NT-SPEEDY

NORMALTECH MF

PRODUZIONE E DISTRIBUZIONE UTENSILI AD ASPORTAZIONE TRUCIOLO

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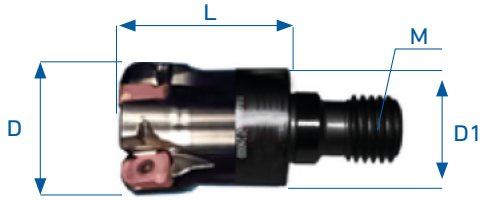
ATTACCO CILINDRICO

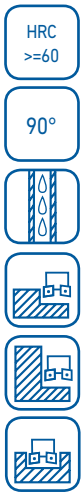
NOVITÀ

CODICE	Ø D	L	L1	Ø dh6	Z	INSERTO	VITE	TORX
VBL06016CWZ2R-150	16	150	30	16	2	BLMP 0603..	VM2506E	T08
VBL06016CLWZ2R-200	16	200	30	16	2	BLMP 0603..	VM2506E	T08
VBL06020CWZ3R-150	20	150	30	20	3	BLMP 0603..	VM2506E	T08
VBL06020CLWZ3R-200	20	200	30	20	3	BLMP 0603..	VM2506E	T08
VBL06025CWZ4R-150	25	150	35	25	4	BLMP 0603..	VM2506E	T08
VBL06025CLWZ4R-200	25	200	35	25	4	BLMP 0603..	VM2506E	T08
VBL06032CWZ5R-150	32	150	40	32	5	BLMP 0603..	VM2506E	T08
VBL06032CLWZ5R-200	32	200	40	32	5	BLMP 0603..	VM2506E	T08
VBL06035CWZ5R-150	35	150	40	32	5	BLMP 0603..	VM2506E	T08
VBL06035CLWZ5R-200	35	200	40	32	5	BLMP 0603..	VM2506E	T08

ATTACCO FILETTATO

NOVITÀ

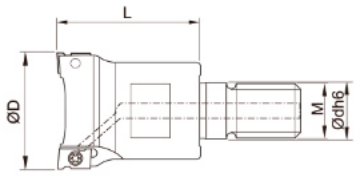




CODICE	D	D1	L	M	Z	INSERTO	VITE	TORX
16 06BL 08	16	13	25	M08	2			
17 06 BL -	17	13	25	-	2			
18 06BL 08	18	13	25	M08	2			
20 06BL 10	20	18	30	M10	2			
20 03BL 10	20	18	30	M10	3			
21 03BL -	21	18	30	-	3			
22 03BL -	22	18	30	-	3			
25 03BL 12	25	21	35	M12	3			
26 03 BL -	26	21	35	-	3	XMBL	M2.5X7	TX08
25 04BL 12	25	21	35	M12	4			
32 04BL 16	32	29	40	M16	4			
32 05BL 16	32	29	40	M16	5			
35 05BL 16 Z4	35	29	43	M16	4			
35 05BL 16 Z5	35	29	43	M16	5			
40 05BL 16	40	29	43	M16	6			
42 05BL 16 Z5	42	29	43	M16	5			
42 05BL 16 Z 6	42	29	43	M16	6			

ATTACCO FILETTATO

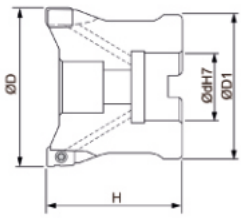
NOVITÀ



CODICE	Ø D	L	M	Ø dh6	Z	INSERTO	VITE	TORX
VASPV06016M08WZ2R	16	25	8	8.5	2	MPHW 0603..	VM2506E	T08
VASPV06020M10WZ3R	20	30	10	10.5	3	MPHW 0603..	VM2506E	T08
VASPV06025M12WZ4R	25	35	12	12.5	4	MPHW 0603..	VM2506E	T08
VASPV06032M16WZ5R	32	40	16	17	5	MPHW 0603..	VM2506E	T08
VASPV06035M16WZ5R	35	40	16	17	5	MPHW 0603..	VM2506E	T08
VASPV06042M16WZ6R	42	40	16	17	6	MPHW 0603..	VM2506E	T08

ATTACCO A MANICOTTO

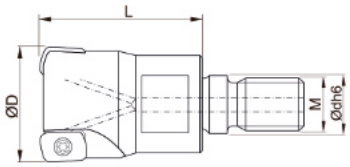
NOVITÀ



CODICE	Ø D	H	Ø D1	Ø dh7	Z	INSERTO	VITE	TORX
VASPV06042MWZ6R-16	42	40	8	16	6	MPHW 0603..	VM2506E	T08
VASPV06052MWZ7R-22	52	50	40	22	7	MPHW 0603..	VM2506E	T08
VASPV06052MWZ7R-27	52	50	45	27	7	MPHW 0603..	VM2506E	T08
VASPV06066MWZ8R-27	66	50	60	27	8	MPHW 0603..	VM2506E	T08

