	56	14	66	4	1	1.5
EMH MB 63-25	63	42	25	64	-	16	74	4	2	2.1
EMH MB 63-32	63	42	32	72	-	14	76	4	2	2.5
EMH MB 80-40	80	42	40	80	-	12	83	4	2	3.2

CC-MB-ER: Mandrino ER porta pinze con innesto MB



Descrizione	Dimensioni (mm)						
	MB d_1	m_1	d	d_2	L	L_1	Kg
CC MB16 ER11M	16	10	0.5 - 7	16	25	2.5	0.03
CC MB20 ER16M	20	13	0.5 - 10	22	32	1.0	0.06
CC MB25 ER20M	25	16	1 - 13	28	40	2.5	0.15
CC MB32 ER25M	32	20	1 - 16	35	42	1.5	0.25
CC MB40 ER25	40	25	1 - 16	42	45	5.0	0.25
CC MB50 ER25	50	32	1 - 16	42	48	7.0	0.70
CC MB50 ER32	50	32	2 - 20	50	59	7.0	1.00
CC MB63 ER32	63	42	2 - 20	50	59	12	1.30
CC MB63 ER40	63	42	3 - 26	63	64	12	1.50

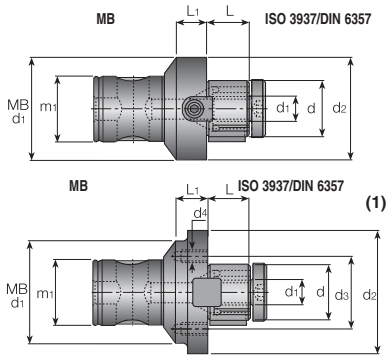
DC MB: Mandrino Porta Punte con innesto MB



Descrizione	Dimensioni (mm)			
	MB d_1	m_1	L_1	Kg
DC MB50 B16	50	32	10.0	0.4
DC MB63 B16	63	42	13.5	0.8

• (1)Senza mandrino porta punte

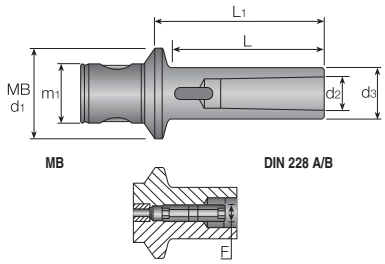
SMH-MB: Porta frese frontali con innesto MB



Descrizione	Dimensioni (mm)									
	MB d_1	m_1	d	d_2	d_3	d_4	d_1	L	L_1	Kg
SMH MB40-16	40	25	16	32	—	—	M8	17	15	0.48
SMH MB40-22	40	25	22	40	—	—	M10	19	13	0.4
SMH MB50-16	50	32	16	32	—	—	M 8	17	15	0.5
SMH MB50-22	50	32	22	40	—	—	M 10	19	15	0.5
SMH MB50-27	50	32	27	50	—	—	M 12	21	15	0.6
SMH MB50-32	50	32	32	70	—	—	M 16	24	15	0.7
SMH MB63-27	63	42	27	60	—	—	M 12	21	15	1.1
SMH MB63-32	63	42	32	70	—	—	M 16	24	15	1.2
SMH MB80-32	80	42	32	70	—	—	M 16	24	15	1.9
SMH MB80-40(1)	80	42	40	88	66.7	M12	M 20	27	24	2.1
SMH MB80-60(1)	80	42	60	128.5	101.6	M16	M 30	40	31.5	3.5

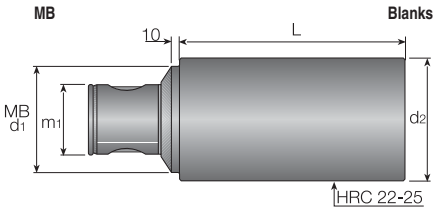
Ricambi
H43-H45

AMT-MB: Mandrino cono morse con innesto MB



Descrizione	Dimensioni (mm)								
	MB d_1	m_1	Morse	d_2	d_3	F	L	L_1	Kg
AMT MB50-MT1	50	32	1	12.065	20	M6	68	80	0.6
AMT MB50-MT2	50	32	2	17.780	30	M10	86	100	0.7
AMT MB50-MT3	50	32	3	23.825	36	M12	110	120	1.0
AMT MB63-MT3	63	42	3	23.825	36	M12	108	120	1.3
AMT MB63-MT4	63	42	4	31.267	48	M16	133	150	2.0

BLANK-MB: Blanks con innesto MB

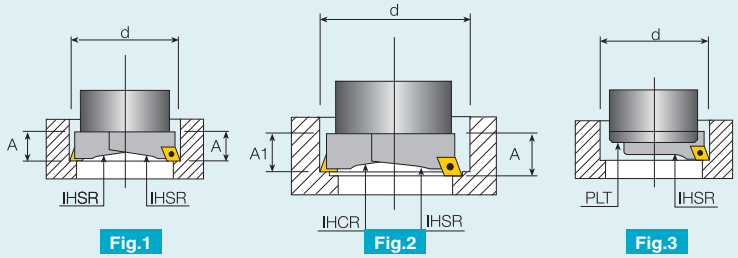


Descrizione	Dimensioni (mm)			
	MB d_1	m_1	d_2	L
BLANK MB50-63X60	50	32	63	60
BLANK MB50-63X120	50	32	63	210
BLANK MB50-63X150	50	32	63	150
BLANK MB50-80X150	50	32	80	150
BLANK MB50-100X150	50	32	100	150
BLANK MB63-80X100	63	42	80	100
BLANK MB63-80X150	63	42	80	150
BLANK MB63-100X100	63	42	100	100
BLANK MB63-100X150	63	42	100	150
BLANK MB63-120X100	63	42	120	100
BLANK MB63-120X200	63	42	120	200
BLANK MB80-100X100	80	42	100	100
BLANK MB80-80X100	80	42	80	100
BLANK MB80-80X150	80	42	80	150
BLANK MB80-100X150	80	42	100	150
BLANK MB80-120X100	80	42	120	100
BLANK MB80-120X200	80	42	120	200
BLANK MB80-100X150	80	42	100	150
BLANK MB80-120X100	80	42	120	100
BLANK MB80-120X200	80	42	120	200

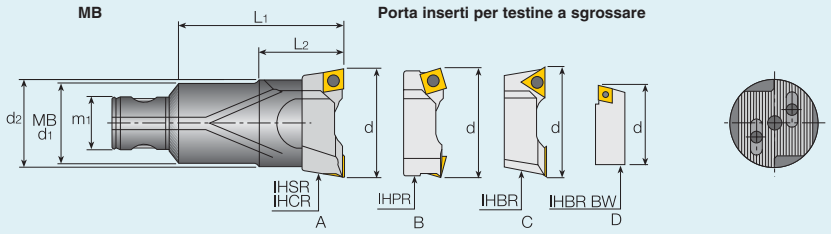
Ricambi
H43-H45

Testine di Barenatura a sgrossare

Accessori per testine di sgrossatura



Nell'utilizzo del sistema MPT, è fortemente consigliato l'uso di un pre-setting con funzione per regolare i taglienti radiali. I bareni sono forniti con 2 porta inserti, per lavorazioni di sgrossatura e grandi asportazioni.
I bareni sono utilizzabili in 3 tipi di lavorazioni:
- Quando i due porta inserti IHSR sono sullo stesso piano, i due taglienti sono equidistanti radialmente, per sgrossare ad alti avanzamenti (Fig. 1).
- Quando i due porta inserti IHCR e IHSR non sono sullo stesso piano, i due taglienti sono a distanze radiali differenti, per sgrossature profonde (Fig. 2).
- Se i bareni montano un solo porta inserto, si possono fare con un'asportazione normale, sia operazioni di sgrossatura che di finitura. In questo caso è fortemente consigliato di utilizzare un anello di protezione ben fisso (Fig. 3).

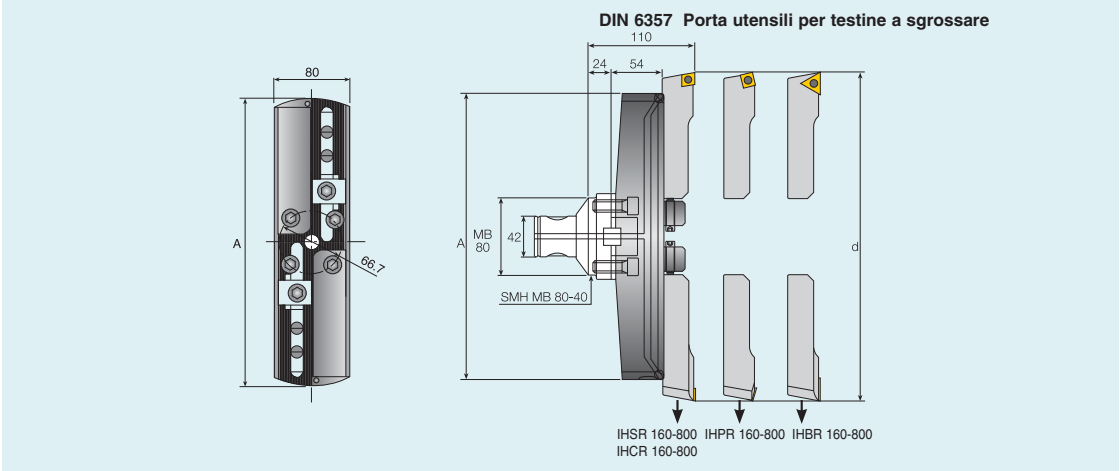


BHR-MB: Testine di Barenatura a sgrossare 18-200mm con innesto MB

Descrizione	d- Gamma Barenatura	MB d_1	m_1	d_2	L_1	L_2	Porta Inserti	Porta Inserti				Kg
								A	B	C	D	
	18-22	16	10	16	34	—	IH...18-22	●			●	0.05
	22-28	20	13	20	40	—	IH...22-28	●			●	0.09
	28-38	25	16	25	50	—	IH...28-38	●			●	0.20
	36-50	32	20	32	63	—	IH...36-50	●	●		●	0.35
	50-68	40	25	40	80	—	IH...50-68	●	●		●	0.70
	68-90	50	32	55	100	50	IH...68-90	●	●		●	1.50
	90-120	50	32	72	80	60	IH...90-120	●	●	●	●	2.00
	90-120	63	42	72	125	63	IH...90-120	●	●	●	●	3.00
	120-160	80	42	95	140	75	IH...120-160	●	●	●	●	5.30
	160-200	80	42	95	140	75	IH...160-800	●	●	●	●	5.30

Ricambi H43-H45
Utensili H14
Guida H46-H52

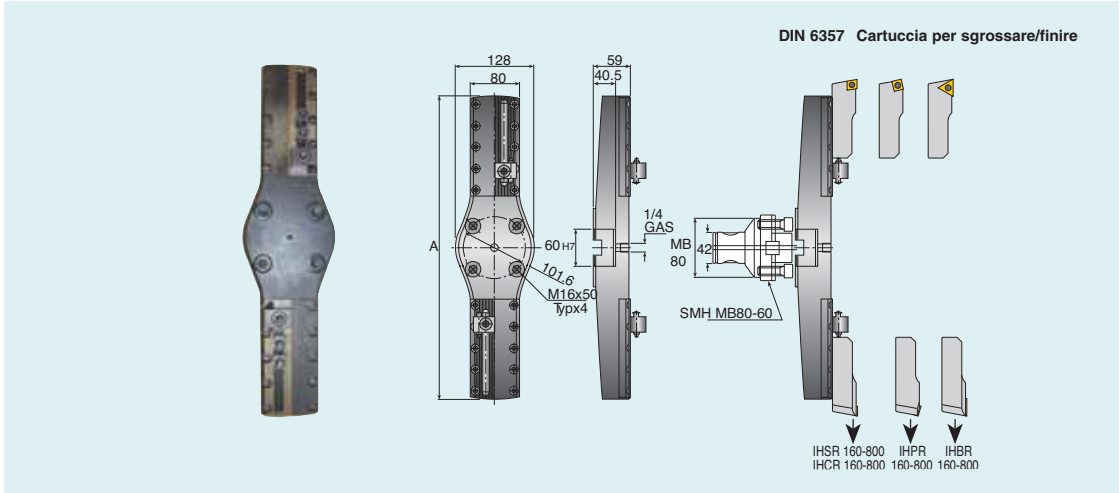
Testine di Barenatura a sgrossare



TCH: Gamma Testine di Barenatura a sgrossare: 200-500mm con innesto MB

Descrizione	d Gamma Barenatura	A	IH...160-800	Kg
TCH 200	200-300	198	IHSR 160-800 IHCR 160-800 IHPR 160-800 IHBR 160-800	2.6
TCH 300	300-400	298		3.5
TCH 400	400-500	398		4.1

- Corpo in alluminio con sedi seghettate in acciaio.



TCH A.L: Gamma testine di barenatura a sgrossare con doppio taglio in alluminio: 500-800mm con innesto MB

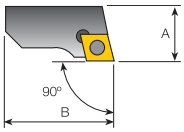
Descrizione	d Gamma Barenatura	A	Kg
TCH A.L 500	500-600	494	7.5
TCH A.L 600	600-700	594	9
TCH A.L 700	700-800	694	10.5

- Corpo in alluminio con sedi seghettate in acciaio.

Ricambi H43-H45
Utensili H14
Guida H46-H52

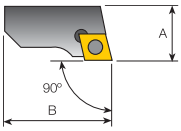
Bareni di sgrossatura - cartucce porta inserto

IHSR



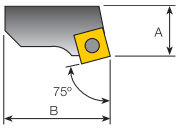
Descrizione	Gamma Bareno	A	B	Vite Inserto	Chiave Torx	Inserto
IHSR 18-22	18-22	8.0	15.0	SR 14-548	T7/5	CCMT 0602...
IHSR 22-28	22-28	9.5	19.0	SR 14-548	T7/5	CCMT 0602...
IHSR 28-38	28-38	12.5	23.0	SR 14-548	T7/5	CCMT 0602...
IHSR 36-50	36-50	15.0	32.0	SR 14-548	T7/5	CCMT 0602...
IHSR 50-68	50-68	19.0	40.0	TS 40097I	T15/5	CCMT 09T3...
IHSR 50-68-12	50-68	19.0	40.0	SR 16-212	T20/5	CCMT 1204..
IHSR 68-90	68-90	22.0	54.0	SR 16-212	T20/5	CCMT 1204..
IHSR 90-120	90-120	27.0	70.5	SR 16-212	T20/5	CCMT 1204...
IHSR 120-160	120-160	32.0	94.5	SR 16-212	T20/5	CCMT 1204..
IHSR 160-800	160-180	32.0	130.0	SR 16-212	T20/5	CCMT 1204..

IHCR



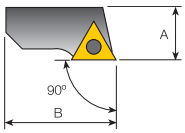
Descrizione	Gamma Bareno	A	B	Vite Inserto	Chiave Torx	Inserto
IHCR 28-38	28-38	12.3	23.0	SR 14-548	T7/5	CCMT 0602..
IHCR 36-50	36-50	14.8	32.0	SR 14-548	T7/5	CCMT 0602...
IHCR 36-50-09	36-50	14.8	32.0	TS 40097I	T15/5	CCMT 09T3..
IHCR 50-68	50-68	18.7	40.0	TS 40097I	T15/5	CCMT 09T3..
IHCR 50-68-12	50-68	18.7	40.0	SR 16-212	T20/5	CCMT 1204..
IHCR 68-90	68-90	21.7	54.0	SR 16-212	T20/5	CCMT 1204..
IHCR 90-120	90-120	26.7	70.5	SR 16-212	T20/5	CCMT 1204..
IHCR 120-160	120-160	31.7	94.5	SR 16-212	T20/5	CCMT 1204..
IHCR 160-800	160-800	31.7	130.0	SR 16-212	T20/5	CCMT 1204..

IHPR



Descrizione	Gamma Bareno	A	B	Vite Inserto	Chiave Torx	Inserto
IHPR 36-50	36-50	15	32.0	TS 40097I	T15/5	SCMT 09T3..
IHPR 50-68	50-68	19	40.0	TS 40097I	T15/5	SCMT 09T3...
IHPR 68-90	68-90	22	54.0	SR 16-212	T20/5	SCMT 1204..
IHPR 90-120	90-120	27	70.5	SR 16-212	T20/5	SCMT 1204..
IHPR 120-160	120-160	32	94.5	SR 16-212	T20/5	SCMT 1204..
IHPR 160-800	160-800	32	130.0	SR 16-212	T20/5	SCMT 1204..

IHBR



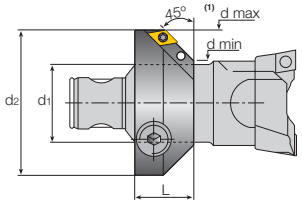
Descrizione	Gamma Bareno	A	B	Vite Inserto	Chiave Torx	Inserto
IHBR 90-120	90-120	27	70.5	SR 16-212	T20/5	TCMT 2205..
IHBR 120-160	120-160	32	94.5	SR 16-212	T20/5	TCMT 2205..
IHBR 160-800	160-800	32	130.0	SR 16-212	T20/5	TCMT 2205..

Inserto H40-H42

Guida H46-H52

Bareni di sgrossatura - cartucce porta inserto

CHA.. 45°: Bareno di smussatura

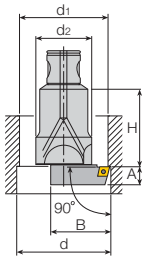


Descrizione	d	d1	d2	L	Inserto	Vite Inserto	Chiave Torx	Kg
CHA 16-45	18-28	16	28	13	DCMT 0702..	SR 14-548	T7/5	0.035
CHA 20-45	22-32	20	32	15	DCMT 0702..	SR 14-548	T7/5	0.045
CHA 25-45	28-43	25	43	18	DCMT 0702..	SR 14-548	T7/5	0.10
CHA 32-45	35-54	32	54	22	DCMT 0702..	SR 14-548	T7/5	0.20
CHA 40-45	46-72	40	72	30	DCMT 11T3..	SR 16-236P	T15/5	0.50
CHA 50-45	56-95	50	95	38	DCMT 11T3..	SR 16-236P	T15/5	1.10

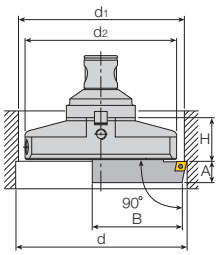
- Per minimizzare il testimone, usare un inserto con raggio di 0.2 mm.
- (1)Solo un inserto può essere montato contemporaneamente su una delle due sedi.