ATTACCO FILETTATO

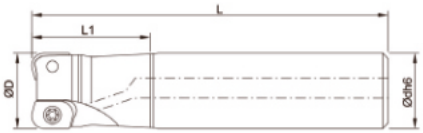
NOVITÀ



CODICE	Ø D	L	M	Ø dh6	Z	INSERTO	VITE	TORX
VASR06016M08WZ2R	16	25	8	8.5	2	EP..0603..	VM2506E	T09
VASR06020M10WZ3R	20	30	10	10.5	3	EP..0603..	VM2506E	T09
VASR06025M12WZ4R	25	35	12	12.5	4	EP..0603..	VM2506E	T09
VASR06032M16WZ5R	32	40	16	17	5	EP..0603..	VM2506E	T09
VASR06035M16WZ5R	35	40	16	17	5	EP..0603..	VM2506E	T09
VASR06042M16WZ6R	42	40	16	17	6	EP..0603..	VM2506E	T09

ATTACCO CILINDRICO

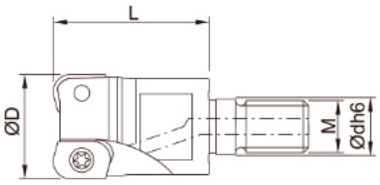
NOVITÀ



CODICE	Ø D	L	L1	Ø dh6	Z	INSERTO	VITE	TORX
V90ASM07012CZ3R	12	120	20	12	3	INTERCAMBIABILE EDMT 070220R JDMT 0702..R	VM1804A	T06
V90ASM07016CWZ4R	16	150	25	16	4		VM1804A	T06
V90ASM07020CWZ5R	20	150	30	20	5		VM1804A	T06
V90ASM07020CLWZ5R-200	20	200	30	20	5		VM1804A	T06
V90ASM07025CWZ5R	25	150	35	25	5		VM1804A	T06
V90ASM07025CLWZ5R-200	25	200	35	25	5		VM1804A	T06

ATTACCO FILETTATO

NOVITÀ

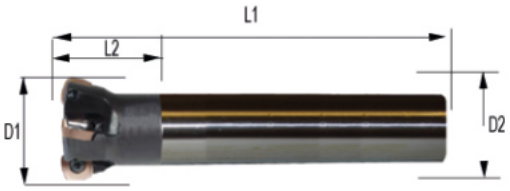


CODICE	Ø D	L	M	Ø dh6	Z	INSERTO	VITE	TORX
V90ASM07012M06Z3R	12	20	06	6.5	3	INTERCAMBIABILE EDMT 070220R JDMT 0702..R	VM1804A	T06
V90ASM07016M08Z4R	16	25	08	8.5	4		VM1804A	T06
V90ASM07020M10Z5R	20	25	10	10.5	5		VM1804A	T06
V90ASM07020M12Z5R	25	28	12	12.5	5		VM1804A	T06

HRC >=60

ATTACCO CILINDRICO

NOVITÀ

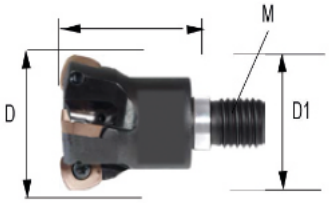


CODICE	D1	D2	L1	L2	Z	INSERTO	VITE	TORX
20 03 130 HP	20	20	130	35	3	XPMW/T2.0	S3	TX10
25 04 140 HP	25	25	140	40	4	XPMW/T2.0	S3	TX10
32 05 200 HP	32	32	150	45	5	XPMW/T2.0	S3	TX10
35 05 200 HP	25	24	200	45	4	XPMW/T2.0	S3	TX10

HRC >=60

ATTACCO FILETTATO

NOVITÀ



CODICE	D	L	D1	M	Z	INSERTO	VITE	TORX
20 HP 30 10	20	30	17.7	M10	3	XPMW/T2.0	S3	TX10
25 HP 35 12	25	35	20.7	M12	4	XPMW/T2.0	S3	TX10
32 HP 40 16	32	40	28.7	M16	5	XPMW/T2.0	S3	TX10
35 HP 40 16	35	40	28.7	M16	5	XPMW/T2.0	S3	TX10

HRC >=60

ATTACCO A MANICOTTO

NOVITÀ

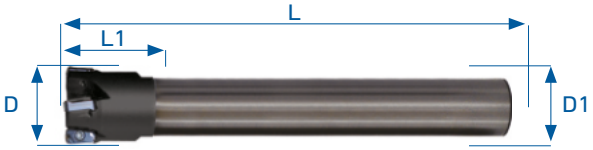
CODICE	D	D1	L	Z	INSERTO	VITE	TORX
50 HP 20.7	50	22	50	7	XPMW/T2.0	S3	TX10
52 HP 20.7	52	22	50	7	XPMW/T2.0	S3	TX10
63 HP 20.8	63	22	50	8	XPMW/T2.0	S3	TX10

* SU RICHIESTA

HRC >=60

90°

ATTACCO CILINDRICO

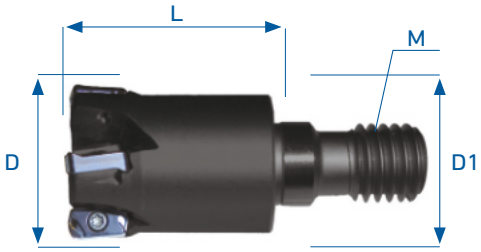


CODICE	D	D1	L	L1	Z	INSERTO	RAGGIO	VITE	TORX
1602 HN 180	16	15	180	30	2	XDNT 1.2	1.2	S2.5	TX08
2003 HN 200	20	19	200	30	3	XDNT 1.2	1.2	S2.5	TX08
2504 HN 200	25	20	200	35	4	XDNT 1.2	1.2	S2.5	TX08
2504 HN 20024*	25	24	200	35	4	XDNT 1.2	1.2	S2.5	TX08
3205 HN 200	32	25	200	40	5	XDNT 1.2	1.2	S2.5	TX08

HRC >=60

90°

ATTACCO FILETTATO

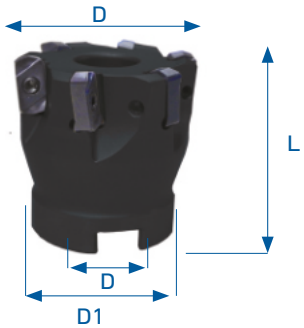


CODICE	D	M	D1	L	Z	INSERTO	RAGGIO	VITE	TORX
16 HN 25 08	16	8	12.7	23	2	XDNT 1.2	1.2	S2.5	TX08
20 HN 30 10	20	10	17.7	30	3	XDNT 1.2	1.2	S2.5	TX08
25 HN 35 12	25	12	20.7	35	4	XDNT 1.2	1.2	S2.5	TX08
32 HN 40 16	32	16	28.7	40	5	XDNT 1.2	1.2	S2.5	TX08
35 HN 43 16*	35	16	28.7	43	6	XDNT 1.2	1.2	S2.5	TX08
40 HN 43 16*	40	16	28.7	43	6	XDNT 1.2	1.2	S2.5	TX08
42 HN 43 16	42	16	28.7	43	6	XDNT 1.2	1.2	S2.5	TX08

HRC >=60

90°

ATTACCO A MANICOTTO



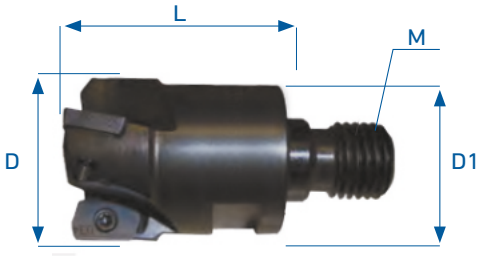
CODICE	D	L	D1	D	Z	INSERTO	RAGGIO	VITE	TORX
40 HN 12.5*	40	50	48	16	5	XDNT 1.2	1.2	S2.5	TX08
42 HN 12.5*	42	50	48	16	5	XDNT 1.2	1.2	S2.5	TX08
50 HN 12.6*	50	50	48	22	6	XDNT 1.2	1.2	S2.5	TX08
52 HN 12.6*	52	50	48	22	6	XDNT 1.2	1.2	S2.5	TX08

HRC >=60

90°

ATTACCO CILINDRICO

CODICE	D	D1	L	L1	Z	INSERTO	RAGGIO	VITE	TORX
20 02 10 HS	20	20	180	40	2	XDS/FHCS	1.5	S30	TX08
25 03 10 HS	25	25	200	45	3	XDS/FCHS	1.5	S30	TX08
32 04 10 HS*	32	32	220	50	4	XDS/FHCS	1.5	S30	TX08



HRC >=60

90°

ATTACCO FILETTATO

CODICE	D	L	D1	M	Z	INSERTO	RAGGIO	VITE	TORX
20 HS 30 10	20	30	17.7	10	2	XDS/FHCS	1.5	S30	TX08
25 HS 35 12	25	35	20.7	12	3	XDS/FCHS	1.5	S30	TX08
32 HS 35 16	32	43	28.7	16	4		1.5	S30	TX08
35 HS 35 16	35	43	28.7	16	4	XDS/FCHS	1.5	S30	TX08
42 HS 43 16	42	43	28.7	16	5	XDS/FHCS	1.5	S30	TX08

HRC >=60

90°

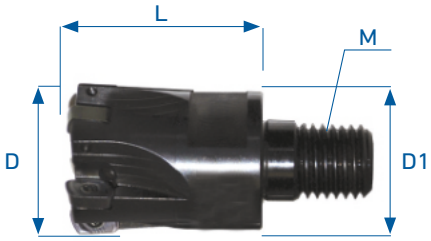
ATTACCO CILINDRICO

CODICE	D	D1	L	L1	Z	INSERTO	RAGGIO	VITE	TORX
16 02 HM 200	16	16	200	20	2	XDSR/T 2.0	2.0	S25	TX08
20 03 HM 200	20	20	200	20	3	XDSR/T 2.0	2.0	S25	TX08
25 04 HM 200	25	25	200	30	4	XDSR/T 2.0	2.0	S25	TX08

HRC >=60

90°

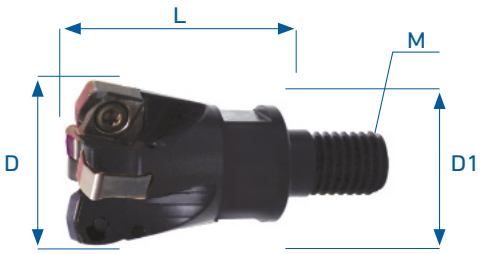
ATTACCO FILETTATO



CODICE	D	L	D1	M	Z	INSERTO	RAGGIO	VITE	TORX
16 HM 25 08	16	25	12.7	08	2	XDSR/T 2.0	2.0	S25	TX08
20 HM 30 10	20	30	17.7	10	3	XDSR/T 2.0	2.0	S25	TX08
25 HM 35 12	25	35	20.7	12	4	XDSR/T 2.0	2.0	S25	TX08
32 HM 40 16	32	40	28.7	16	5	XDSR/T 2.0	2.0	S25	TX08
35 HM 43 16	35	43	28.7	16	5	XDSR/T 2.0	2.0	S25	TX08
40 HM 43 16	40	43	28.7	16	6	XDSR/T 2.0	2.0	S25	TX08
42 HM 43 16*	42	43	28.7	16	6	XDSR/T 2.0	2.0	S25	TX08