IHSR-BW: Cartucce per BHR e TCH per retro barenatura per testine di sgrossatura

BHR 20-162/IHSR...BW



TCH 200-800/IHSR...BW



Descrizione	BHR/TCH	d Gamma Bareno	d2	H	A	B
IHSR 20-24 BW	BHR16-16	20-24	16	27.5	8.0	16.0
IHSR 23.5-30 BW	BHR20-20	23.5-30	20	32.5	9.5	19.5
IHSR 29.5-40 BW	BHR25-20	29.5-40	25	39.0	12.0	24.0
IHSR 39-52 BW	BHR32-32	39-52	32	50.0	14.0	32.0
IHSR 51-70 BW	BHR40-40	51-70	40	63.5	17.5	42.0
IHSR 69-92 BW	BHR50-50	69-92	55	80.5	21.0	57.0
IHSR 91-122 BW	BHR63-63	91-122	72	100.5	25.0	76.0
IHSR 121-162 BW	BHR80-80	121-162	95	110.5	28.0	101.0
IHSR 161-802 BW	BHR80-08	161-802	95	110.5	28.0	122.0
IHSR 161-802 BW	TCH200	202-302	198	56.5	28.0	122.0
IHSR 161-802 BW	TCH300	302-402	298	56.5	28.0	122.0
IHSR 161-802 BW	TCH400	402-502	398	61.5	28.0	122.0
IHSR 161-802 BW	TCH500	502-602	494	61.5	28.0	122.0
IHSR 161-802 BW	TCH600	602-702	594	61.5	28.0	122.0
IHSR 161-802 BW	TCH700	702-802	694	61.5	28.0	122.0

- d_2= Dimensioni del bareno in uso.
- d_1= (diametro min. foro)= (d+d2+1)÷2

Ricambi

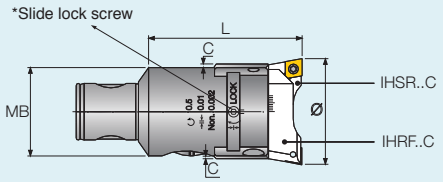
Descrizione	Vite di bloccaggio	Chiave Torx	Inserto
IHSR 20-24 BW	SR 14-548	T7/5	CCMT 0602..
IHSR 23.5-30 BW	SR 14-548	T7/5	CCMT 0602..
IHSR 29.5-40 BW	SR 14-548	T7/5	CCMT 0602..
IHSR 39-52 BW	TS 40097I	T15/5	CCMT 09T3..
IHSR 51-70 BW	SR 16-212	T20/5	CCMT 1204..
IHSR 69-92 BW	SR 16-212	T20/5	CCMT 1204..
IHSR 91-122 BW	SR 16-212	T20/5	CCMT 1204..
IHSR 121-162 BW	SR 16-212	T20/5	CCMT 1204..
IHSR 161-802 BW	SR 16-212	T20/5	CCMT 1204..

Inserto H40-H42
Guida H46-H52

Testine di Barenatura di finitura

BHC-MB: Regolazione diretta del diametro 10µm e 2µm con la scala del Nonio

10µm
2µm



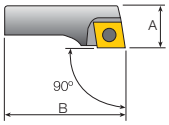
BHC-MB: Testine Combi sgrossatura/finitura

Descrizione	Gamma Bareno	MB	L	C	Porta inserto	Kg
BHC MB25-25X57	28-36	25	56.5	±0.5	IH.. C	0.20
BHC MB32-32X71	36-46	32	71.0	±0.5	IH.. C	0.35
BHC MB40-40X90	46-60	40	90.0	±1.0	IH.. C	0.70
BHC MB50-50X87	60-75	50	87.0	±1.0	IH.. C	1.50
BHC MB63-63X109	75-95	63	109.0	±2.0	IH.. C	2.70
BHC MB80-80X130	95-120	80	130.0	±2.0	IH.. C	4.80

- Le testine per sgrossatura precedono quelle a finire di 0.2 mm. Ogni testina può essere regolata indipendentemente.
- Il porta inserti per finitura può essere regolato radialmente fino a 5 microns.

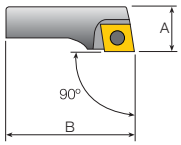
*Importante
- Gli inserti raggiati per barenature combinate di sgrossatura e finitura devono essere della stessa misura .
- Allentare la vite della slitta* prima di ogni regolazione.

IHRF-C: Cartucce porta inserto di finitura per testine Combo BHC



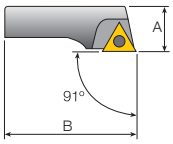
Descrizione	Gamma Bareno	A	B	Vite Inserto	Chiave Torx	Inserto
IHRF 28-36 C	28-36	9.8	24.0	SR 14-548	T7/5	CCGT 0602..
IHRF 36-46 C	36-46	11.3	30.0	SR 14-548	T7/5	CCGT 0602..
IHRF 46-60 C	46-60	13.8	40.0	TS 40097I	T15/5	CCGT 09T3...
IHRF 60-75 C	60-75	18.8	54.0	TS 40097I	T15/5	CCGT 09T3...
IHRF 75-95 C	75-95	24.3	68.0	TS 40097I	T15/5	CCGT 09T3...
IHRF 95-120 C	95-120	29.3	87.0	TS 40097I	T15/5	CCGT 09T3...

IHSR-C: Cartucce porta inserto di sgrossatura per testine Combi BHC



Descrizione	Gamma Bareno	A	B	Vite Inserto	Chiave Torx	Inserto
IHSR 28-36 C	28-36	10.0	24.0	SR 14-548	T7/5	CCMT 0602..
IHSR 36-46 C	36-46	11.5	30.0	SR 14-548	T7/5	CCMT 0602..
IHSR 46-60 C	46-60	14.0	40.0	TS 40097I	T15/5	CCMT 09T3...
IHSR 60-75 C	60-75	19.0	54.0	TS 40097I	T15/5	CCMT 09T3...
IHSR 75-95 C	75-95	24.5	68.0	TS 40097I	T15/5	CCMT 09T3...
IHSR 95-120 C	95-120	29.5	87.0	TS 40097I	T15/5	CCMT 09T3...

IHFF-C: Cartucce porta inserto di finitura per testine Combi BHC



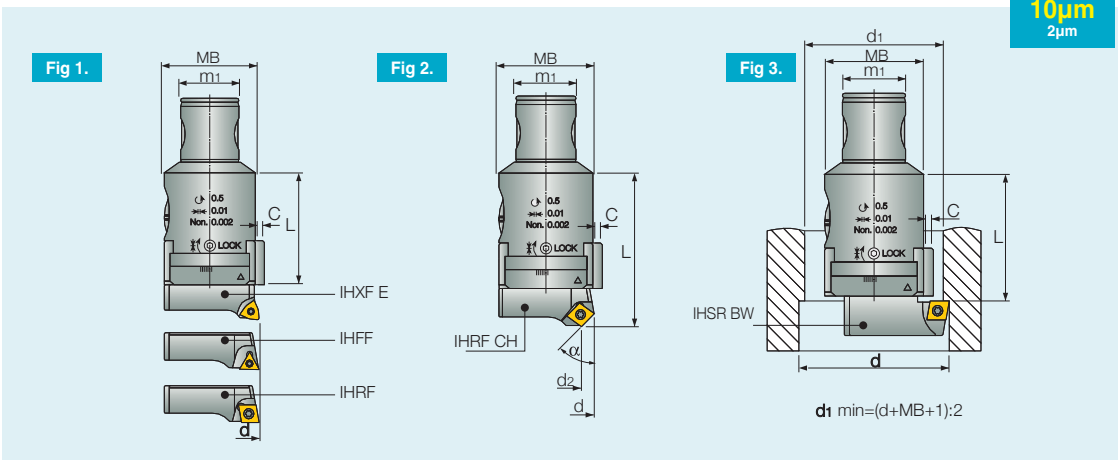
Descrizione	Gamma Bareno	A	B	Vite Inserto	Chiave Torx	Inserto
IHFF 28-36 C	28-36	9.8	24.0	SO 25061I	T8/5	TPGX 0902...
IHFF 36-46 C	36-46	11.3	30.0	SO 25061I	T8/5	TPGX 0902...
IHFF 46-60 C	46-60	13.8	40.0	SO 30081I	T8/5	TPGX 1103...
IHFF 60-75 C	60-75	18.8	54.0	SO 30081I	T8/5	TPGX 1103...
IHFF 75-95 C	75-95	24.3	68.0	SO 30081I	T8/5	TPGX 1103...
IHFF 95-120 C	95-120	29.3	87.0	SO 30081I	T8/5	TPGX 1103...

Inserto
H40-H42

Testina di Barenatura di finitura

BHE-MB: Regolazione diretta del diametro 10µm e 2µm con la Scala del Nonio

10µm
2µm

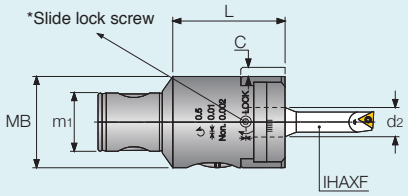


Descrizione	d	d1	MB	m1	L	α°	C	IH				Kg.	Fig.
BHE MB14-14X30	14.5-18	-	14	10	30.0	-	1	IH..14	●	-	-	0.02	1
BHE MB16-16X34	18-24	-	16	10	34.0	-	2	IH..16	-	-	●	0.05	1
	20-26	16	16	10	27.5	-	2	IH..16	-	-	●	0.05	3
BHE MB20-20X40	22-30	-	20	13	40.0	-	3	IH..20	-	-	●	0.10	1
	24.5-33	20	20	13	33.5	-	3	IH..20	-	-	●	0.10	3
BHE MB25X25-50	28-40	-	25	16	50.0	-	3	IH..25	-	●	●	0.20	1
	28-40	25-37	25	16	50.0	15.0	3	IH..25	-	-	●	0.20	2
	28-40	21.5-33.5	25	16	50.0	30.0	3	IH..25	-	-	●	0.20	2
	28-40	19-31	25	16	50.0	45.0	3	IH..25	-	-	●	0.20	2
	31.5-42	25	25	16	41.5	-	3	IH..25	-	-	●	0.20	3
BHE MB32-32X63	35-53	-	32	20	63.0	-	4	IH..32	-	●	●	0.35	1
	35-53	31.5-49.5	32	20	63.0	15.0	4	IH..32	-	-	●	0.35	2
	35-53	28.5-46.5	32	20	63.0	30.0	4	IH..32	-	-	●	0.35	2
	35-53	26-43	32	20	63.0	45.0	4	IH..32	-	-	●	0.35	2
	39-55	32	32	20	53.0	-	4	IH..32	-	-	●	0.35	3
BHE MB40-40X80	48-66	-	40	25	80.0	-	5	IH..40	-	●	●	0.70	1
	48-66	43-61	40	25	80.0	15.0	5	IH..40	-	-	●	0.70	2
	48-66	38.5-56.5	40	25	80.0	30.0	5	IH..40	-	-	●	0.70	2
	48-66	34.5-52.5	40	25	80.0	45.0	5	IH..40	-	-	●	0.70	2
	51-68	40	40	25	68.0	-	5	IH..40	-	-	●	0.70	3
BHE MB50-50X80	54-86	-	50	32	80.0	-	5	IH..50	-	●	●	1.0	1
	54-86	49-81	50	32	80.0	15.0	5	IH..50	-	-	●	1.0	2
	54-86	44.5-76.5	50	32	80.0	30.0	5	IH..50	-	-	●	1.0	2
	54-86	40.5-72.5	50	32	80.0	45.0	5	IH..50	-	-	●	1.0	2
	56-88	50	50	32	63.0	-	5	IH..50	-	-	●	1.0	3
BHE MB63-63X89	75-125	-	63	42	89.0	-	10	IH..50	-	●	●	2.6	1
BHE MB80-80X104	92-160	-	80	42	104.0	-	12	IH..50	-	●	●	4.2	1

Testine di Barenatura di finitura

BHE-MB: Regolazione diretta del diametro 10µm e 2µm con la Scala del Nonio

10µm
2µm



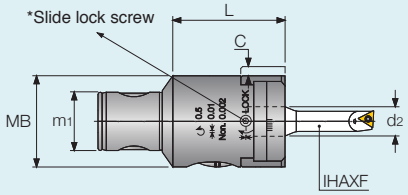
BHE-MB: Testa di finitura (2.5-30mm)

Descrizione	Gamma Bareno	MB	m1	d2 H6	L	C	Kg
BHE MB50-50X80	2.5-30	50	32	16	61	5	1.0

• Importante: Allentare la vite della slitta* prima della regolazione.

BHE-MB-H: Regolazione diretta del diametro 10µm e 2µm con la Scala del Nonio

10µm
2µm

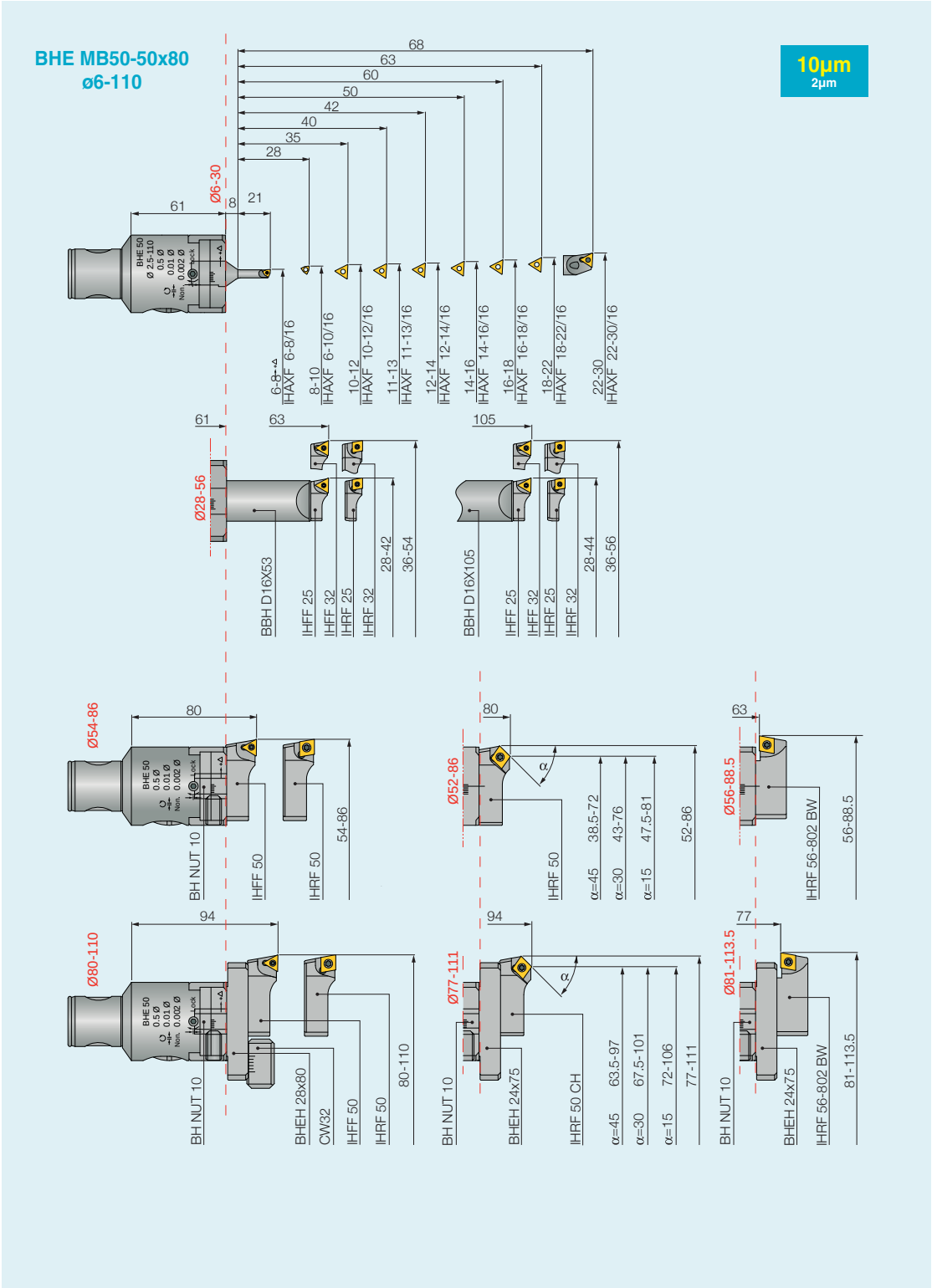


BHE-MB-H: Testa di finitura per alte velocità

Descrizione	Gamma Bareno	MB	m1	d2 H6	L	C	Kg
BHE MB32-32X53 H	2.5-18	32	20	8	53	3	0.35
BHE MB50-50x60 H	2.5-22	50	32	16	60	4	1.00

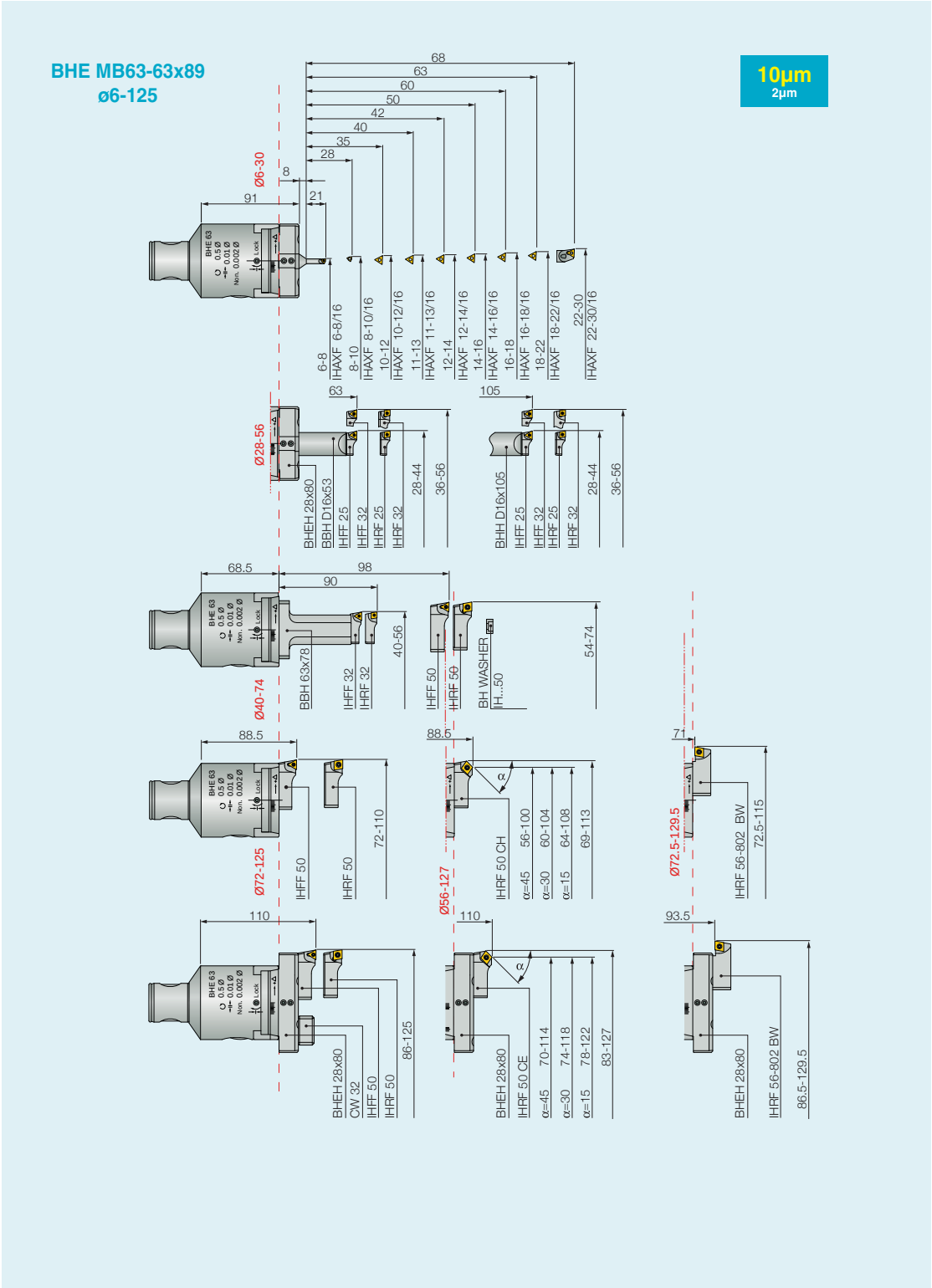
• Importante: Allentare la vite della slitta * prima di iniziare la regolazione.