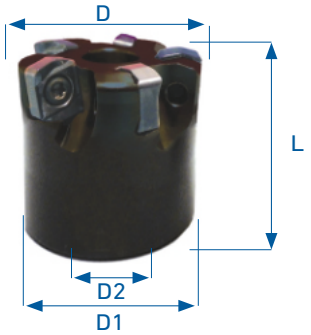
* SU RICHIESTA

ATTACCO FILETTATO



CODICE	D	L	D1	M	Z	INSERTO	RAGGIO	VITE	TORX
32 HZ 02 16*	32	43	28.7	16	2	XDZT 2.0	2.0	S40	TX15
32 HZ 03 16	32	43	28.7	16	3	XDZT 2.0	2.0	S40	TX15
42 HZ 03 16*	42	43	28.7	16	3	XDZT 2.0	2.0	S40	TX15
42 HZ 04 16	42	43	28.7	16	4	XDZT 2.0	2.0	S40	TX15

ATTACCO A MANICOTTO



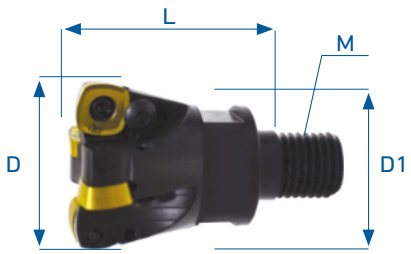
CODICE	D	L	D1	D2	Z	INSERTO	RAGGIO	VITE	TORX
50 HZ 20.5*	50	50	48	22	5	XDZT 2.0	2.0	S40	TX15
52 HZ 20.5	52	50	48	22	5	XDZT 2.0	2.0	S40	TX15
66 HZ 20.6	66	50	58	27	6	XDZT 2.0	2.0	S40	TX15
80 HZ 20.7	80	50	58	27	7	XDZT 2.0	2.0	S40	TX15
100 HZ 20.8	100	50	70	32	8	XDZT 2.0	2.0	S40	TX15

* SU RICHIESTA

HRC >=60

90°

ATTACCO FILETTATO

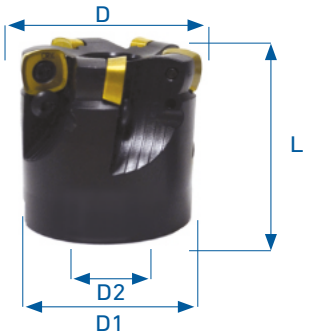


CODICE	D	L	D1	M	Z	INSERTO	RAGGIO	VITE	TORX
32 HQ 43 16	32	43	28.7	16	3	XDSR/T 4.5	4.5	S40/35D	TX15
42 HQ 43 16	42	43	28.7	16	4	XDSR/T 4.5	4.5	S40/35D	TX15

HRC >=60

90°

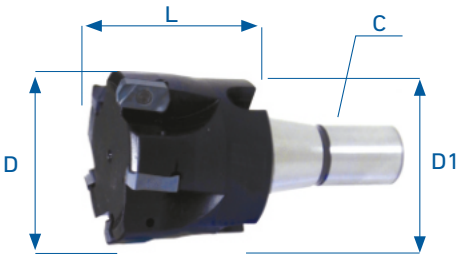
ATTACCO A MANICOTTO



CODICE	D	L	D1	D2	Z	INSERTO	RAGGIO	VITE	TORX
42 HQ 45.4*	42	43	42	16	4	XDSR/T 4.5	4.5	S40/35D	TX15
50 HQ 45.5*	50	50	48	22	5	XDSR/T 4.5	4.5	S40/35D	TX15
52 HQ 45.5	52	50	48	22	5	XDSR/T 4.5	4.5	S40/35D	TX15
66 HQ 45.6	66	50	58	27	6	XDSR/T 4.5	4.5	S40/35D	TX15
80 HQ 45.7	80	50	58	27	7	XDSR/T 4.5	4.5	S40/35D	TX15
100 HQ 45.8	100	50	70	32	8	XDSR/T 4.5	4.5	S40/35D	TX15

HRC >=60

90°

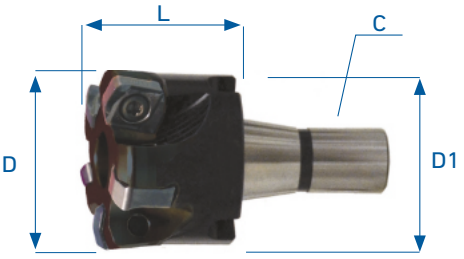


ATTACCO SOLID

CODICE	D	D1	L	C	Z	INSERTO	RAGGIO	VITE	TORX
42 XN 38 05	42	39	38	C4	5	XDNT 1.2	1.2	S2.5	TX08

HRC >=60

90°

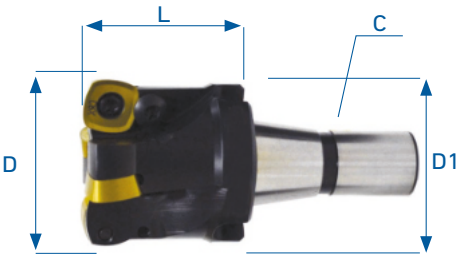


ATTACCO SOLID

CODICE	D	D1	L	C	Z	INSERTO	RAGGIO	VITE	TORX
42 XZ 38 04*	42	39	38	C4	4	XDZT 2.0	2.0	S40	TX15
52 HZ 40 05	52	49	43	C5	5	XDZT 2.0	2.0	S40	TX15

HRC >=60

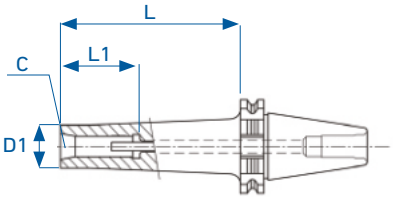
90°



ATTACCO SOLID

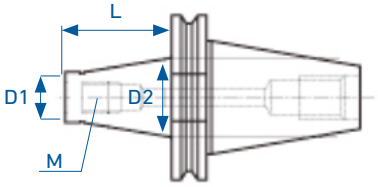
CODICE	D	D1	L	C	Z	INSERTO	RAGGIO	VITE	TORX
42 XE 38 04	42	39	38	C4	4	XDRS/T 4.5	4.5	S40/35D	TX15
52 XE 40 05	52	49	43	C5	5	XDRS/T 4.5	4.5	S40/35D	TX15

* SU RICHIESTA



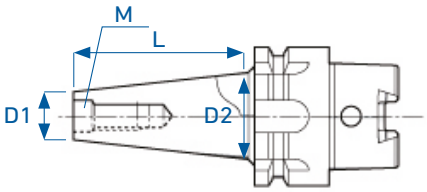
ATTACCO SOLID

CODICE	ISO	L	L1	D1	ATTACCO
40. C4. 075	40	50	50	38	C4
40. C4. 100	40	75	75	38	C4
40. C4. 150	40	125	75	38	C4
40. C4. 200	40	175	75	38	C4
40. C4. 250	40	225	75	38	C4
40. C4. 300	40	275	75	38	C4
50. C4. 100	50	75	75	38	C4
50. C4. 150	50	125	125	38	C4
50. C4. 200	50	175	125	38	C4
50. C4. 250	50	225	125	38	C4
50. C4. 300	50	275	125	38	C4
50. C4. 350	50	325	125	38	C4
50. C4. 400	50	375	125	38	C4
50. C5. 100	50	75	75	48	C5
50. C5. 150	50	125	125	48	C5
50. C5. 200	50	175	125	48	C5
50. C5. 250	50	225	125	48	C5
50. C5. 300	50	275	125	48	C5
50. C5. 350	50	325	125	48	C5
50. C5. 400	50	375	125	48	C5



ATTACCO SYSTEM

CODICE	ISO	M	D1	D2	L
30 M6/40SK	40	6	9.7	13	30
50 M6/40SK	40	6	9.7	20	50
70 M6/40SK	40	6	9.7	23	70
30 M8/40SK	40	8	12.7	15	30
50 M8/40SK	40	8	12.7	23	50
70 M8/40SK	40	8	12.7	23	70
90 M8/40SK	40	8	12.7	23	90
30 M10/40SK	40	10	17.7	20	30
50 M10/40SK	40	10	17.7	25	50
70 M10/40SK	40	10	17.7	28	70
90 M10/40SK	40	10	17.7	28	90
30 M12/40SK	40	12	20.7	24	30
50 M12/40SK	40	12	20.7	24	50
70 M12/40SK	40	12	20.7	31	70
90 M12/40SK	40	12	20.7	31	90
30 M16/40SK	40	16	28.7	29	30
50 M16/40SK	40	16	28.7	34	50
70 M16/40SK	40	16	28.7	34	70
90 M16/40SK	40	16	28.7	34	90
30 M10/50SK	50	10	17.7	20	30
50 M10/50SK	50	10	17.7	25	50
70 M10/50SK	50	10	17.7	28	70
100 M10/50SK	50	10	17.7	31	100
30 M12/50SK	50	12	20.7	24	30
50 M12/50SK	50	12	20.7	24	50
70 M12/50SK	50	12	20.7	31	70
100 M12/50SK	50	12	20.7	31	100
150 M12/50SK	50	12	20.7	41	150
30 M16/50SK	50	16	28.7	29	30
50 M16/50SK	50	16	28.7	34	50
70 M16/50SK	50	16	28.7	34	70
100 M16/50SK	50	16	28.7	41	100
150 M16/50SK	50	16	28.7	52	150
200 M16/50SK	50	16	28.7	57	200



CODICE FORMA A	CODICE FORMA B	HSK	M	D1	D2	L
25 M6/63A	25 M6/63E	63	6	9.7	10	25
50 M6/63A	50 M6/63E	63	6	9.7	20	50
75 M6/63A	75 M6/63E	63	6	9.7	20	75
25 M8/63A	25 M8/63E	63	8	12.7	15	25
50 M8/63A	50 M8/63E	63	8	12.7	23	50
75 M8/63A	75 M8/63E	63	8	12.7	23	75
100 M8/63A	100 M8/63E	63	8	12.7	25	100
25 M10/63A	25 M10/63E	63	10	17.7	20	25
50 M10/63A	50 M10/63E	63	10	17.7	25	50
75 M10/63A	75 M10/63E	63	10	17.7	28	75
100 M10/63A	100 M10/63E	63	10	17.7	30	100
25 M12/63A	25 M12/63E	63	12	20.7	24	25
50 M12/63A	50 M12/63E	63	12	20.7	24	50
75 M12/63A	75 M12/63E	63	12	20.7	31	75
100 M12/63A	100 M12/63E	63	12	20.7	31	100
25 M16/63A	25 M16/63E	63	16	28.7	34	25
50 M16/63A	50 M16/63E	63	16	28.7	34	50
75 M16/63A	75 M16/63E	63	16	28.7	34	75
100 M16/63A	100 M16/63E	63	16	28.7	39	100