Gamma bareni di finitura: Regolazione diretta del diametro 10µm e 2µm con la Scala del Nonio

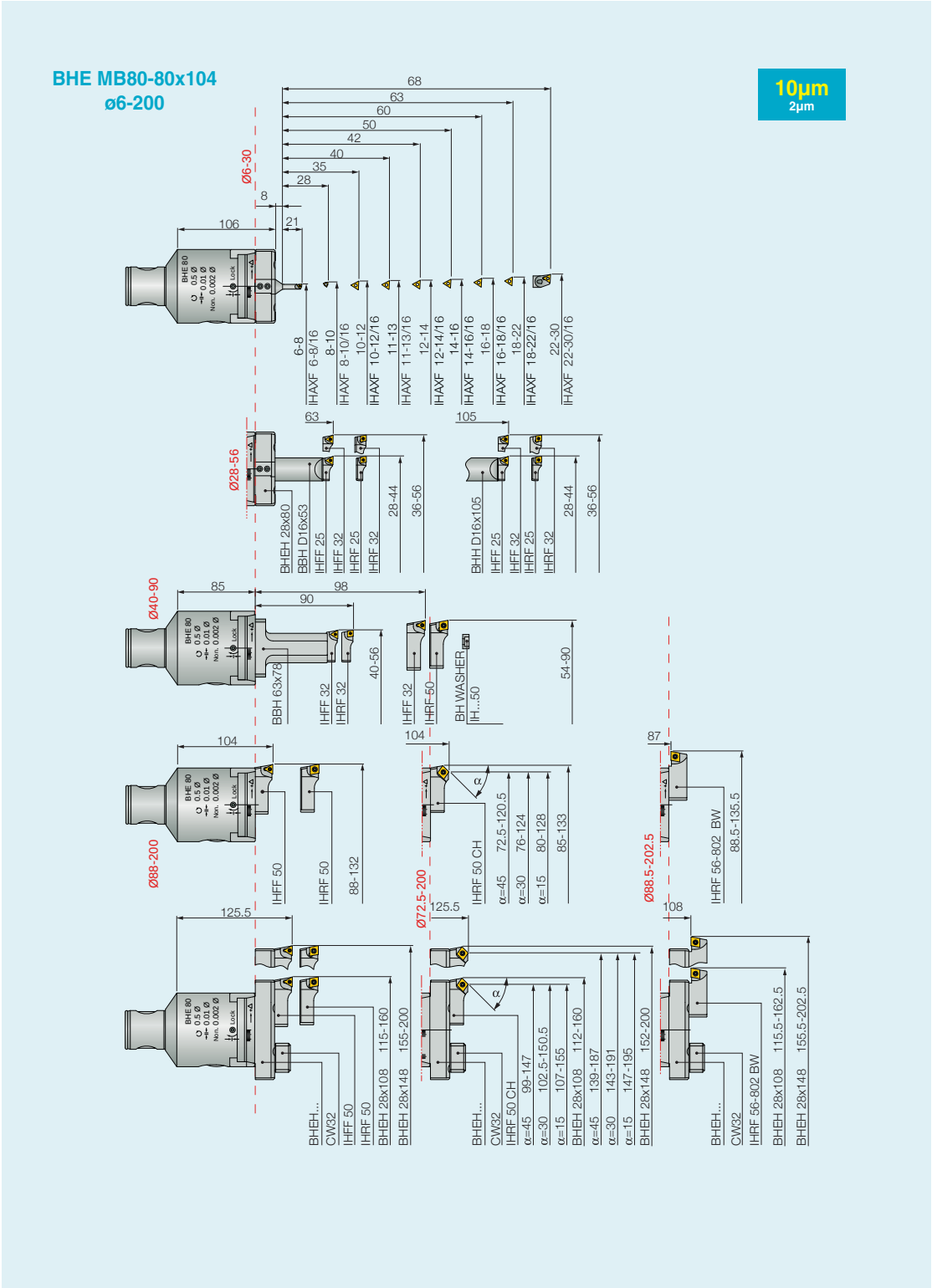


Testine di Barenatura di finitura

Gamma bareni di finitura: Regolazione diretta del diametro 10µm e 2µm con la Scala del Nonio



Gamma bareni di finitura: Regolazione diretta del diametro 10µm e 2µm con la Scala del Nonio



Testina di Barenatura di finitura

BHF Testine di Barenatura a finire

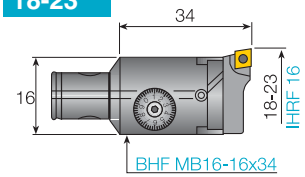
2µm

Queste testine per barenatura permettono microregolazioni anche di 0.002mm, consentendo lavorazioni di alta precisione con tolleranze strettissime e con una finitura superficiale eccellente.

BHF MB16-MB40
Gamma Diametro: 18-63

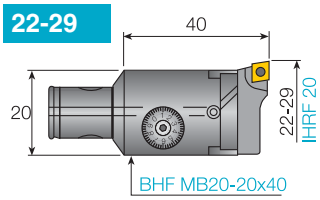
BHF MB16-16x34 RV

18-23



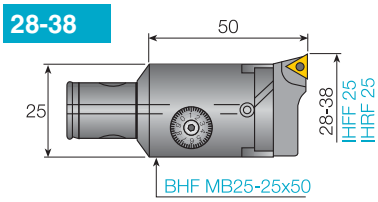
BHF MB20-20x40 RV

22-29



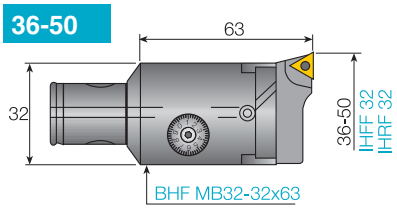
BHF MB25-25x50

28-38



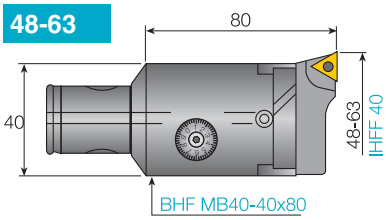
BHF MB32-32x63

36-50



BHF MB40-40x80

48-63



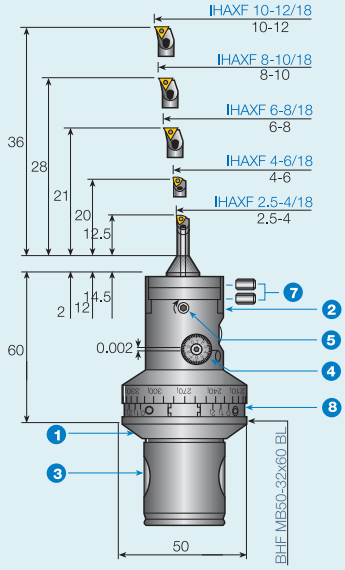
Gamma dei diametri testine di Barenatura a finire

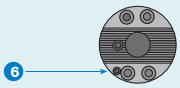
	0 10 20 30 40 50 60 70 80 90 100 110 120 130 150 180 280 400 600 700 800
BHF MB50-32x60 BL	2.5-12
BHF MB50-50x68 BL	2.5-20
BHF MB50-50x60	2.5-84
BHF MB50-63x87	2.5-160
BHF MB80-80x94	2.5-220
BHF MB16-16x34 RV	18-23
BHF MB20-20x40 RV	22-29
BHF MB25-25x50	28-38
BHF MB32-32x63	36-50
BHF MB40-40x80	48-63
BHF MB80-125x114	36-500
TCH 200	
TCH 300	300-400
TCH 400	400-500
TCH A.L 500	500-600
TCH A.L 600	600-700
TCH A.L 700	700-800

Testina di Barenatura a finire con anello di bilanciatura

BHF MB50-32x60 BL
Gamma Diametro: 2.5-12

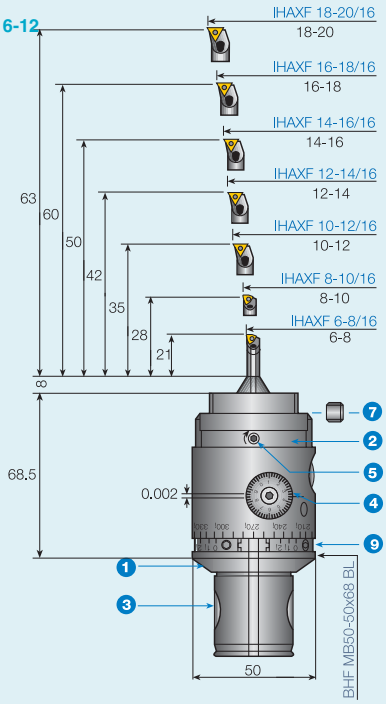
2µm

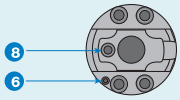




1. Corpo
2. Slitta Utensile
3. Perno ad espandere
4. Regolatore diametro
5. Vite Bloccaggio Slitta
6. Refrigerante
7. Viti Bloccaggio Bareno
8. Anello di Bilanciatura

BHF MB50-50x68 BL
Gamma Diametro: 6-12



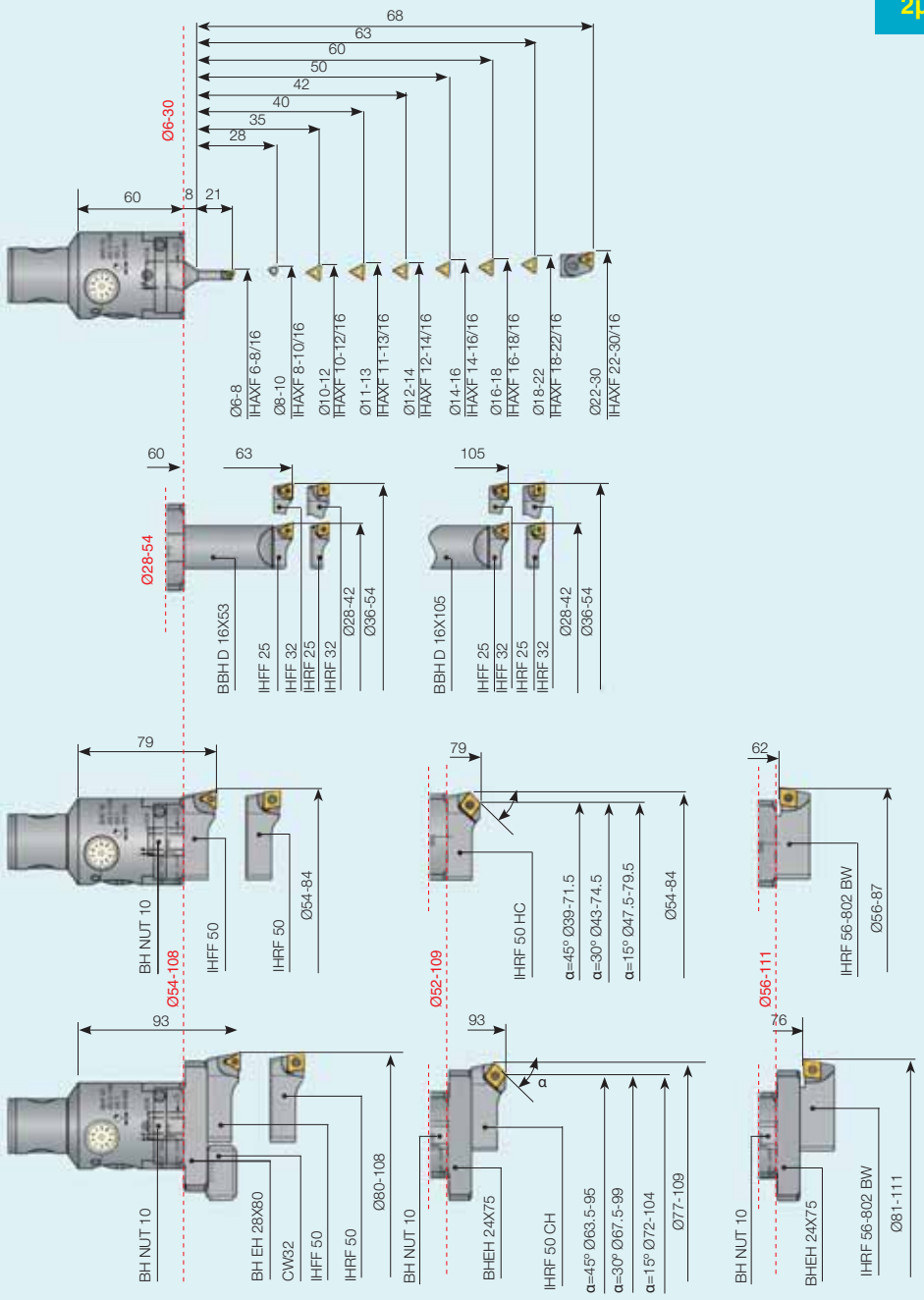


1. Corpo
2. Slitta Utensile
3. Perno ad espandere
4. Regolatore diametro
5. Vite Bloccaggio Slitta
6. Refrigerante
7. Viti Bloccaggio Bareno
8. Ugello oliatura
9. Anello di Bilanciatura

Gamma Bareni di finitura: Regolazione diretta del diametro **2µm**

BHF MB50-50x60
Gamma Diametro: 6-108

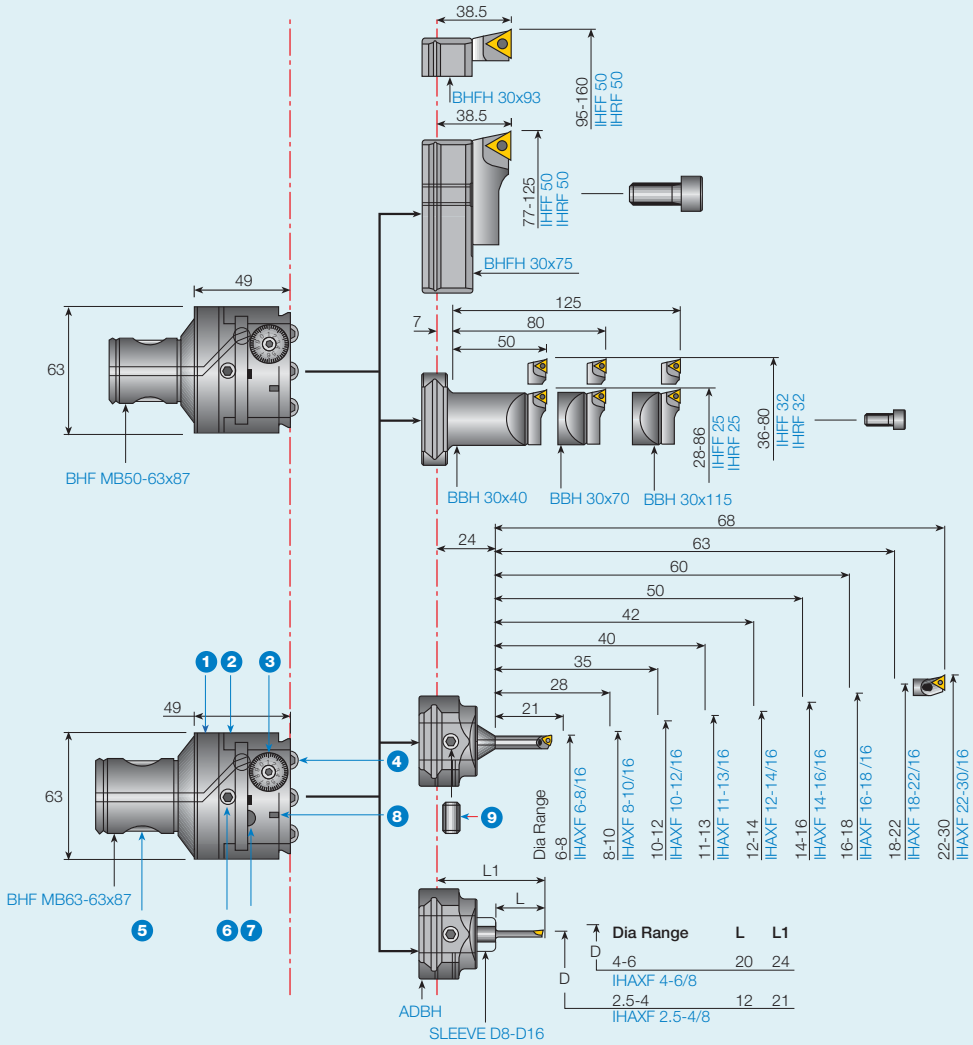
2µm



Gamma Bareni di finitura: Regolazione diretta del diametro **2µm**

BHF MB50-63x87
BHF MB63-63x87
Gamma Diametro: 2.5-160

2µm

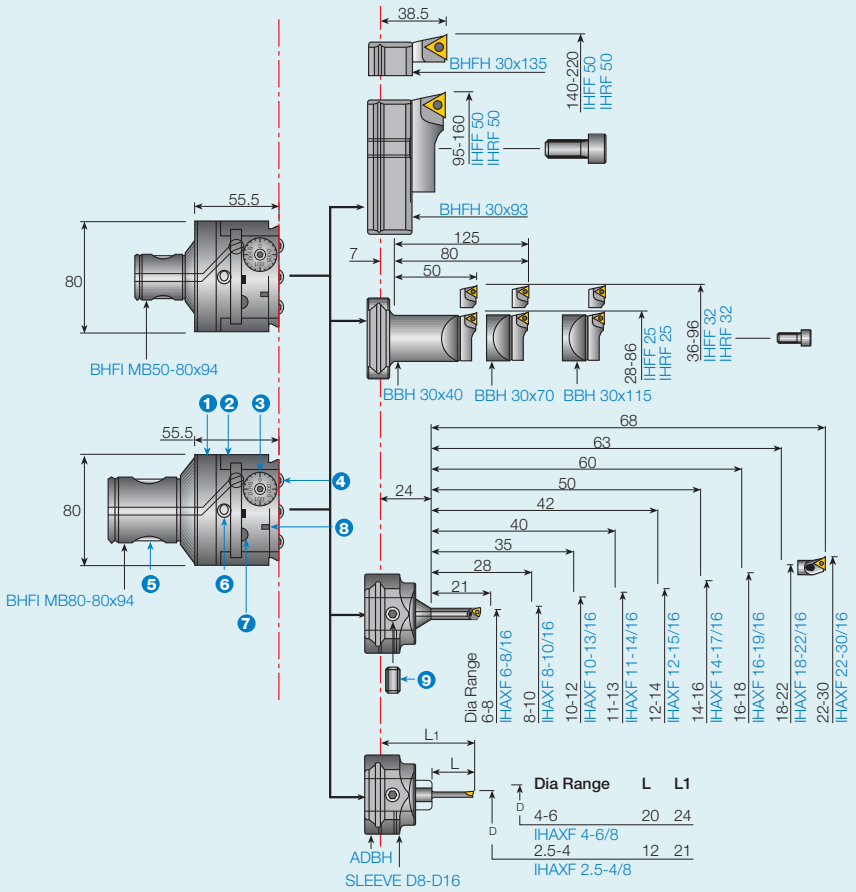


1. Corpo
2. Slitta Utensile
3. Regolatore diametro
4. Vite bloccaggio testina
5. Perno ad espandere
6. Vite Bloccaggio Slitta
7. Refrigerante
8. Ugello oliatura
9. Vite bloccaggio testina

Gamma Bareni di finitura: Regolazione diretta del diametro 2µm

BHF MB50-80x94
BHF MB80-80x94
Gamma Diametro: 2.5-220

2µm

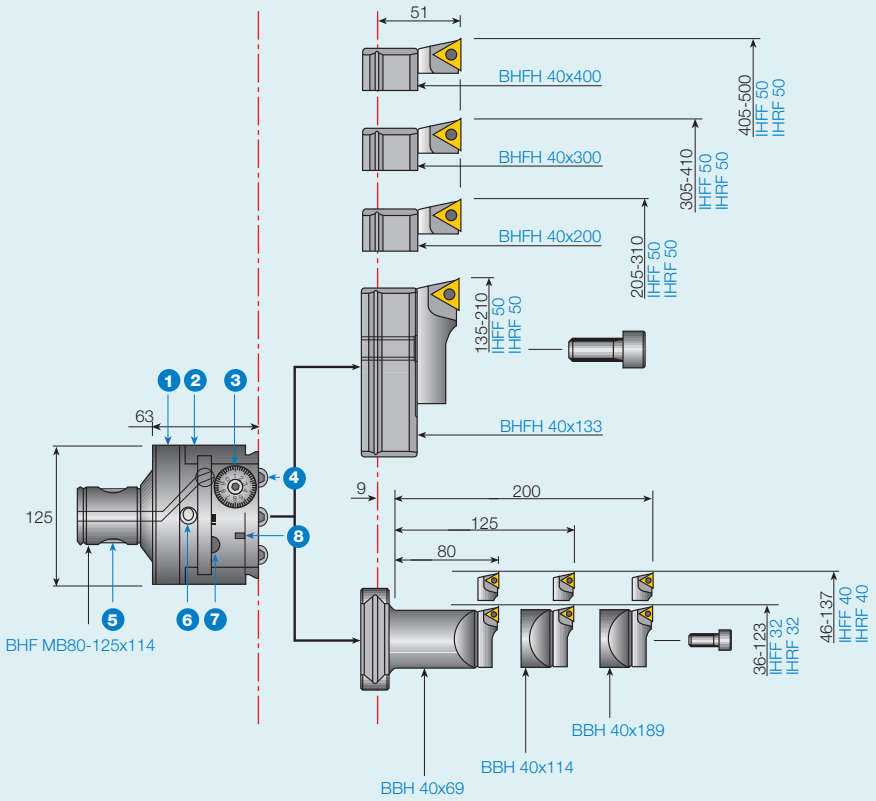


1. Corpo
2. Slitta Utensile
3. Regolatore diametro
4. Vite bloccaggio testina
5. Perno ad espandere
6. Vite Bloccaggio Slitta
7. Refrigerante
8. Ugello oliatura
9. Vite bloccaggio testina

Gamma Bareni di finitura: Regolazione diretta del diametro 2µm

BHF MB80-125x114
Gamma Diametro:36-500

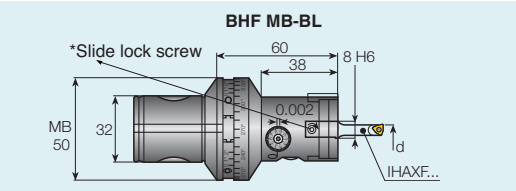
2µm

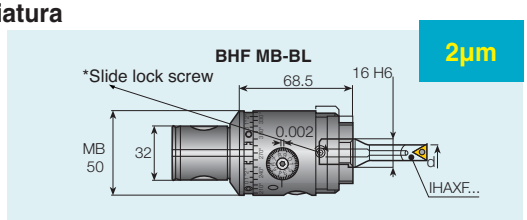


1. Corpo
2. Slitta Utensile
3. Regolatore diametro
4. Vite bloccaggio testina
5. Perno ad espandere
6. Vite Bloccaggio Slitta
7. Refrigerante
8. Ugello oliatura

Testine di Barenatura a finire

Testina di Barenatura a finire con Anello di Bilanciatura





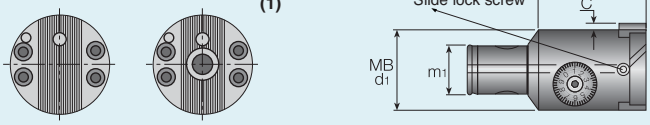
2µm

BHF MB-BL

Descrizione	d Gamma Bareno	Bar	Kg
BHF MB50-32x60 BL	2.5-12	IHAXF...	0.8

BHF MB-BL

Descrizione	d Gamma Bareno	Bar	Kg
BHF MB50-50x68 BL	2.5-20	IHAXF...	1.4



2µm

BHF MB: Testine di Barenatura a finire 18-63mm

Descrizione	Gamma Bareno	MB d_1	m_1	L	C	Porta inserto	Kg
BHF MB16-16X34 RV	18-23	16	10	26.0	1	IH..16	0.05
BHF MB20-20X40 RV	22-29	20	13	32.5	2	IH..20	0.1
BHF MB25-25X50	28-38	25	16	40.0	2	IH..25	0.2
BHF MB32-32X63	36-50	32	20	51.5	3	IH..32	0.35
BHF MB40-40X80	48-63	40	25	66.0	4	IH..40	0.7

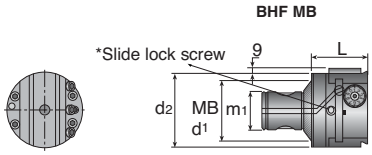
BHF MB: Testine di Barenatura a finire 2.5-84mm

Descrizione	Gamma Bareno	MB d_1	m_1	L	C	Porta inserto	Kg
BHF MB50-50X60	2.5-84	50	32	60	4	IH..50	1.0

• Importante: Allentare la vite* della slitta prima di iniziare la regolazione.

2µm

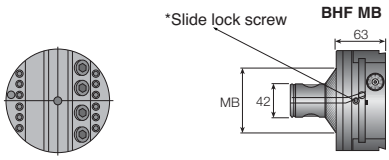
BHF MB: Testina di Barenatura a finire 77-160mm



Descrizione	Gamma Bareno	MB d_1	m_1	d_2	L	Slitta	Kg
BHF MB50-63X87	77-100	50	32	63	49	BHFH 30X75	1.7
	95-125	50	32	63	49	BHFH 30X93	1.8
BHF MB63-63X87	77-100	63	42	63	49	BHFH 30X75	2.0
	95-125	63	42	63	49	BHFH 30X93	2.1
BHF MB50-80X94	95-140	50	32	80	55.5	BHFH 30X93	2.6
	140-160	50	32	80	55.5	BHFH 30X135	2.8
BHF MB80-80X94	95-140	80	42	80	55.5	BHFH 30X93	3.1
	140-160	80	42	80	55.5	BHFH 30X135	3.3

2µm

BHF MB: Testina di Barenatura a finire 135-500mm



Descrizione	Gamma Bareno	MB	Slitta	Kg
BHF MB80-125X114	135-210	80	BHFH 40X133	7.2
	205-310	80	BHFH 40X200	8.1
	305-410	80	BHFH 40X300	9.2
	405-500	80	BHFH 40X400	10.3

• Importante: Allentare la vite* della slitta prima di iniziare la regolazione.

Ricambi H43-H45
Slitta H30
Guida H46-H52
Utensili H30

Utensili per Bareni a finire

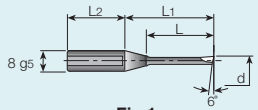


Fig.1

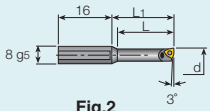
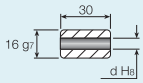


Fig.2

Metallo duro integrale

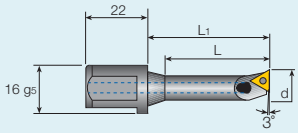
IHAXF: Utensili 8 mm per Bareni a finire 2.5-12mm

Descrizione	d Gamma Bareno	L	L1	L2	Vite	Chiave	Inserto	Fig
IHAXF 2.5-4/8	2.5-4	12.5	21	22	—	—	Solid	1
IHAXF 4-6/8	4-6	20.0	24	24	—	—	Solid	1
IHAXF 6-8/8	6-8	21.0	21	—	SR 14-299	T-6/5	WCGT 0201	2
IHAXF 8-10/8	8-10	—	28	—	SR 14-299	T-6/5	WCGT 0201	2
IHAXF 10-12/8	10-12	—	36	—	SR 14-299	T-6/5	TPGX 0902	2



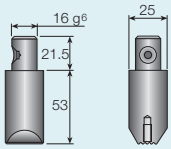
BUSSOLA : Riduzioni per testine di Barenatura a finire

Descrizione	d
SLEEVE D8-D16	8



IHAXF: Utensili 16 mm per Bareni a finire 6-30mm

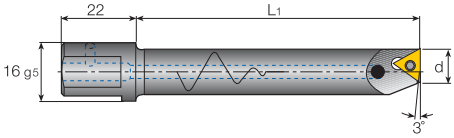
Descrizione	d Gamma Bareno	L	L1	Vite	Chiave	Inserto
IHAXF 6-8/16	6-8	21.0	29	SR 14-299	T-6/5	WCGT 0201
IHAXF 8-10/16	8-10	28.0	36	SR 14-299	T-6/5	WCGT 0201
IHAXF 10-12/16	10-12	35.0	43	SO 25061I	T-8/5	TPGX 0902
IHAXF 11-13/16	11-13	40.0	48	SO 25061I	T-8/5	TPGX 0902
IHAXF 12-14/16	12-14	42.0	48	SO 25061I	T-8/5	TPGX 0902
IHAXF 14-16/16	14-16	50.0	52	SO 25061I	T-8/5	TPGX 0902
IHAXF 16-18/16	16-18	50.0	58	SO 25061I	T-8/5	TPGX 0902
IHAXF 18-22/16	18-22	60.0	63	SO 25061I	T-8/5	TPGX 0902
IHAXF 22-30/16	22-30	60.0	68	SO 25061I	T-8/5	TPGX 0902



BBH: Prolunga per BHF 50x50x63

Descrizione	Kg
BBH D16X53	0.3

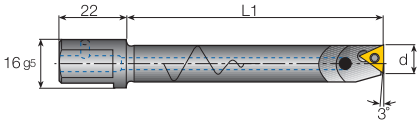
IHAXF-AVI: Utensili antivibranti per Bareni a finire – Metallo pesante



Descrizione	d Gamma Bareno	L1	Inserto	Vite	Chiave
IHAXF 6-9-AVI	6-9	36	WCGT 0201..	SR 14-299	T-6/5
IHAXF 8-10-AVI	8-10	48	WCGT 0201..	SR 14-299	T-6/5
IHAXF 10-12-AVI	10-12	60	TPGX 0902..	SO 25061I	T-8/5
IHAXF 12-14-AVI	12-14	72	TPGX 0902..	SO 25061I	T-8/5
IHAXF 14-16-AVI	14-16	84	TPGX 0902..	SO 25061I	T-8/5
IHAXF 16-18-AVI	16-18	96	TPGX 0902..	SO 25061I	T-8/5

• Note: Non consigliato per le testine di finitura con anello di bilanciatura BHF-BL.

IHAXF-E: Utensili antivibranti per Bareni a finire - metallo duro



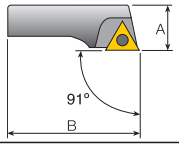
Descrizione	d Gamma Bareno	L1	Inserto	Vite	Chiave
IHAXF 6-8-E	6-8	45	WCGT 0201..	SR 14-299	T-6/5
IHAXF 8-10-E	8-10	60	WCGT 0201..	SR 14-299	T-6/5
IHAXF 10-12-E	10-12	75	TPGX 0902..	SO 25061I	T-8/5
IHAXF 12-14-E	12-14	90	TPGX 0902..	SO 25061I	T-8/5
IHAXF 14-16-E	14-16	105	TPGX 0902..	SO 25061I	T-8/5
IHAXF 16-18-E	16-18	120	TPGX 0902..	SO 25061I	T-8/5

• Note: Non consigliato per le testine di finitura con anello di bilanciatura BHF-BL.

Inserto H40-H42
Guida H46-H52

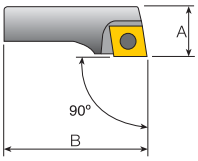
Bareni a finire - cartucce e slitte

IHFF



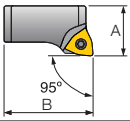
Descrizione	A	B	Vite Inserto	Chiave Torx	Inserto
IHFF 25	10.0	26.5	SO 25061I	T8/5	TPGX 0902...
IHFF 32	11.5	34.5	SO 25061I	T8/5	TPGX 0902...
IHFF 40	14.0	44.0	SO 30081I	T8/5	TPGX 1103...
IHFF 50	19.0	52.0	SO 30081I	T8/5	TPGX 1103...

IHRF

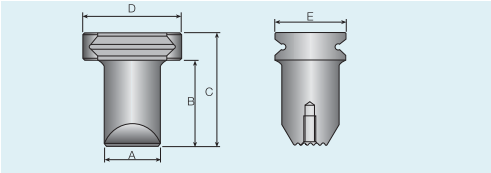


Descrizione	A	B	Vite Inserto	Chiave Torx	Inserto
IHFF 25	10.0	26.5	SO 25061I	T8/5	TPGX 0902...
IHRF 20	8.5	21.0	SR 14-548	T-7/5	CCGT 0602..
IHRF 25	10.0	26.5	SR 14-548	T-7/5	CCGT 0602..
IHRF 32	11.5	34.5	TS 40097I	T-7/5	CCGT 0602..
IHRF 40	14.0	44.0	TS 40097I	T-15/5	CCGT 09T3...
IHRF 50	19.0	52.0	TS 40097I	T-15/5	CCGT 09T3...

IHWF

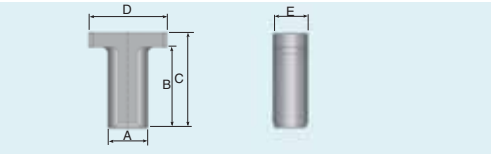


Descrizione	Gamma Bareno	A	B	Vite Inserto	Chiave Torx	Inserto
IHWF 14E	14.5-18	8.0	14.0	SR 14-299	T6/5	WCGT 0201...



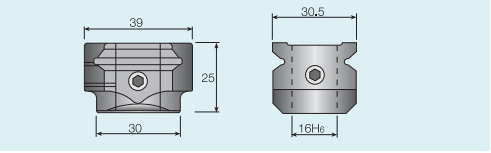
BBH: Slitta prolungata per Bareni a finire

Descrizione	A	B	C	D	E	Kg
BBH 30X40	25	40	52.5	43	30.5	0.3
BBH 30X70	25	70	82.5	43	30.5	0.4
BBH 30X115	27	115	127.5	43	30.5	0.7
BBH 40X69	32	69	86	56	40	0.7
BBH 40X114	32	114	131	56	40	1.0
BBH 40X189	38	189	206	56	40	2.0



BBH: Slitta prolungata per Bareni a finire BHE

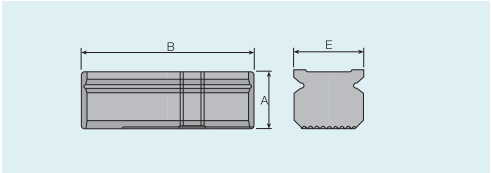
Descrizione	A	B	C	D	E	Kg
BBH 63X78	32	66	78	63	28	0.7



ADBH: Bussola utensili per testine di finitura

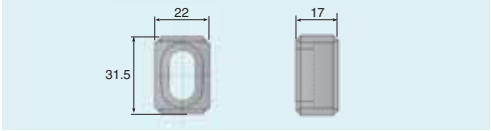
Descrizione	Kg
ADBH 30XD16	0.2

Inserto
H40-H42



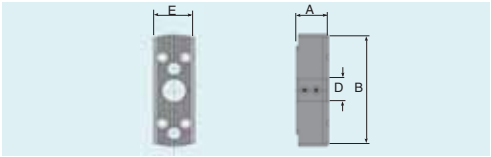
BHFH: Slitta per Bareni a finire

Descrizione	A	B	E	Kg
BHFH 30X75	25	75	30.5	0.4
BHFH 30X93	25	93	30.5	0.5
BHFH 30X135	25	135	30.5	0.7
BHFH 40X133	40	133	40	1.5
BHFH 40X200	40	200	40	2.4
BHFH 40X300	40	300	40	3.5
BHFH 40X400	40	400	40	4.6



CW32: Contrappeso per bilanciatura

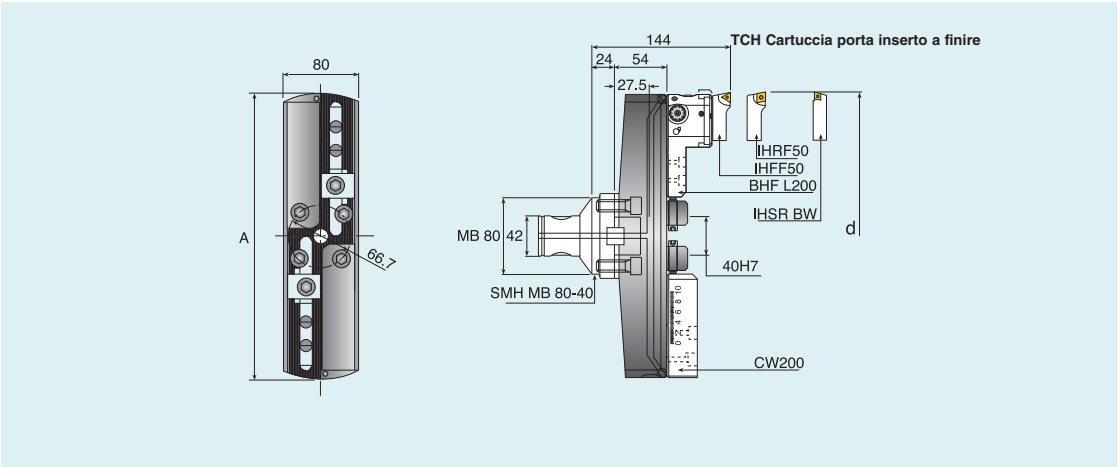
Descrizione	Kg
CW32	0.5



BHEH: Slitta per Bareni a finire BHE

Descrizione	A	B	D	E	Kg
BHEH 24X75	14.5	75	-	24	0.2
BHEH 28X80	22.5	80	16	28	03
BHEH 28X108	22.5	108	-	28	0.5
BHEH 28X148	22.5	148	-	28	0.6

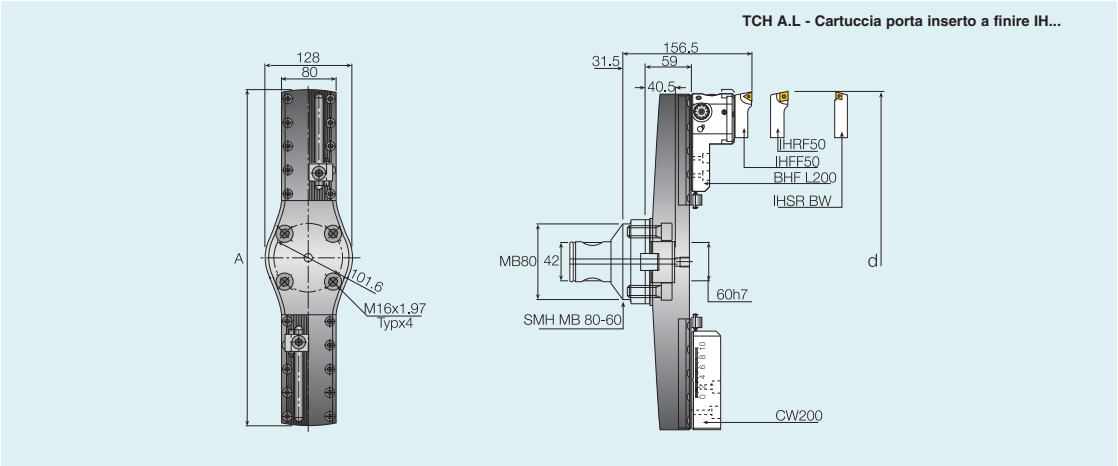
Testina di Barenatura a finire



TCH: Testine di Barenatura a finire 200-500mm con innesto MB

Descrizione	d Gamma Bareno	A	Kg
TCH 200	200-300	198	2.6
TCH 300	300-400	298	3.5
TCH 400	400-500	398	4.1

- La posizione "O" del contrappeso di bilanciatura corrisponde al D=200 mm.
- Per ogni 10 mm di cambio del diametro di barenatura, muovere il contrappeso di bilanciatura di 1 posizione.
- Corpo in alluminio con sedi seghettate in acciaio.