B L XDSR 1.5

B L XDNT 1.2

B L FHCS

B L XDST 2.0

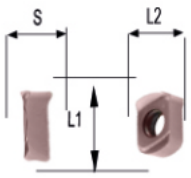
B L XDSR 2.0

B L XDZT 2.0

B L XDST 4.5

B L XDSR 4.5

NOVITÀ



CODICE	L1	L2	S	R/PROG.	QUALITY
XBLM 20 035...	9.00	6.38	3.2	2.0	035
XBLM 20 034....	9.00	6.38	3.2	2.0	034
XBLM 20 030.....	9.00	6.38	3.2	2.0	030

MPHW 060308

ISO CODICE	P	M	K	N	S	H	iC	S	L	R	STOCK
MPHW 060308 ZEL ATH08M	•	•	•				6.35	3.18	6.35	0.8	•
MPHW 060308 ZEL ATH08M	•	•	•				6.35	3.18	6.35	2	•

EPNW 0603TN-8

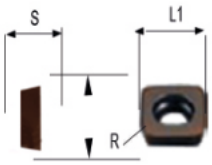
ISO CODICE	P	M	K	N	S	H	iC	S	L	R	STOCK
EPNW 0603TN-8 JP4020	•		•			•	6.35	3.18	9.5	2	•
EPMT 0603TN-8 JP4020	•	•	•			•	6.35	3.18	9.5	2	•

EDMT 070220R-T

ISO CODICE	P	M	K	N	S	H	iC	S	L	R	STOCK
EDMT 070220R-T JP4020	•	•	•	•			4.3	2.5	6.4	2	•

JDMT 070208R

ISO CODICE	P	M	K	N	S	H	iC	S	L	R	STOCK
JDMT 070280R JP4020	•	•	•	•			4.3	2.45	6.4	0.8	•



CODICE	L1	S	RAGGIO	QUALITY
XPMW/T 2.0...	8.00	3.00	2.0	030-035-034

QUALITÀ	CODICE	PVTI	VITE	TORX	VITE	S	B	L	R/PROG
P35 P20 K03 M35	XDNT 1.2	034 035 030* CRX*	S25	TX08	...	4.30	6	11.60	1.2
P35 P20 K03 M35	XDNT 1.5 FHCS	034 035 030* ...	S30	TX09	...	3.18	8	14	1.5
P35 P20 K03 M35	XDSR 2.0 XDST 2.0	034 035 030 CRX	S25	TX08	...	3.20	6,5	9.80	2.0
P35 P20 K03 M35	XDZT 2.0	034 035 030 CRX*	S40	TX15	...	5.5	12	15	2.0
P35 P20 K03 M35	XDSR 4.5 XDST 4.5	034 035 030 CRX	S40	TX15	35D	5.0	13	13	4.5

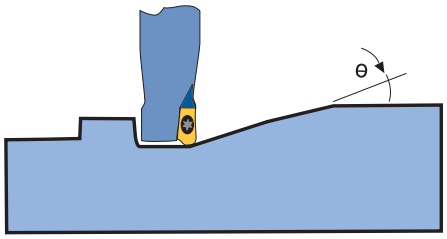
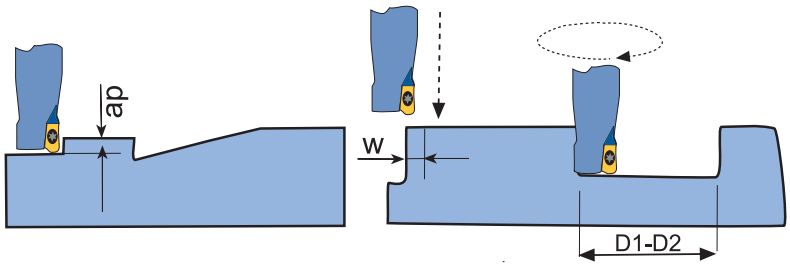


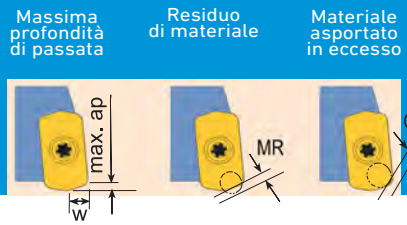
TABELLA PER L'ANGOLO MAX DI PENETRAZIONE IN RAMPA

INS \ DIAM	16	20	25	32	35	40	42	50	52	66	80	100	125
XDNT 1.2	2.1°	1.4°	1°	0.7°	_	_	0.7°	_	_	_	_	_	_
XDSRT/FHCS	_	3°	3°	3°	3°	_	3°	_	_	_	_	_	_
XDSR/T 2.0	2°	2°	2°	2°	1.5°	1.5°	_	_	_	_	_	_	_
XDZT 2.0	_	_	_	1.5°	_	_	1.3°	0.9°	0.8°	0.5°	0.5°	0.5°	_
XDSR/T 4.5	_	_	_	1°	1°	_	1°	1°	1°	1°	1°	1°	1°