TCH A.L: Testine di Barenatura a finire in alluminio 500-800mm con innesto MB

Descrizione	d Gamma Bareno	A	Kg
TCH A.L 500	500-600	494	7.5
TCH A.L 600	600-700	594	9.0
TCH A.L 700	700-800	694	10.5

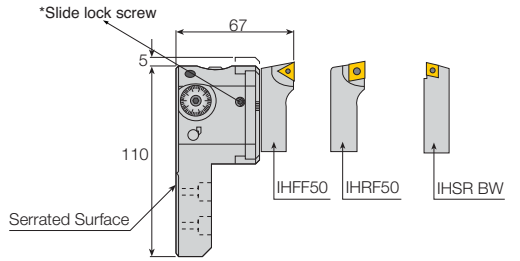
- La posizione "O" del contrappeso di bilanciatura corrisponde al D=200 mm.
- Per ogni 10 mm di cambio del diametro di barenatura, muovere il contrappeso di bilanciatura di 1 posizione.
- Corpo in alluminio con sedi seghettate in acciaio.

Ricambi
H43-H45

Utensili
H30

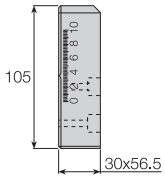
Bareni a finire -Cartucce e Utensili

BHF L200: (200-800) Testine di Barenatura a finire



Descrizione	Gamma Bareno	Kg
BHF L200	200-800	1.3

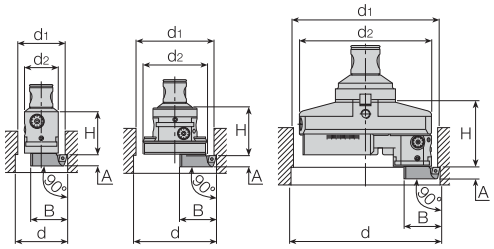
CW200: Contrappeso di bilanciatura TCH



Descrizione	Kg
CW200	1.3

- Importante: Allentare la vite della slitta * prima di iniziare la regolazione.

IHSR-BW: Cartucce per BHF e TCH per retro barenature con testine a finire



BHF16-50
IHRF...BW

BHF63-125
BHFI
IHRF...BW

TCH200-800
BHF L200
IHRF...BW

Descrizione	Testine di barenatura	d Gamma Bareni	d2	H	A	B
IHRF 20-26 BW	BHF MB16-16X34	20-26	16	27.5	8.0	18.0
IHRF 24.5-33 BW	BHF MB20-20X40	24.5-33	20	33.5	8.5	22.5
IHRF 31.5-42 BW	BHF MB25-25X50	31.5-42	25	41.5	9.5	28.5
IHRF 39-55 BW	BHF MB32-32X63	39-55	32	53.0	11.0	35.5
IHRF 51-68 BW	BHF40-40	51-65	40	68.0	13.5	46.0
IHRF 56-802 BW	BHF50-50	56-86	50	62.0	17.5	53.0
	BHF63+BHFH30X75	82-120	75	70.2	17.5	53.0
	BHF80+BHFH30X93	100-142	93	79.5	17.5	53.0
	BHF125+BHFH40X133	140-240	135	98.0	17.5	53.0
	TCH200+BHF L200	202-302	198	103.0	17.5	53.0
	TCH300+BHF L200	302-402	298	103.0	17.5	53.0
	TCH400+BHF L200	402-502	398	103.0	17.5	53.0
	TCH500+BHF L200	502-602	494	108.0	17.5	53.0
	TCH600+BHF L200	602-702	594	108.0	17.5	53.0
	TCH700+BHF L200	702-802	694	108.0	17.5	53.0

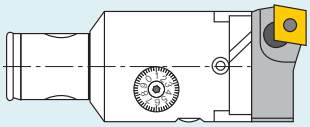
- d_2= Dimensioni del bareno in uso.
- d_1= (dia. min. foro)= $(d+d_2+1):2$

Ricambi

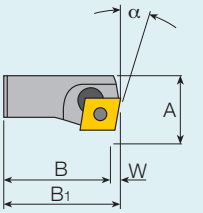
Descrizione	Vite di bloccaggio	Chiave Torx	Inserto
IHRF 20-25 BW	SR 14-548	T7/5	CCGT 0602..
IHRF 24.5-32 BW	SR 14-548	T7/5	CCGT 0602..
IHRF 31.5-40 BW	SR 14-548	T7/5	CCGT 0602..
IHRF 39-52 BW	SR 14-548	T7/5	CCGT 0602..
IHRF 51-65 BW	TS 40097I	T15/5	CCGT 09T3..
IHRF 56-802 BW	TS 40097I	T15/5	CCGT 09T3..

Inserto H40-H42
Guida H46-H52
Utensile H30

Bareni a finire - Cartucce



MB16-MB80



Porta inserto IHRF...CH

IHRF-CH: Cartucce per smussi per testine di barenatura BHF

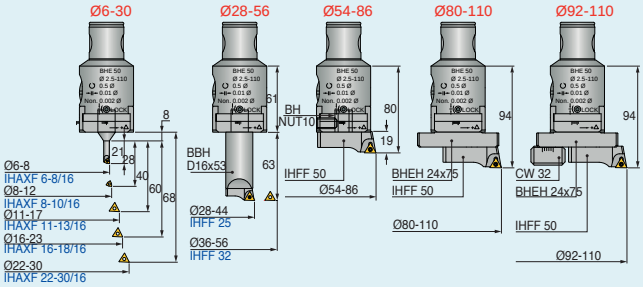
Descrizione	Gamma Bareno	°	B	B1	A	W	Vite di bloccaggio	Chiave Torx	Inserto
IHRF 25 CH15	28-38	15°	28.0	29.6	13.0	1.6	SR 14-548	T7/5	CCGT 0602...
IHRF 32 CH15	36-50	15°	33.1	34.7	13.0	1.6	SR 14-548	T7/5	CCGT 0602...
IHRF 40 CH15	48-63	15°	44.9	47.4	17.5	2.5	TS 40097I	T15/5	CCGT 09T3...
IHRF 50 CH15	54-160	15°	52.9	55.4	17.5	2.5	TS 40097I	T15/5	CCGT 09T3...
IHRF 25 CH30	28-38	30°	25.4	29.6	11.0	3.2	SR 14-548	T7/5	CCGT 0602...
IHRF 32 CH30	36-50	30°	31.5	34.7	11.0	3.2	SR 14-548	T7/5	CCGT 0602...
IHRF 40 CH30	48-63	30°	42.6	47.4	15.4	4.8	TS 40097I	T15/5	CCGT 09T3...
IHRF 50 CH30	54-160	30°	50.6	55.4	15.4	4.8	TS 40097I	T15/5	CCGT 09T3...
IHRF 25 CH45	28-38	45°	25.1	29.6	11.5	4.5	SR 14-548	T7/5	CCGT 0602...
IHRF 32 CH45	36-50	45°	30.2	34.7	11.5	4.5	SR 14-548	T7/5	CCGT 0602...
IHRF 40 CH45	48-63	45°	40.6	47.4	16.0	6.8	TS 40097I	T15/5	CCGT 09T3...
IHRF 50 CH45	54-160	45°	48.6	55.4	16.0	6.8	TS 40097I	T15/5	CCGT 09T3..

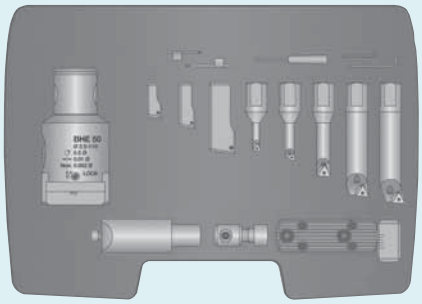
Inserto
⇨H40-42

Kits

Kit Barenatura BHE MB50-50 (ø6-110mm) con testina di barenatura a finire

10µm
2µm





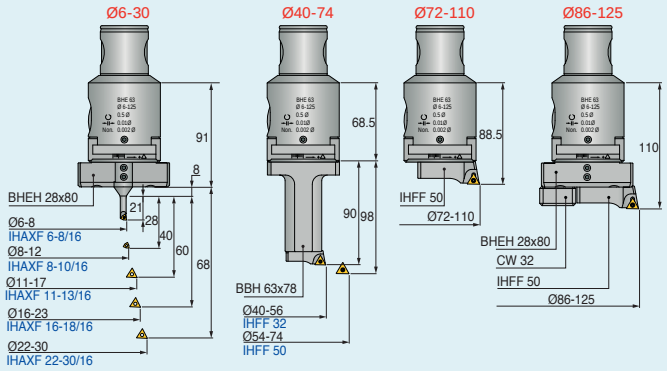
1 BHE MB50-50x80
1 IHFF 25
1 IHFF 32
1 IHFF 50
1 IHAXF 6-8/16
1 IHAXF 8-10/16
1 IHAXF 11-13/16
1 IHAXF 16-18/16
1 IHAXF 22-30/16
1 BBH D16x53
1 BHEH 24x75
1 BH NUT 10
1 CW 32

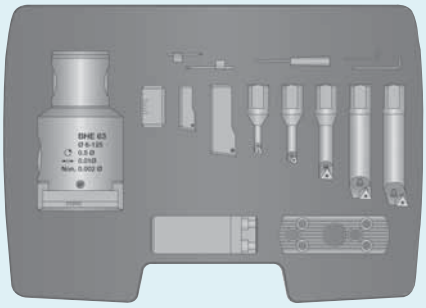
Descrizione	MB d1	Gamma Bareno
KIT BHE MB50-50X80	50	6-110

- Regolazione diretta del diametro 10µm e 2µm con la Scala del Nonio

Kit Barenatura BHE MB63-63 (ø6-125mm) con testina di barenatura a finire

10µm
2µm



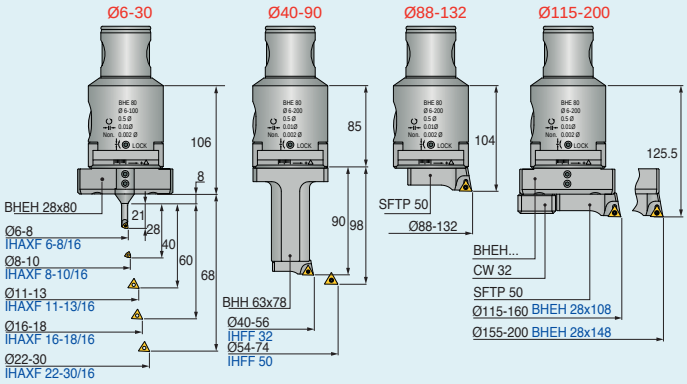


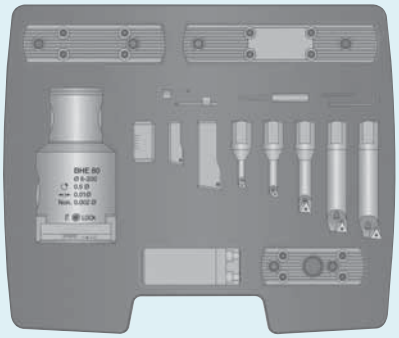
1 BHE MB63-63x89
1 IHFF 32
1 IHFF 50
1 IHFF 6-8/16
1 IHAXF 8-10/16
1 IHAXF 11-13/16
1 IHAXF 16-18/16
1 IHAXF 22-30/16
1 BBH 63x78
1 BHEH 28x80
1 BH WASHER IH..50
1 CW 32

Descrizione	MB d1	Gamma Bareno
KIT BHE MB63-63X89	63	6-125

Kit Barenatura BHE MB80-80 (ø6-200 mm) con testina di barenatura a finire

10µm
2µm





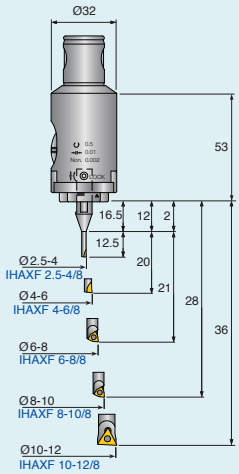
1 BHE MB80-80x104
1 IHFF 32
1 IHFF 50
1 IHFF 6-8/16
1 IHAXF 8-10/16
1 IHAXF 11-13/16
1 IHAXF 16-18/16
1 IHAXF 22-30/16
1 BBH 63x78
1 BHEH 28x80
1 BHEH 28x108
1 BHEH 28x148
1 BH WASHER IH..50
1 CW 32

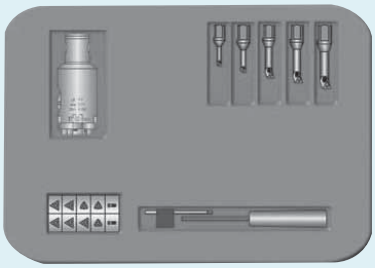
Descrizione	MB d1	Gamma Bareno
KIT BHE MB80-80X104	80	6-200

G2.5
12,000 RPM

Kit Barenatura BHE MB32-32x53 H (ø2.5-12mm) con testina di barenatura a finire

10µm
2µm





Utensili per barenatura:
1 BHF MB32-32X53 H
1 IHAXF 2.5-4/8
1 IHAXF 4-6/8
1 IHAXF 6-8/8
1 IHAXF 8-10/8
1 IHAXF 10-12/8

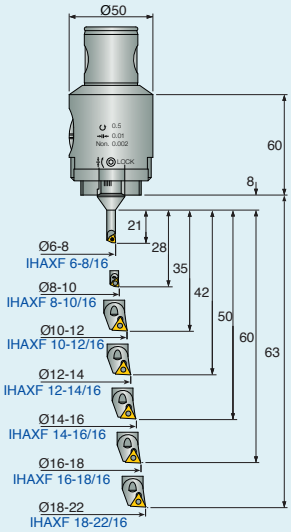
Inserti:
5 TPGX 090202L
2 WCGT 020102L

Descrizione	MB d1	Gamma Bareno
KIT BHE MB32-32X53 H	32	2.5-12

G2.5
12,000 RPM

Kit Barenatura BHE MB50-50x60 H (ø6-22mm) con testina di barenatura a finire

10µm
2µm



Utensili di barenatura:
1 BHE MB50-50X60 H
1 IHAXF 6-8/16
1 IHAXF 8-10/16
1 IHAXF 10-12/16
1 IHAXF 12-14/16
1 IHAXF 14-16/16
1 IHAXF 16-18/16
1 IHAXF 18-22/16

Inserti:
5 TPGX 090202L
2 WCGT 020102L

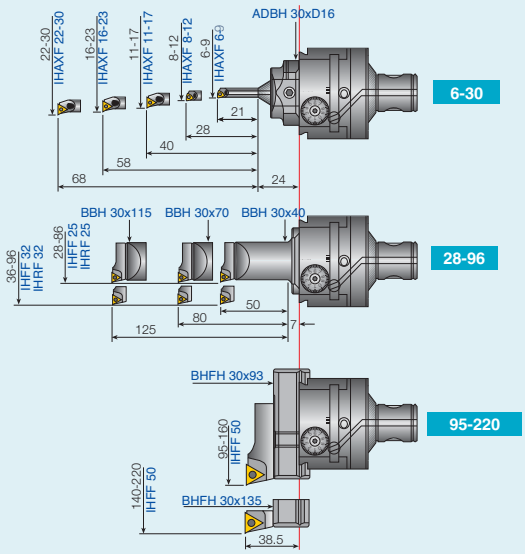
Descrizione	MB d1	Gamma Bareno
KIT BHE MB50-50X60 H	50	6-22

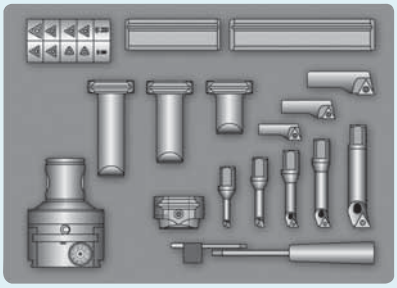
- Regolazione diretta del diametro 10µm e 2µm con la scala del nonio

Kits

Kit BHF MB50-80 / Kit BHF MB80-80
Gamma Diametro 6-220mm

2µm



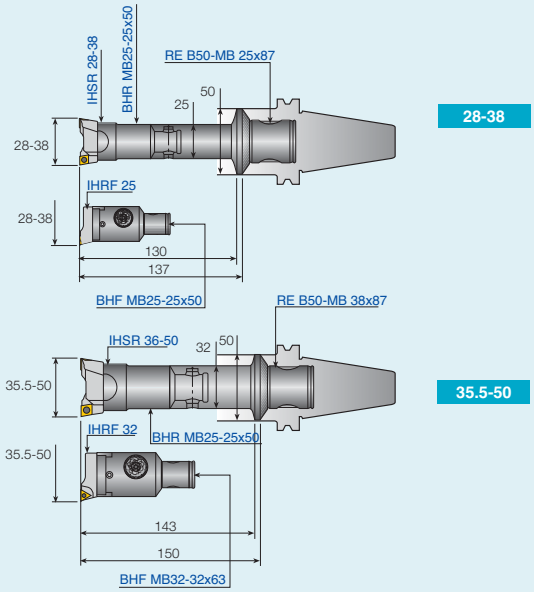


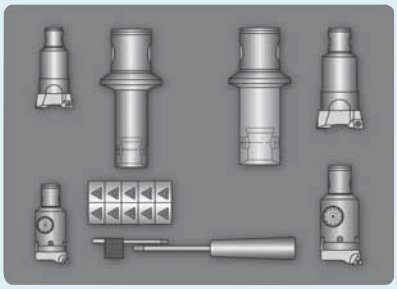
1 BHF MB..-80x94
1 IHAXF 6-8/16
1 IHAXF 8-10/16
1 IHAXF 11-13/16
1 IHAXF 16-18/16
1 IHAXF 22-30/16
1 ADBH 30xD16
1 BBH 30x40
1 BBH 30x70
1 BBH 30x115
1 BHFH 30x93
1 BHFH 30x135
1 IHFF 25
1 IHFF 32
1 IHFF 50
5 TPGX 090202L
1 TPGX 110302L
2 WCGT 020102L
T-8/5
T-6/5

Descrizione	MB d_1	Gamma Diametro
KIT BHF MB50-80	50	6-220
KIT BHF MB80-80	80	6-220

Kit STAMPI MB25-32, Gamma Diametro 28-50mm
Kit composto di testine a finire e sgrossare

2µm





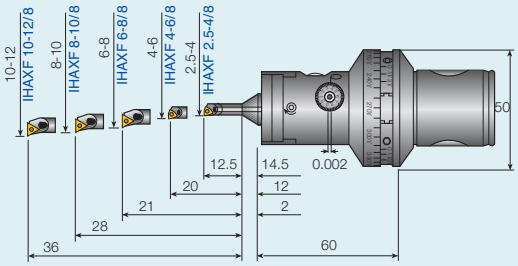
1 RE MB50-MB25X87
1 RE MB50-MB32X87
1 BHF MB25-25X50
1 BHF MB32-32X63
1 IHFF 25
1 IHFF 32
1 BHR MB25-25X50
1 BHR MB32-32X63
2 IHSR 28-38
2 IHSR 36-50
10 INSERTS
TPGX 090202L
T-8/5

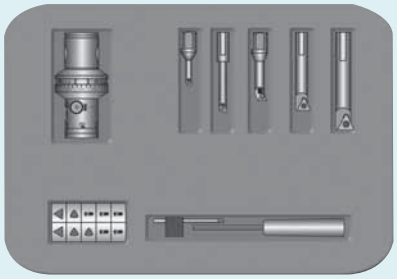
Descrizione	MB d_1	Gamma Diametro
KIT MOLD BH F/R 28-50	25, 32	28-50

G2.5
20,000 RPM

Kit Barenatura Gamma Diametro 2.5-12mm con testina a finire con anello di bilanciatura BHF

2µm



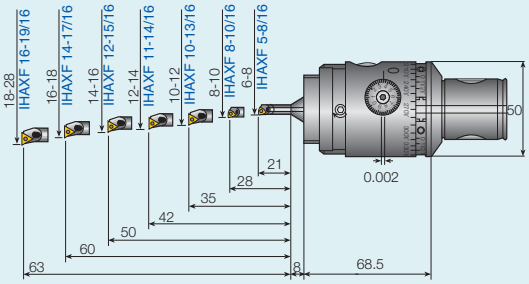


1 BHF MB50-32X60 BL
1 IHAXF 2.5-4/8
1 IHAXF 4-6/8
1 IHAXF 6-8/8
1 IHAXF 8-10/8
1 IHAXF 10-12/8
5 TPGX 090202L
2 WCGT 020102L

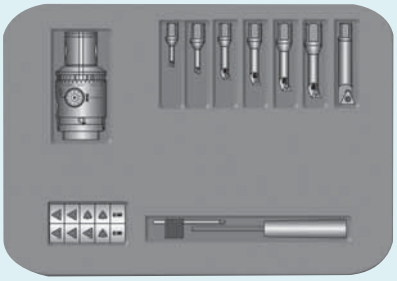
Descrizione	MB d1	Gamma Diametro
KIT BL BHF MB50-32	50	2.5-12

Kit Barenatura Gamma Diametro 6-20mm con testina a finire con anello di bilanciatura BHF BL

2µm



(1) Con BHF BL il max. diametro di bilanciatura è 20 mm.



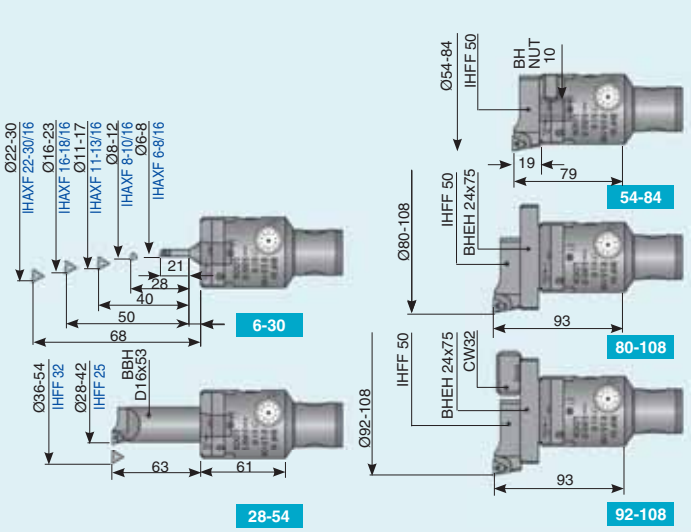
1 BHF MB50-50X68 BL
1 IHAXF 6-8/16
1 IHAXF 8-10/16
1 IHAXF 10-12/16
1 IHAXF 12-14/16
1 IHAXF 14-16/16
1 IHAXF 16-18/16
1 IHAXF 18-22/16
5 TPGX 090202L
2 WCGT 020102L

Descrizione	MB d1	Gamma Diametro
KIT BHF MB50-50 BL	50	6-20

Kits

Kit BHF MB50-50
Gamma Diametro 6-108mm

2µm



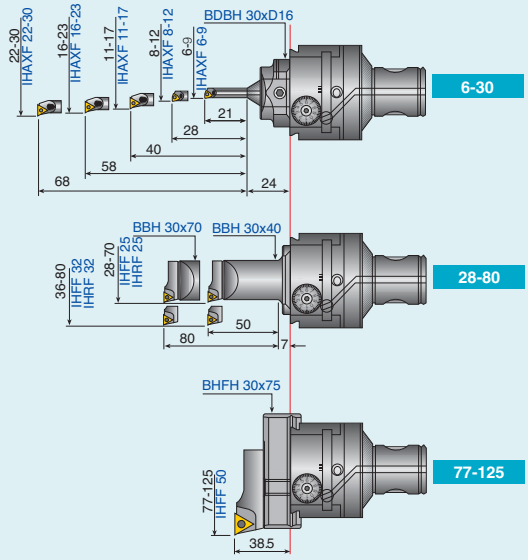
1 BHF MB50-50x60
1 IHFF 25
1 IHFF 32
1 IHFF 50
1 IHAXF 6-8/16
1 IHAXF 8-10/16
1 IHAXF 11-13/16
1 IHAXF 16-18/16
1 IHAXF 22-30/16
1 BBH D 16x53
1 BHEH 24x75
1 BH NUT 10
1 CW 32

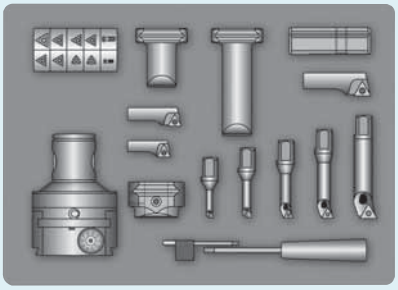
5 TPGX 090202L
1 TPGX 110302L
2 WCGT 020102L

Descrizione	MB d1	Gamma Diametro
KIT BHF MB50-50 6-108	50	6-108

Kit BHF MB50-63 / Kit BHF MB63-63
Gamma Diametro 6-125mm

2µm





1 BHF MB...-63x87
1 IHAXF 6-8/16
1 IHAXF 8-10/16
1 IHAXF 11-13/16
1 IHAXF 16-18/16
1 IHAXF 22-30/16
1 ADBH 30xD16
1 BBH 30x40
1 BBH 30x70

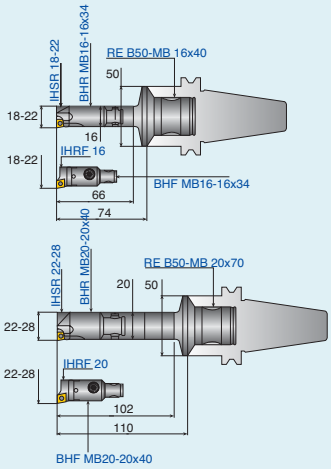
1 BHFH 30x75
1 IHFF 25
1 IHFF 32
1 IHFF 50
5 TPGX 090202L
1 TPGX 110302L
2 WCGT 020102L
T-8/5
T-6/5

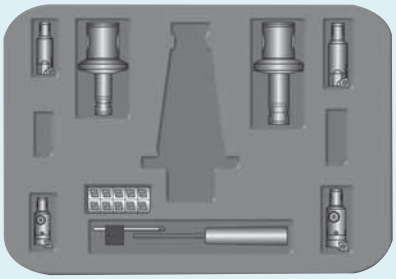
Descrizione	MB d1	Gamma Diametro
KIT BHF MB50-63	50	6-125
KIT BHF MB63-63	63	6-125

Kits

Kit STAMPI MB 16, 20, Gamma Diametro 18-28mm
Kit composto da testine a finire e sgrossare

2µm



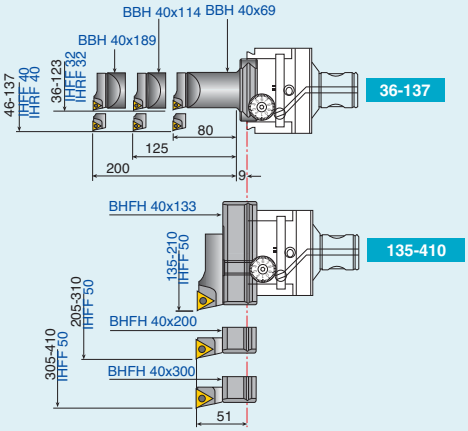


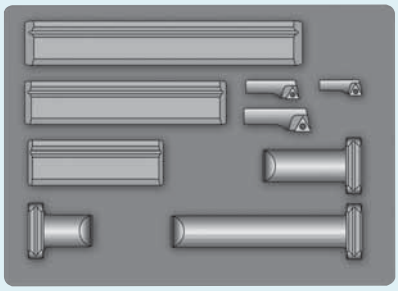
1 RE MB50-MB16x40
1 RE MB50-MB20x70
1 BHF MB16-16x34
1 BHF MB20-20x40
1 IHRF 16
1 IHRF 20
1 BHR MB16-16x34
1 BHR MB20-20x40
2 IHSR 18-22
2 IHSR 22-28
10 CCGT 060202L
T-8/5
T-6/5

Descrizione	MB d1	Gamma Diametro
KIT MOLD BH F/R 18-28	16,20	18-28

Kit BHFH MB80-125 Porta utensili per BHF MB80-125x114, Gamma Diametro 36-410mm

2µm





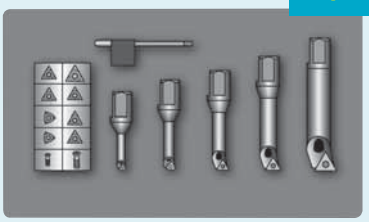
1 BBH 40x69
1 BBH 40x114
1 BBH 40x189
1 BHFH 40x133
1 BHFH 40x200
1 BHFH 40x300
1 IHFF 25
1 IHFF 40
1 IHFF 50

Descrizione	MB d1	Gamma Diametro
KIT BHFH MB80-125	80	36-410

Kit IHAXF 6-30, Gamma Diametro 6-30 mm

2µm

1 IHAXF 6-8/16
1 IHAXF 8-10/16
1 IHAXF 11-13/16
1 IHAXF 16-18/16
1 IHAXF 22-30/16
5 TPGX 090202L
3 WCGT 020102L
T-8/5
T-6/5

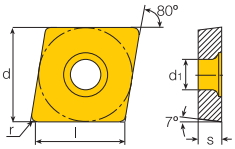


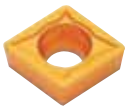
Descrizione	Gamma Diametro
KIT IHAXF 6-30	6-30

Inserti Barenatura

Inserti rombici a 80° con spoglia positiva a 7°

CCMT-MT Rompitruciolo

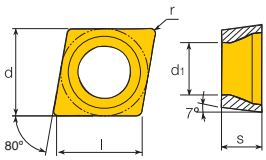




Tolleranze
d = 6.35, 9.52 ± 0.05
d = 12.7 ± 0.08
s ± 0.13

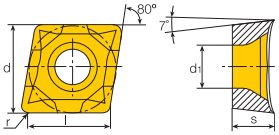
Descrizione	Dimensioni (mm)					Grado												
	l	d	s	r	d1	K10	PV3010	CT3000	TT7005	TT7015	TT8115	TT8125	TT8135	TT9225	TT9235	TT5100	TT5080	TT8020
CCMT 060204 MT	6.0	6.35	2.38	0.4	2.8	●	●	●	●	●	●	●		●	●	●	●	●
CCMT 060208 MT	5.6	6.35	2.38	0.8	2.8			●	●	●	●					●		
CCMT 09T304 MT	9.2	9.52	3.97	0.4	4.4		●	●	●	●	●	●	●	●	●	●	●	●
CCMT 09T308 MT	8.8	9.52	3.97	0.8	4.4			●	●	●	●	●	●	●	●	●	●	●
CCMT 120404 MT	12.4	12.7	4.76	0.4	5.5			●	●	●	●					●		●
CCMT 120408 MT	12.0	12.7	4.76	0.8	5.5			●	●	●	●	●	●	●	●	●	●	●
CCMT 120412 MT	11.6	12.7	4.76	1.2	5.5						●	●						

CCGT-SA Rompitruciolo



Descrizione	Dimensioni (mm)					Grado	
	l	d	s	r	d1	TT5080	TT9020
CCGT 060202 SA	6.2	6.35	2.38	0.2	2.8	●	●
CCGT 060204 SA	6.0	6.35	2.38	0.4	2.8	●	●
CCGT 09T302 SA	9.4	9.52	3.97	0.2	4.4	●	●
CCGT 09T304 SA	9.2	9.52	3.97	0.4	4.4	●	●

CCGT-FL: Rompitruciolo per alluminio



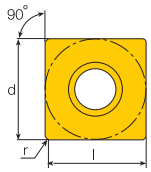
Descrizione	Dimensioni (mm)					Grado
	l	d	s	r	d1	K10
CCGT 060202 FL	6.2	6.35	2.38	0.2	2.8	●
CCGT 060204 FL	6.0	6.35	2.38	0.4	2.8	●
CCGT 09T302 FL	9.4	9.52	3.97	0.2	4.4	●
CCGT 09T304 FL	9.2	9.52	3.97	0.4	4.4	●
CCGT 09T308 FL	8.8	9.52	3.97	0.8	4.4	●
CCGT 120402 FL	12.6	12.7	4.76	0.2	5.5	●
CCGT 120404 FL	12.4	12.7	4.76	0.4	5.5	●
CCGT 120408 FL	12.0	12.7	4.76	0.8	5.5	●

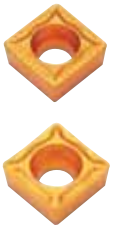
Guida
H46-H52

Inserti di Barenatura

Inserti rombici 80° con spoglia positiva a 7°

SCMT MT, FG Rompitruciolo

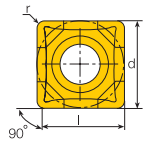


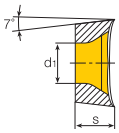


Tolleranze
d = 9.52 ± 0.05
d = 12.7 ± 0.08
s ± 0.13

Descrizione	Dimensioni (mm)					Grado										
	l	d	s	r	d_1	CT3000	TT7005	TT7015	TT8115	TT8125	TT8135	TT9225	TT9235	TT5100	TT5080	TT8020
SCMT 09T308 FG	8.7	9.52	3.97	0.8	4.4					●		●		●		●
SCMT 09T304 MT	9.1	9.52	3.97	0.4	4.4	●	●	●	●	●		●		●		●
SCMT 09T308 MT	8.7	9.52	3.97	0.8	4.4	●	●	●	●	●	●	●	●	●	●	●
SCMT 120404 MT	12.3	12.7	4.76	0.4	5.5	●	●		●	●		●		●		
SCMT 120408 MT	11.9	12.7	4.76	0.8	5.5	●	●	●	●	●		●	●	●	●	●
SCMT 120412 MT	11.5	12.7	4.76	1.2	5.5				●		●					

SCGT-FL: Rompitruciolo per alluminio

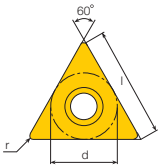


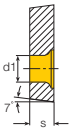


Descrizione	Dimensioni (mm)					Grado
	l	d	s	r	d_1	K10
SCGT 09T308 FL	8.7	9.53	3.97	0.8	4.4	●
SCGT 120402 FL	12.5	12.7	4.76	0.2	5.5	●
SCGT 120404 FL	12.3	12.7	4.76	0.4	5.5	●
SCGT 120408 FL	11.9	12.7	4.76	0.8	5.5	●

Inserti triangolari con spoglia positiva a 7°

TCMT 22 Rompitruciolo





Tolleranze
d ± 0.08
s ± 0.13

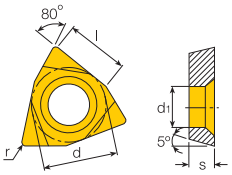
Descrizione	Dimensioni (mm)					Grado
	l	d	s	r	d_1	P30
TCMT 220508-19	22	12.7	5.0	0.8	5.5	●

Guida
H46-H52

Inserti di Barenatura

Inserti trigoni a 80° con spoglia positiva a 7° per testine di finitura

WCGT Rompitruciolo

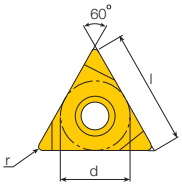


Tolleranze
d ± 0.025
s ± 0.13

Descrizione	Dimensioni (mm)					Gradi
	l	d	s	r	d_1	TT9030
WCGT 020102L	2.18	3.97	1.59	0.2	2.3	●
WCGT 020104L	2.18	3.97	1.59	0.4	2.3	●

Inserti triangolari con spoglia positiva a 11° per testine di finitura

TPGX Rompitruciolo



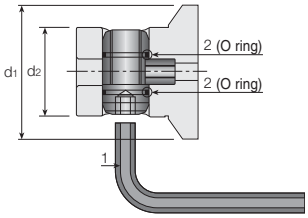
Tolleranze
d ± 0.025
s ± 0.13

Descrizione	Dimensioni (mm)					Gradi	
	l	d	s	r	d_1	CT3000	K10
TPGX 090202L	9.52	5.56	2.38	0.2	2.5	●	
TPGX 090204L	9.52	5.56	2.38	0.4	2.5	●	
TPGX 110302L	11.00	6.35	3.18	0.2	3.5	●	
TPGX 110304L	11.00	6.35	3.18	0.4	3.5	●	●

Guida
H46-H52

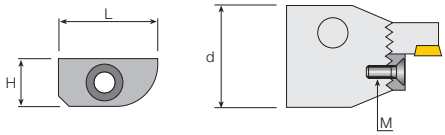
Ricambi

MB Viti di bloccaggio: MB Grano ad espansione



Descrizione	Dimensioni (mm)			
	d_1	d_2	1	2
MB CLAMP 16	16	10	2.5	—
MB CLAMP 20	20	13	3	—
MB CLAMP 25	25	16	3	—
MB CLAMP 32	32	20	4	—
MB CLAMP 40	40	25	5	ORM 0100-10
MB CLAMP 50	50	32	6	ORM 0130-10
MB CLAMP 50	50	32	6	ORM 0140-10
MB CLAMP 63-80	63-80	42	8	OR 2075

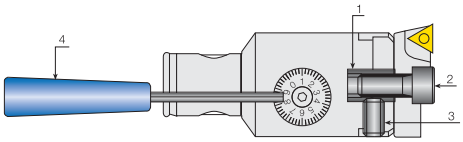
Piastra di protezione: PLT



Descrizione	Dimensioni (mm)			
	d	H	L	M
PLT16	16	7	14	M 3X8
PLT20	20	8.5	17	M 4X10
PLT25	25	10.2	21	M 4X16
PLT32	32	13.9	28	M 5X20
PLT40	40	17.4	35	M 6X25
PLT50	50	21.4	47.5	M 8X25
PLT63	63	26.4	62	M 10X30
PLT80	80	33.9	82.5	M 12X35

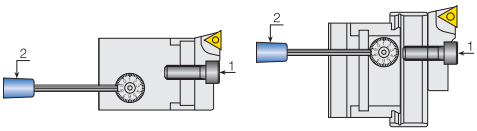
- Proteggere il millerighe quando si usa una cartuccia singola.