INSERTI XDNT 1.2

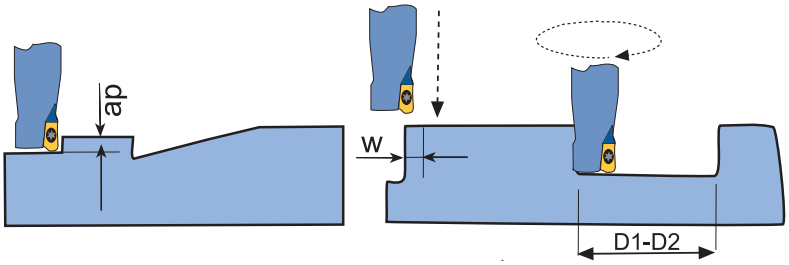
DIAM.	Max of ap (mm)	Max W (mm)	Max hole D1	Max hole D2	R di programmazione	MR	OC
16	0.3	3.0	22	30	1.2 consigliato	0.6	_
20	0.5	3.0	30	38	1.5	0.5	_
25	0.5	3.0	40	48	2.0	0.26	0.09
32	0.8	3.0	54	62	2.5	0.15	0.27
35	_	_	_	_			
40	1.0	3.0	70	78			
42	1.0	3.0	74	82			
50	1.0	3.0	98	90			



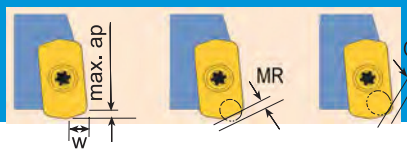
ATTENZIONE: R di programmazione consigliato 1.2. I valori espressi nella tabella sono calcolati in via teorica.

• A MAGAZZINO ○ SU RICHIESTA

INSERTI XDSR/ET 1.5

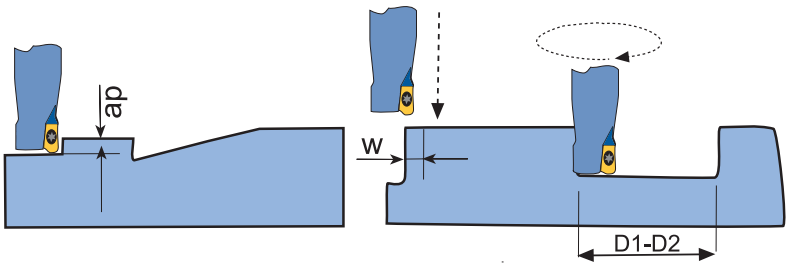


DIAM.	Max of ap (mm)	Max W (mm)	Max hole D1	Max hole D2	R di programmazione	MR	OC
20	0.3	4.7	30	38	1.5 consigliato	0.28	_
25	0.5	4.7	40	48	2.0	0.10	0.3
32	0.5	4.7	54	62			
35	0.7	4.7	60	68			
40	_	_	_	_			
42	0.7	4.7	74	82			

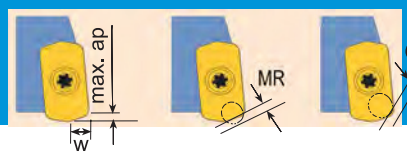


ATTENZIONE: R di programmazione consigliato 1.5. I valori espressi nella tabella sono calcolati in via teorica.

INSERTI XDSR/T 2.0

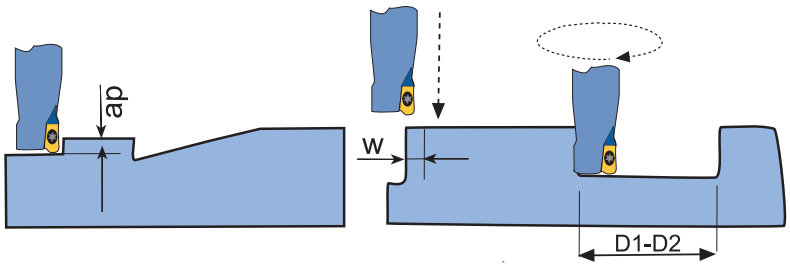


DIAM.	Max of ap (mm)	Max W (mm)	Max hole D1	Max hole D2	R di programmazione	MR	OC
16	0.3	3.8	22	30	2.0 consigliato	0.50	_
20	0.3	3.8	30	38	2.5	0.35	0.08
25	0.5	3.8	40	48	3.0	0.24	0.22
32	0.8	3.8	54	62	4.0	0.11	0.42
42	0.8	3.8	74	82			



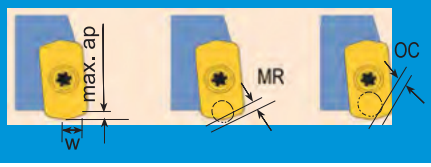
ATTENZIONE: R di programmazione consigliato 2.0. I valori espressi nella tabella sono calcolati in via teorica.