Ricambi per BHF MB50



Descrizione	1	2	3	4
BHF MB50-50	BH NUT 10	BH NUT 10 SCREW M10x25	BH TOOL LOCK SR M10x16-50	BH HW 2.5 HANDLE

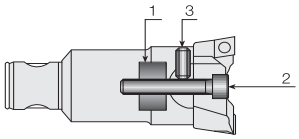
Viti per BHF



Descrizione	1	2
BHF MB16	BH LOCK SCREW M3x6	BH HW 1.5 HANDLE
BHF MB20	BH LOCK SCREW M4x8	BH HW 1.5 HANDLE
BHF MB25	BH LOCK SCREW M5x10	BH HW 2 HANDLE
BHF MB32	BH LOCK SCREW M6x12	BH HW 2 HANDLE
BHF MB40	BH LOCK SCREW M8x14	BH HW 2.5 HANDLE
BHF MB63-80-125	SR M10x25 DIN912	BH HW 3 HANDLE

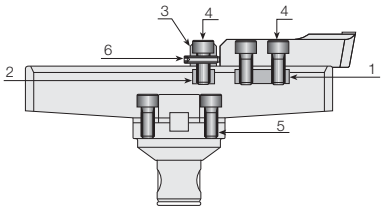
Ricambi

Viti per BHR



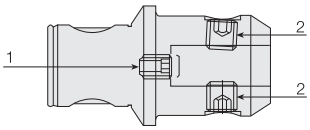
Descrizione	1	2	3
BHR MB16...	BH NUT-BHR MB16	SR M3X14 DIN912	SR M3X4 DIN913
BHR MB20...	BH NUT-BHR MB20	BH M4x15 UNI 5931 12.9	BH M3X5 UNI 5923 12.9
BHR MB25...	BH NUT-BHR MB25	SR M4X20 DIN912	SR M3X8 DIN913
BHR MB32...	BH NUT-BHR MB32	SR M5X25 DIN912	BH M4x12 UNI 5923 12.9
BHR MB40...	BH NUT-BHR MB40	SR M6X30 DIN912	BH M5x14 UNI 5923 12.9
BHR MB50...	BH NUT-BHR MB50	SR M8X35 DIN912	BH M5x12 UNI 5923 12.9
BHR MB63...	BH NUT-BHR MB63	SR M10X40 DIN912	SR M6X16 DIN913
BHR MB80...	BH NUT-BHR MB80	BH M12x45 UNI 5931 12.9	SR M8X25 DIN913

Viti per TCH



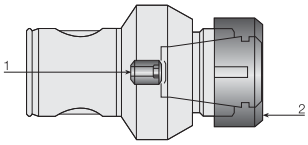
Descrizione	1	2	3
TCH 200-300-400	BH TCH NUT-A	BH TCH NUT-B	BH TCH NUT-C
Descrizione	**4**	**5**	**6**
TCH 200-300-400	SR M12x40 DIN912	SR M12x35 DIN912	BH M8x40 UNI 5925-12.9

Viti per EMH



Descrizione	Vite #1	Vite # 2
EMH MB 50-6	EMH 50-6 SCREW	M6x10 EM SCREW
EMH MB 50-8	EMH 50-8 SCREW	M8x10 EM SCREW
EMH MB 50-10	EMH 50-10 SCREW	M10x12 EM SCREW
EMH MB 50-12	EMH 50-12 SCREW	M12x16 EM SCREW
EMH MB 50-14	EMH 50-14 SCREW	M14x16 EM SCREW
EMH MB 50-16	EMH 50-16 SCREW	M14x16 EM SCREW
EMH MB 50-20	EMH 50-20 SCREW	M16x16 EM SCREW
EMH MB 63-16	EMH 63-16 SCREW	M14x16 EM SCREW
EMH MB 63-20	EMH 63-20 SCREW	M16x16 EM SCREW
EMH MB 63-25	EMH 63-25 SCREW	M18x20 EM SCREW
EMH MB 63-32	EME 63-32 SCREW	M18x20 EM SCREW
EMH MB 80-40	EMH 80-40 SCREW	M20x20 EM SCREW

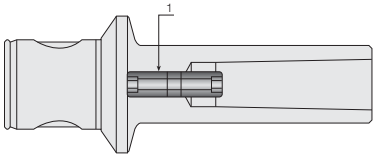
Ricambi per CC



Descrizione	1	2	Chiave
CC MB16-ER11M	CC MB16 SCREW	NUT ER11 MINI	WRENCH ER11 MINI
CC MB20-ER16M	CC MB20 SCREW	NUT ER16 MINI	WRENCH ER16 MINI
CC MB25-ER20M	CC MB25 SCREW	NUT ER20 MINI	WRENCH ER20 MINI
CC MB32-ER25M	CC MB32 SCREW	NUT ER25 MINI	WRENCH ER25 MINI
CC MB40-ER25	CC MB40 SCREW	NUT ER25 TOP	WRENCH ER25
CC MB50-ER25	CC MB50 SCREW	NUT ER25 TOP	WRENCH ER25
CC MB50-ER32	CC MB50 SCREW	NUT ER32 TOP	WRENCH ER32
CC MB63-ER32	CC MB63 SCREW	NUT ER32 TOP	WRENCH ER32
CC MB63-ER40	CC MB63 SCREW	NUT ER40 TOP	WRENCH ER40

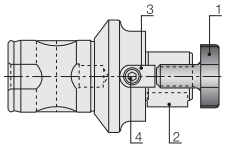
Ricambi

Vite per attacchi cono morse AMT



Descrizione	1
AMT MB50-MT2	AMT MT2-SCREW
AMT MB50-MT3	AMT MT3-SCREW
AMT MB63-MT3	AMT MT3-SCREW
AMT MB63-MT4	AMT MT4-SCREW

Vite per attacchi frontali portafrese SMH



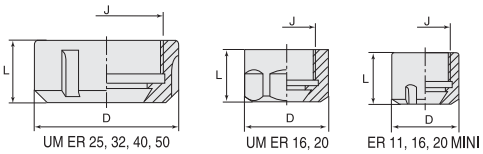
Descrizione	1	2	3	4
SMH MB40-22	M 10 CLAMP SCREW SEM 22	DOG DRIVE SMH 22	KEY SMH 22	M4x10 SMH KEY SCREW
SMH MB50-16	M 8 CLAMP SCREW SEM 16	DOG DRIVE SMH 16	KEY SMH 16	M3x 8 SMH KEY SCREW
SMH MB50-22	M 10 CLAMP SCREW SEM 22	DOG DRIVE SMH 22	KEY SMH 22	M4x10 SMH KEY SCREW
SMH MB50-27	M 12 CLAMP SCREW SEM 27	DOG DRIVE SMH 27	KEY SMH 27	M5x12 SMH KEY SCREW
SMH MB50-32	M 16 CLAMP SCREW SEM 32	DOG DRIVE SMH 32	KEY SMH 32	M6x16 SMH KEY SCREW
SMH MB63-27	M 12 CLAMP SCREW SEM 27	DOG DRIVE SMH 27	KEY SMH 27	M5x12 SMH KEY SCREW
SMH MB63-32	M 16 CLAMP SCREW SEM 32	DOG DRIVE SMH 32	KEY SMH 32	M6x16 SMH KEY SCREW
SMH MB80-32	M 16 CLAMP SCREW SEM 32	DOG DRIVE SMH 32	KEY SMH 32	M6x16 SMH KEY SCREW
SMH MB80-40	M 20 CLAMP SCREW SEM 40	DOG DRIVE SMH 40	KEY SMH 40	M6x18 SMH KEY SCREW

ER - Top™ Ghiera portapinze con ralla a sfere

DIN 6499

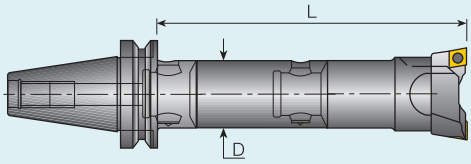
Descrizione	Dimensioni (mm)		
	D	L	J
NUT ER 16 TOP MINI	22	18	M19 X1.0
NUT ER 16 TOP	28	17	M22 X1.5
NUT ER 20 TOP	34	19	M25 X1.5
NUT ER 25 TOP	42	20	M32 X1.5
NUT ER 32 TOP	50	22	M40 X1.5
NUT ER 40 TOP	63	25	M50 X1.5

ER Ghiera portapinze

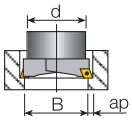


Descrizione	Dimensioni (mm)		
	D	L	J
NUT ER 11 MINI	16	10.8	M13 X0.75
NUT ER 11 UM	19	11.3	M14 X0.75
NUT ER 16 MINI	22	18	M19 X1.0
NUT ER 16 UM	28	17	M22 X1.5
NUT ER 20 MINI	28	19	M24 X1.0
NUT ER 20 UM	34	19	M25 X1.5
NUT ER 25 MINI	35	20	M30 X1.5
NUT ER 25 UM	42	20	M32 X1.5
NUT ER 32 UM	50	22	M40 X1.5
NUT ER 40 UM	63	25	M50 X1.5
NUT ER 50 UM	78	55	M64 X2.0

Parametri di taglio per testine di sgrossatura BHR



Profondità di taglio

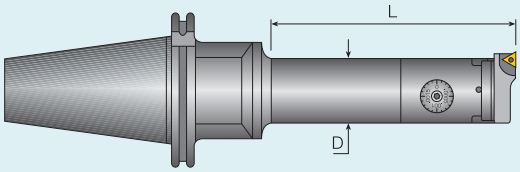


È consigliabile partire con foro B ≥ al diametro del bareno d

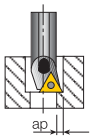
B Gamma di utilizzo	ap Acciaio	ap Ghisa, Alluminio
18-28	ap - 1.5-2	ap - 2-2.5
28-50	ap - 2-3	ap - 2.5-3.5
50-68	ap - 3-4	ap - 3.5-5
68-200	ap - 4-5	ap - 5-7
200-500	ap - 5-6	ap - 6-8

• In caso di utilizzo di un singolo tagliente, deve essere dimezzato l'avanzamento.

Dati di taglio per testine di finitura



•••-Buona
•• -Normale
• -Scarsa

Materiale	L/D	Stabilità	Velocità di taglio Vc=m/min	Avanzamento f=mm/giro Raggio inserto R=0.2	Avanzamento f=mm/giro Raggio inserto R=0.4	Profondità di taglio ap
Acciaio al Carbonio HB≤200	L/D=2.5	•••	200-300	0.05-0.08	0.08-0.10	 ap 0.1-0.25
	L/D=4	••	160-250	0.05-0.08	0.08-0.10	
	L/D=6.3	•	70-100	0.05-0.08	-	
Acciaio al Carbonio HB>200	L/D=2.5	•••	160-250	0.05-0.08	0.08-0.10	
	L/D=4	••	150-200	0.05-0.08	0.08-0.10	
	L/D=6.3	•	70-100	0.05-0.08	-	
Acciaio inox	L/D=2.5	•••	150-200	0.05-0.08	0.08-0.10	
	L/D=4	••	0.05-0.08	0.08-0.10	0.08-0.10	
	L/D=6.3	•	70- 80	0.05-0.08	0.08-0.10	
Acciaio legato(1) HB 480-550	L/D=2.5	•••	120-160	0.05-0.08	0.08-0.10	
	L/D=4	••	100-140	0.05-0.08	0.08-0.10	
	L/D=6.3	•	70-100	0.05-0.08	-	
Ghisa	L/D=2.5	•••	120-160	0.05-0.08	0.08-0.10	
	L/D=4	••	100-140	0.05-0.08	0.08-0.10	
	L/D=6.3	•	70-100	0.05-0.08	-	
Alluminio	L/D=2.5	•••	300-400	0.05-0.08	0.08-0.10	
	L/D=4	••	250-350	0.05-0.08	0.08-0.10	
	L/D=6.3	•	100-150	0.05-0.08	-	

Istruzioni d'uso testine di barenatura BHF 16-50 e BHE

Assemblaggio

- Nel montaggio della testina di barenatura BHF, il perno di espansione deve essere ben fermo all'interno del corpo cilindrico
- Inserire la testina BHF nel gambo
- Stringere il perno (2) in senso orario

Le forze di serraggio consigliate sono (N·m)

BHF MB16 - 16 x 34	2.0 - 2.5
BHF MB20 - 20 x 40	4.0 - 4.5
BHF MB25 - 25 x 50	6.5 - 7.5
BHF MB32 - 32 x 63	7.0 - 8.0
BHF MB40 - 40 x 80	16.0 - 18.0
BHF MB50 - 50 x 60	30.0 - 35.0

- Inserire la vite (5) fino al completo inserimento nel foro della ghiera o nel bareno

Smontaggio

Allentare il perno (2) in senso anti-orario

Posizionamento

- Allentare la vite (4) prima di iniziare la regolazione della slitta.
- Ruotando il regolatore diametro (3) in senso anti-orario, posizionare la slitta (7) per permettere una regolazione di 4mm.
- Fissare la slitta nella posizione desiderata, usando la vite (4).
- Stringere la vite (4)
- Prima della regolazione della slitta, allentare la vite (4).

Manutenzione

Settimanalmente:

- Lubrificare attraverso l'ugello di oliatura (8) con olio ISO UN G220.

Periodicamente:

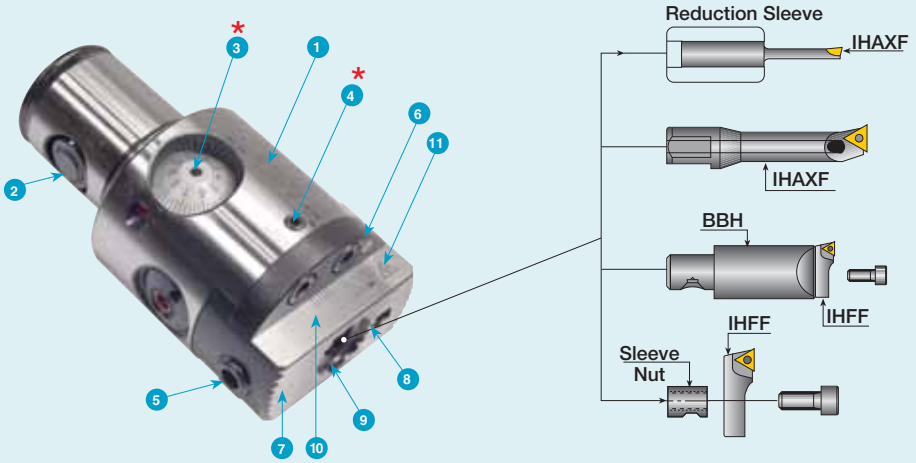
- Pulire la superficie conica cilindrica e quindi lubrificare
- Oliare il perno ad espandere (2) con lubrificante anti- frizione
- Pulire e lubrificare la guida della slitta.

NOTA IMPORTANTE:

Il porta utensile deve essere montato saldamente sulla slitta ogni volta.

* In seguito a fenomeni di ritorno, se superate il valore richiesto, ruotare il regolatore diametro (3) in senso contrario di almeno un giro e quindi regolare di nuovo nel senso iniziale.

In foto BHF 50



1 Corpo
2 Perno ad espandere
* 3 Regolatore diametro
* 4 Vite bloccaggio slitta
5 Vite bloccaggio testina
6 Refrigerante
7 Slitta utensile
8 Ugello oliatura
9 Foro utensile .63H7
10 Gamma regolazione slitta Non superare la gamma indicata!!
11 Indicazione posizione tagliente

Istruzioni d'uso testine di barenatura a finire BHF 63-125

Assemblaggio

- Nel montaggio della testina di barenatura BHF, il perno ad espansione deve essere ben fermo all'interno del corpo cilindrico
- Inserire la testina BHF nel gambo
- Stringere il perno (2), girando in senso orario

Le forze di serraggio consigliate sono: (N·m)

BHF MB50 - 63 x 87	30 - 35
BHF MB50 - 80 x 94	30 - 35
BHF MB63 - 63 x 87	80 - 90
BHF MB80 - 80 x 94	80 - 90
BHF MB80 - 125 x 94	80 - 90
BHF MB50 - 50 x 60	30.0 - 35.0

- Inserire la vite (5) fino al completo inserimento nel foro della ghiera o del bareno.

Smontaggio

- Allentare il perno (2) girando in senso anti-orario.

Posizionamento

- Allentare la vite (4) prima di iniziare la regolazione della slitta.
- Ruotando il regolatore diametro (3) in senso anti-orario, posizionare la slitta (7) per permettere una regolazione di 4mm.
- Fissare la slitta nella posizione desiderata usando la vite (4).
- Stringere la vite (4)
- Prima di ogni regolazione della slitta, allentare la vite (4).

Manutenzione

Settimanalmente:

- Lubrificare attraverso l'ugello di oliatura (8) con olio ISO UN G220.

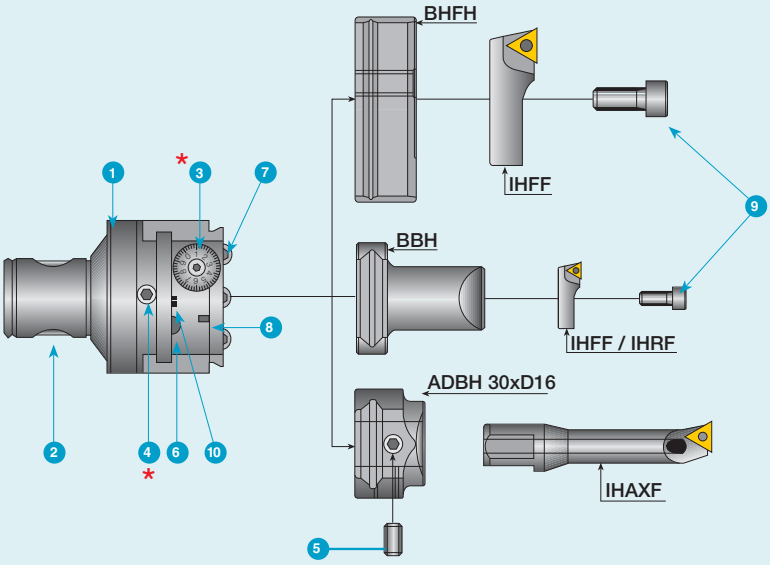
Periodicamente:

- Pulire la superficie conica cilindrica e quindi lubrificare
- Oliare il perno ad espansione (2) con lubrificante anti-frizione
- Pulire e lubrificare la guida della slitta.

NOTA IMPORTANTE:

Il porta utensile deve essere montato saldamente sulla slitta ogni volta

* In seguito a fenomeni di ritorno, se superate il valore richiesto, ruotare il regolatore diametro (3) in senso contrario di almeno un giro e quindi regolare di nuovo nel senso iniziale.



1 Corpo
2 Perno ad espandere
* 3 Regolatore diametro
* 4 Vite bloccaggio slitta
5 Vite bloccaggio testina
6 Refrigerante
7 Slitta utensile
8 Ugello oliatura
9 Vite bloccaggio testina
10 Gamma regolazione slitta Non superare la gamma indicata

Stabilità
•••– Buona
•• – Normale
• – Scarsa

BHR Dati di taglio Bareno per sgrossatura

ISO	Materiale lavorato	Durezza HB	Sporgenza L/D		Gamma Bareno D18-28		Gamma Bareno D28-50		Gamma Bareno D50-68	
				ap (mm)	0.5-1.2	1.2-2.5	0.8-1.5	1.5-2.5	0.8-1.5	1.5-3.0
				R (Raggio)	0.2	0.4	0.2-0.4	0.4	0.2-0.4	0.4-0.8
P	Acciaio al Carbonio	HB<200	2.5 •••	Vc (m/min)	150-180	120-150	160-200	140-170	160-200	140-180
				f (mm/giro)	0.1-0.2	0.08-0.2	0.15-0.2	0.1-0.175	0.15-0.25	0.08-0.2
			4 •••	Vc (m/min)	140-160	100-140	160-180	120-150	160-180	120-150
				f (mm/giro)	0.1-0.18	0.08-0.15	0.1-0.12	0.08-0.1	0.1-0.12	0.08-0.1
			6.3 •••	Vc (m/min)	60-80	40-60	60-90	50-60	70-90	50-70
				f (mm/giro)	0.06-0.12	0.06-0.1	0.06-0.12	0.06-0.1	0.06-0.1	0.06-0.1
	Acciaio al Carbonio	HB>200	2.5 •••	Vc (m/min)	130-160	100-130	140-180	120-160	140-180	120-160
				f (mm/giro)	0.08-0.15	0.08-0.12	0.08-0.2	0.06-0.12	0.08-0.25	0.08-0.18
			4 •••	Vc (m/min)	110-140	80-110	100-140	80-120	100-140	80-120
				f (mm/giro)	0.08-0.12	0.08-0.1	0.08-0.15	0.06-0.15	0.08-0.2	0.06-0.15
			6.3 •••	Vc (m/min)	70-90	60-70	80-100	60-80	80-100	60-80
				f (mm/giro)	0.08-0.1	0.06-0.08	0.06-0.1	0.06-0.08	0.08-0.15	0.06-0.1

ISO	Materiale lavorato	Durezza HB	Sporgenza L/D		Gamma Bareno D68-120		Gamma Bareno D120-200		Gamma Bareno D200-500	
				ap (mm)	0.8-1.5	1.5-3.5	0.8-2.0	2.0-3.5	0.8-1.5	2.0-4.0
				R (Raggio)	0.2-0.4	0.4-0.8	0.2-0.4	0.4-0.8	0.2-0.4	0.4-0.8
P	Acciaio al Carbonio	HB<200	2.5 •••	Vc (m/min)	160-220	150-180	180-250	160-200	220-280	200-220
				f (mm/giro)	0.15-0.25	0.08-0.2	0.15-0.3	0.1-0.2	0.15-0.3	0.1-0.15
			4 •••	Vc (m/min)	140-180	120-150	160-200	140-180	N.R.	N.R.
				f (mm/giro)	0.08-0.2	0.08-0.15	0.1-0.2	0.08-0.15		
			6.3 •••	Vc (m/min)	70-100	50-70	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.06-0.1	0.06-0.1				
	Acciaio al Carbonio	HB<200	2.5 •••	Vc (m/min)	140-180	120-160	150-170	100-140	100-140	80-120
				f (mm/giro)	0.15-0.3	0.12-0.2	0.15-0.25	0.1-0.2	0.15-0.3	0.1-0.2
			4 •••	Vc (m/min)	120-150	100-140	100-130	80-110	N.R.	N.R.
				f (mm/giro)	0.1-0.2	0.1-0.18	0.08-0.2	0.08-0.12		
			6.3 •••	Vc (m/min)	80-100	60-80	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.08-0.12	0.08-0.12				

ISO	Materiale lavorato	Durezza HB	Sporgenza L/D		Gamma Bareno D18-28		Gamma Bareno D28-50		Gamma Bareno D50-68	
				ap (mm)	0.5-1.0	1.0-1.8	0.5-1.0	1.0-1.8	0.5-1.2	1.2-2.0
				R (Raggio)	0.2	0.4	0.2-0.4	0.4	0.2-0.4	0.4-0.8
P	Acciaio Legato	HB<200	2.5 •••	Vc (m/min)	140-160	90-120	150-180	100-130	160-200	140-180
				f (mm/giro)	0.08-0.18	0.08-0.15	0.08-0.2	0.08-0.18	0.1-0.25	0.1-0.15
			4 ••	Vc (m/min)	100-130	70-100	110-150	90-120	140-180	100-130
				f (mm/giro)	0.08-0.15	0.06-0.12	0.08-0.18	0.08-0.15	0.8-0.18	0.08-0.12
			6.3 •	Vc (m/min)	80-100	60-90	80-100	70-90	100-140	80-120
				f (mm/giro)	0.08-0.15	0.06-0.1	0.06-0.12	0.06-0.12	0.6-0.15	0.08-0.1
	Acciaio Legato	HB>200	2.5 •••	Vc (m/min)	130-150	120-140	130-150	120-140	140-170	120-150
				f (mm/giro)	0.08-0.18	0.06-0.15	0.08-0.18	0.06-0.15	0.08-0.2	0.08-0.18
			4 ••	Vc (m/min)	100-130	100-120	100-130	100-120	120-150	100-120
				f (mm/giro)	0.08-0.15	0.06-0.13	0.08-0.15	0.06-0.13	0.08-0.18	0.08-0.15
			6.3 •	Vc (m/min)	80-100	70-90	80-100	70-90	100-120	70-90
				f (mm/giro)	0.08-0.12	0.06-0.11	0.08-0.12	0.06-0.11	0.08-0.12	0.06-0.11

ISO	Materiale lavorato	Durezza HB	Sporgenza L/D		Gamma Bareno D68-120		Gamma Bareno D120-200		Gamma Bareno D200-500	
				ap (mm)	0.8	2.5	0.8-2.0	2.0-3.5	0.8-2.0	2.0-4.0
				R (Raggio)	0.2-0.4	0.4-0.8	0.2-0.4	0.4-0.8	0.2-0.4	0.4-0.8
P	Acciaio Legato	HB<200	2.5 •••	Vc (m/min)	160-220	140-180	160-220	140-180	160-220	140-180
				f (mm/giro)	0.1-0.3	0.1-0.25	0.1-0.3	0.1-0.25	0.1-0.35	0.1-0.3
			4 ••	Vc (m/min)	150-200	120-160	120-160	120-160	N.R.	N.R.
				f (mm/giro)	0.1-0.2	0.08-0.18	0.1-0.2	0.08-0.18		
			6.3 •	**Vc** (m/min)	100-140	100-140	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.08-0.18	0.08-0.15				
	Acciaio Legato	HB>200	2.5 •••	Vc (m/min)	160-200	140-180	140-200	140-180	140-200	140-180
				f (mm/giro)	0.1-0.3	0.01-0.25	0.01-0.35	0.01-0.3	0.01-0.35	0.01-0.3
			4 ••	Vc (m/min)	140-160	120-140	150-180	120-140	N.R.	N.R.
				f (mm/giro)	0.08-0.2	0.08-0.15	0.08-0.12	0.08-0.12		
			6.3 •	Vc (m/min)	100-120	70-90	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.08-0.16	0.08-0.12				

• **N.R.** = Non consigliato

Stabilità
••• – Buona
•• – Normale
• – Scarsa

BHR Dati di taglio Bareno di sgrossatura

ISO	Materiale lavorato	Durezza HB	Sporgenza L/D		Gamma Bareno D18-28		Gamma Bareno D28-50		Gamma Bareno D50-68	
				ap (mm)	0.5-1.0	1.0-1.8	0.5-1.0	1.0-1.8	0.5-1.2	1.2-2.0
				R (Raggio)	0.2	0.4	0.2-0.4	0.4	0.2-0.4	0.4-0.8
M	Acciaio Inox	Ferritico e Martensitico	2.5 •••	Vc (m/min)	100-150	110-130	120-160	100-150	120-160	110-160
				f (mm/giro)	0.08-0.15	0.06-0.12	0.08-0.18	0.06-0.12	0.08-0.25	0.08-0.18
			4 ••	Vc (m/min)	90-130	90-120	100-140	90-140	100-150	80-120
				f (mm/giro)	0.08-0.12	0.06-0.1	0.08-0.12	0.06-0.1	0.08-0.18	0.08-0.12
			6.3 •	Vc (m/min)	60-90	50-70	60-90	50-70	70-100	50-70
				f (mm/giro)	0.06-0.1	0.06-0.1	0.06-0.12	0.06-0.1	0.06-0.15	0.08-0.1
	Acciaio Inox	Austenitico	2.5 •••	Vc (m/min)	110-130	100-130	120-150	110-140	110-160	100-150
				f (mm/giro)	0.08-0.15	0.06-0.12	0.08-0.18	0.06-0.12	0.08-0.25	0.06-0.12
			4 ••	Vc (m/min)	80-110	80-110	90-130	90-120	100-150	90-130
				f (mm/giro)	0.08-0.12	0.06-0.1	0.08-0.12	0.06-0.1	0.08-0.18	0.06-0.1
			6.3 •	Vc (m/min)	60-90	50-70	60-90	50-70	70-100	50-70
				f (mm/giro)	0.06-0.1	0.06-0.1	0.06-0.12	0.06-0.1	0.06-0.15	0.06-0.1
	Acciaio Inox Fuso	Ferritico e Martensitico	2.5 •••	Vc (m/min)	90-130	100-130	120-150	110-140	120-160	100-150
				f (mm/giro)	0.08-0.15	0.06-0.12	0.08-0.18	0.06-0.12	0.08-0.25	0.06-0.12
			4 ••	Vc (m/min)	70-110	80-110	90-130	90-120	100-150	90-130
				f (mm/giro)	0.08-0.12	0.06-0.1	0.08-0.12	0.06-0.1	0.08-0.18	0.06-0.1
			6.3 •	Vc (m/min)	60-90	50-70	60-90	50-70	70-100	50-70
				f (mm/giro)	0.06-0.1	0.06-0.1	0.06-0.12	0.06-0.1	0.06-0.15	0.06-0.1
	Acciaio Inox Fuso	Austenitico	2.5 •••	Vc (m/min)	80-120	70-110	100-150	90-140	110-150	100-150
				f (mm/giro)	0.08-0.15	0.06-0.12	0.08-0.18	0.06-0.12	0.08-0.25	0.06-0.12
			4 ••	Vc (m/min)	70-100	70-100	80-130	70-120	90-140	90-130
				f (mm/giro)	0.08-0.12	0.06-0.1	0.08-0.12	0.06-0.1	0.08-0.18	0.06-0.1
			6.3 •	Vc (m/min)	60-90	50-70	60-90	50-70	70-100	50-70
				f (mm/giro)	0.06-0.1	0.06-0.1	0.06-0.12	0.06-0.1	0.06-0.15	0.06-0.1

ISO	Materiale Lavorato	Durezza HB	Sporgenza L/D		Gamma Bareno D68-120		Gamma Bareno D120-200		Gamma Bareno D200-500	
				ap (mm)	0.8-1.8	1.8-2.5	0.8-2.0	2.0-3.0	0.8-2.0	2.0-3.5
				R (Raggio)	0.2-0.4	0.4-0.8	0.2-0.4	0.4-0.8	0.2-0.4	0.2-0.4
M	Acciaio Inox	Ferritico e Martensitico	2.5 •••	Vc (m/min)	130-220	120-200	140-220	120-180	150-220	120-200
				f (mm/giro)	0.08-0.3	0.08-0.25	0.08-0.3	0.08-0.25	0.08-0.3	0.08-0.25
			4 ••	Vc (m/min)	100-160	90-140	120-180	90-140	N.R.	N.R.
				f (mm/giro)	0.08-0.25	0.08-0.18	0.08-0.25	0.08-0.18		
			6.3 •	Vc (m/min)	70-100	50-70	N.R.	N.R.	N.R.	N.R
				f (mm/giro)	0.08-0.2	0.08-0.15				
	Acciaio Inox	Austenitico	2.5 •••	Vc (m/min)	120-200	100-160	120-200	100-160	120-200	100-180
				f (mm/giro)	0.08-0.3	0.08-0.25	0.08-0.3	0.08-0.25	0.08-0.3	0.08-0.25
			4 ••	Vc (m/min)	100-150	90-140	100-160	90-140	N.R.	N.R.
				f (mm/giro)	0.08-0.25	0.08-0.18	0.08-0.25	0.08-0.18	0.08-0.18	0.06-0.1
			6.3 •	Vc (m/min)	70-100	50-70	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.08-0.2	0.08-0.15				
	Acciaio Inox Fuso	Ferritico e Martensitico	2.5 •••	Vc (m/min)	130-200	120-180	140-200	120-160	140-200	120-180
				f (mm/giro)	0.08-0.3	0.08-0.25	0.08-0.3	0.08-0.25	0.08-0.3	0.08-0.25
			4 ••	Vc (m/min)	110-150	90-150	100-160	90-140	N.R.	N.R.
				f (mm/giro)	0.08-0.25	0.08-0.18	0.08-0.25	0.08-0.18		
			6.3 •	Vc (m/min)	70-100	50-70	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.08-0.2	0.08-0.15				
	Acciaio Inox Fuso	Austenitico	2.5 •••	Vc (m/min)	130-180	120-180	120-200	100-160	120-200	100-180
				f (mm/giro)	0.08-0.3	0.08-0.25	0.08-0.3	0.08-0.25	0.08-0.3	0.08-0.25
			4 ••	Vc (m/min)	100-140	90-140	100-160	90-140	N.R.	N.R.
				f (mm/giro)	0.08-0.25	0.08-0.18	0.08-0.25	0.08-0.18		
			6.3 •	Vc (m/min)	70-190	50-70	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.08-0.2	0.08-0.15				

• **N.R.** = Non consigliato

Stabilità
•••– Buona
••– Normale
• – Scarsa

BHR Dati di taglio Bareno di Sgrossatura

ISO	Materiale lavorato	Durezza HB	Sporgenza L/D		Gamma Bareno D18-28		Gamma Bareno D28-50		Gamma Bareno D50-68	
				ap (mm)	0.5-1.0	1.0-1.8	0.5-1.0	1.0-1.8	0.5-1.2	1.2-2.0
				R (Raggio)	0.2-0.4	0.4	0.2-0.4	0.4	0.2-0.4	0.4-0.8
K	Ghisa Grigia GG 10-25	HB<200	2.5 •••	Vc (m/min)	120-160	100-140	120-180	110-150	120-180	110-150
				f (mm/giro)	0.06-0.15	0.06-0.18	0.06-0.15	0.06-0.12	0.08-0.2	0.08-0.12
			4 ••	Vc (m/min)	100-140	80-120	100-150	80-120	100-150	80-120
				f (mm/giro)	0.06-0.12	0.06-0.1	0.06-0.12	0.06-0.1	0.08-0.12	0.08-0.1
			6.3 •	Vc (m/min)	70-100	60-90	70-100	60-90	70-100	60-90
				f (mm/giro)	0.06-0.1	0.06-0.1	0.06-0.1	0.06-0.1	0.08-0.1	0.08-0.1
	Ghisa Grigia GG 25-40		2.5 •••	Vc (m/min)	140-200	140-200	140-220	160-250	180-220	200-280
				f (mm/giro)	0.06-0.15	0.06-0.18	0.06-0.15	0.06-0.18	0.08-0.2	0.1-0.25
			4 ••	Vc (m/min)	120-160	120-160	120-180	140-200	140-180	180-220
				f (mm/giro)	0.06-0.12	0.06-0.14	0.06-0.12	0.06-0.14	0.08-0.12	0.08-0.2
			6.3 •	Vc (m/min)	70-100	60-90	70-100	60-90	60-100	60-120
				f (mm/giro)	0.06-0.1	0.06-0.1	0.06-0.1	0.06-0.1	0.08-0.1	0.08-0.1
	Ghisa GGG	Sferoidale e Grafite	2.5 •••	Vc (m/min)	120-180	120-180	120-200	140-220	180-220	180-240
				f (mm/giro)	0.06-0.15	0.06-0.18	0.06-0.15	0.06-0.18	0.08-0.18	0.1-0.2
			4 ••	Vc (m/min)	120-160	120-160	120-180	140-200	140-200	160-220
				f (mm/giro)	0.06-0.12	0.06-0.14	0.06-0.12	0.06-0.14	0.08-0.12	0.08-0.18
			6.3 •	Vc (m/min)	60-100	60-90	60-100	60-90	60-90	60-100
				f (mm/giro)	0.06-0.1	0.06-0.1	0.06-0.1	0.06-0.1	0.08-0.1	0.08-0.1

ISO	Materiale Lavorato	Durezza HB	Sporgenza L/D		Gamma Bareno D18-28		Gamma Bareno D28-50		Gamma Bareno D50-68	
				ap (mm)	0.8-1.8	1.8-2.5	0.8-2.0	2.0-3.0	0.8-2.0	2.0-3.5
				R (Raggio)	0.2-0.4	0.4-0.8	0.2-0.4	0.4-0.8	0.2-0.4	0.4-0.8
K	Ghisa Grigia GG 10-25	HB<200	2.5 •••	Vc (m/min)	120-200	110-150	150-250	180-280	150-250	180-280
				f (mm/giro)	0.08-0.25	0.08-0.3	0.08-0.25	0.08-0.35	0.08-0.25	0.08-0.35
			4 ••	Vc (m/min)	100-150	80-120	120-170	120-170	N.R.	N.R.
				f (mm/giro)	0.08-0.18	0.08-0.2	0.08-0.18	0.08-0.25		
			6.3 •	Vc (m/min)	70-100	60-90	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.08-0.15	0.08-0.12				
	Ghisa Grigia GG 25-40		2.5 •••	Vc (m/min)	50-300	250-350	250-350	250-350	250-350	250-350
				f (mm/giro)	0.12-0.35	0.12-0.35	0.15-0.3	0.15-0.4	0.15-0.3	0.15-0.4
			4 ••	Vc (m/min)	200-270	230-300	200-300	200-270	N.R.	N.R.
				f (mm/giro)	0.1-0.25	0.12-0.3	0.15-0.3	0.15-0.35		
			6.3 •	Vc (m/min)	70-150	60-120	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.1-0.15	0.12-0.25				
	Ghisa GGG	Sferoidale e Grafite	2.5 •••	Vc (m/min)	200-240	200-280	200-280	220-300	220-300	220-300
				f (mm/giro)	0.12-0.3	0.12-0.3	0.15-0.3	0.15-0.35	0.15-0.3	0.15-0.35
			4 ••	Vc (m/min)	160-220	180-240	180-250	200-270	N.R.	N.R.
				f (mm/giro)	0.1-0.2	0.12-0.25	0.15-0.25	0.15-0.35		
			6.3 •	Vc (m/min)	60-100	60-100	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.1-0.15	0.12-0.2				

• **N.R.** = Non consigliato

Stabilità
•••– Buona
•• – Normale
• – Scarsa

BHR Dati di taglio Bareno di sgrossatura

ISO	Materiale lavorato	Durezza HB	Sporgenza L/D		Gamma Bareno D18-28		Gamma Bareno D28-50		Gamma Bareno D50-68	
				ap (mm)	0.5-1.5	1.5-2.5	0.5-1.5	1.5-2.5	0.5-2.0	1.2-3.0
				R (Raggio)	0.2-0.4	0.4	0.2-0.4	0.4	0.2-0.4	0.4-0.8
N	Alluminio/ Fuso	>12si	2.5 •••	Vc (m/min)	200-300	240-350	200-300	240-350	200-300	240-350
				f (mm/giro)	0.06-0.2	0.06-0.25	0.06-0.2	0.06-0.25	0.06-0.25	0.06-0.3
			4 ••	Vc (m/min)	150-220	150-220	150-220	150-220	150-220	150-220
				f (mm/giro)	0.06-0.2	0.06-0.2	0.06-0.2	0.06-0.2	0.06-0.2	0.06-0.2
			6.3 •	Vc (m/min)	60-100	60-100	60-100	60-100	60-100	60-100
				f (mm/giro)	0.06-0.1	0.06-0.1	0.06-0.1	0.06-0.1	0.06-0.1	0.06-0.1
	Alluminio/ Fuso	<12si	2.5 •••	Vc (m/min)	180-250	220-280	180-250	220-280	180-250	220-280
				f (mm/giro)	0.06-0.2	0.06-0.25	0.06-0.25	0.06-0.25	0.06-0.25	0.06-0.3
			4 ••	Vc (m/min)	120-220	120-220	120-220	120-220	120-220	120-220
				f (mm/giro)	0.06-0.2	0.06-0.2	0.06-0.2	0.06-0.2	0.06-0.2	0.06-0.25
			6.3 •	Vc (m/min)	60-100	60-100	60-100	60-100	60-100	60-100
				f (mm/giro)	0.06-0.1	0.06-0.1	0.06-0.1	0.06-0.1	0.06-0.1	0.06-0.1

ISO	Materiale lavorato	Durezza HB	Sporgenza L/D		Gamma Bareno D68-120		Gamma Bareno D120-200		Gamma Bareno D200-500	
				ap (mm)	0.8-3.0	1.8-4.0	0.8-3.0	2.0-4.0	0.8-3.0	2.0-4.5
				R (Raggio)	0.2-0.4	0.4-0.8	0.2-0.4	0.4-0.8	0.2-0.4	0.4-0.8
N	Alluminio/ Fuso	>12si	2.5 •••	Vc (m/min)	200-300	240-350	200-300	240-350	200-300	240-350
				f (mm/giro)	0.06-0.25	0.06-0.3	0.06-0.25	0.06-0.4	0.06-0.25	0.06-0.4
			4 ••	Vc (m/min)	150-220	150-220	150-220	150-220	N.R.	N.R.
				f (mm/giro)	0.06-0.2	0.06-0.2	0.06-0.2	0.06-0.2		
			6.3 •	Vc (m/min)	60-100	60-100	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.06-0.1	0.06-0.1				
	Alluminio/ Fuso	<12si	2.5 •••	Vc (m/min)	180-250	220-280	180-250	220-280	180-250	220-280
				f (mm/giro)	0.06-0.25	0.06-0.3	0.06-0.3	0.06-0.4	0.06-0.3	0.06-0.4
			4 ••	Vc (m/min)	120-220	120-220	120-220	120-220	N.R.	N.R.
				f (mm/giro)	0.06-0.2	0.06-0.25	0.06-0.2	0.06-0.25		
			6.3 •	Vc (m/min)	60-100	60-100	N.R.	N.R.	N.R.	N.R.
				f (mm/giro)	0.06-0.1	0.06-0.1				

• **N.R.** = Non consigliato