INSERTI XDZT 2.0



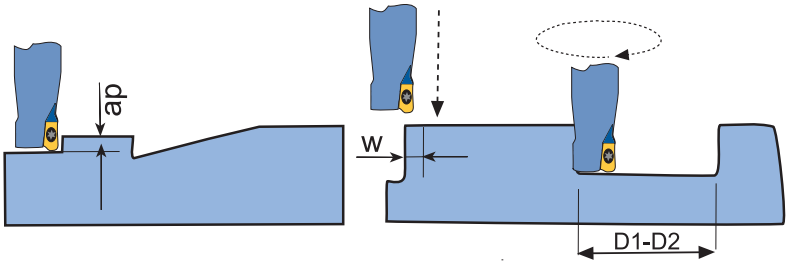
DIAM.	Max of ap (mm)	Max W (mm)	Max hole D1	Max hole D2	R di programmazione	MR	OC
32	0.5	5.0	47	59	2.0	1.0	_
40	_	_	_	_	3.0	0.77	_
42	0.8	5.0	63	75	4.0	0.54	0.26
50	1.5	5.0	83	95			
52	1.5	5.0	87	99			
66	1.5	5.0	115	127			
80	1.5	5.0	143	155			
100	1.5	5.0	183	195			

Massima profondità di passata — Residuo di materiale — Materiale asportato in eccesso



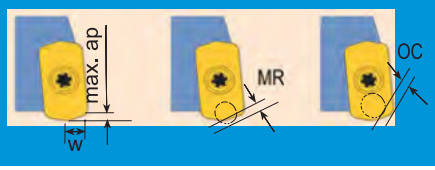
ATTENZIONE: R di programmazione consigliato 2.0. I valori espressi nella tabella sono calcolati in via teorica.

INSERTI XDSR/T 4.5



DIAM.	Max of ap (mm)	Max W (mm)	Max hole D1	Max hole D2	R di programmazione	MR	OC
32	0.5	8.2	44	64	4.5	0.83	_
40	_	_	_	_	5.0	0.65	0.07
42	0.9	8.2	64	80	5.5	0.55	0.2
50	2.0	8.2	80	96			
52	2.0	8.2	85	100			
66	2.5	8.2	113	128			
80	2.5	8.2	141	156			
100	2.5	8.2	180	195			

Massima profondità di passata — Residuo di materiale — Materiale asportato in eccesso



ATTENZIONE: R di programmazione consigliato 4.5. I valori espressi nella tabella sono calcolati in via teorica.

AVANZAMENTO DI SGROSSATURA

Cod. Inserto Ap/mm=	0.15	0.35	0.50	1.0	2.0	2.5
			Fz in funzione di ap			
XDNT 1.2	2.0	1.8	1.5	0.7	-	-
XDSR 1.5	1.4	1.3	1.0	1.0	-	-
XDSR/T 2.0	1.5	1.5	1.2	0.75	-	-
XDZT 2.0	-	-	2.0	1.5	1.0	-
XDSR/T 4.5			2.8	1.5	1.2	0.5
Coefficiente Co	1.3	1.1	1.2	1.0	0.9	0.8

AVANZAMENTO DI FINITURA

SOVRAMETALLO	COEFFICIENTE	VALORE Ra	Fz	Ap MAX
m m a e	Co	Ra 0.2	0.04	0.1
0.1	1.2	Ra 0.4	0.09	0.2
		Ra 0.6	0.17	0.4
0.2	1	Ra 1.6	0.29	0.4
		Ra 3.2	0.40	0.4
0.4	0.7	Ra 6.3	0.57	0.4
		Ra 8	0.69	0.4

VELOCITÀ DI TAGLIO CONSIGLIATE

Sgrossatura Generica				Sgrossatura alto avanzamento				Materiali
CRX	034	035	030	CRX	034	035	030	
	110-130	180-200			160-200	180-200		acciaio <1100N
	90-120	120-170	80-150		150-180	160-200		acciaio >1100N
70-150	70-100			90-200	90-120			acciaio inox
	80-110	90-120	120-180		160-180	170-200	180-200	ghisa
	_		_		_		_	alluminio
25-50				35-70				titanio
			70-100				70-180	acciaio temprato <55Hrc
			50-90				60-120	acciaio temprato <55Hrc

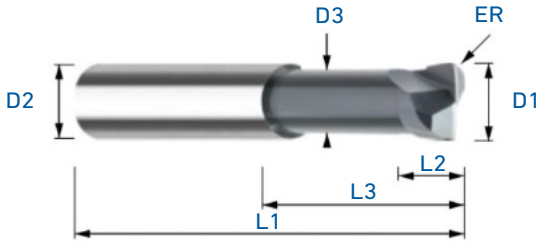
AVANZAMENTI CONSIGLIATI IN FUNZIONE DEL DIAMETRO E DELLA PASSATA

INSERTO		Diametro Fresa 16-20 mm	Diametro Fresa 25-42 mm	Diametro Fresa 50-100 mm
XDNT 1.2	fz= ap=	0.8 - 1.3 0.7 - 0.5	0.8 - 1.7 1.0 - 0.5	- -
XDSR/FHCS	fz= ap=	0.8 - 1.2 0.6 - 0.4	1.0 - 1.6 1.0 - 0.5	- -
XDSR/T 2.0	fz= ap=	0.8 - 1.3 1.0 - 0.5	1.0 - 1.6 1.0 - 0.5	- -
XDZT 2.0	fz= ap=	- -	1.2 - 1.7 0.6 - 0.4	1.2 - 2.0 1.5 - 0.5
XDSR/T 4.5	fz= ap=	- -	1.2 - 1.7 1.0 - 0.5	1.2 - 2.0 2.0 - 1.5

APPLICAZIONI INSERTI CONSIGLIATE IN FUNZIONE DEI MATERIALI

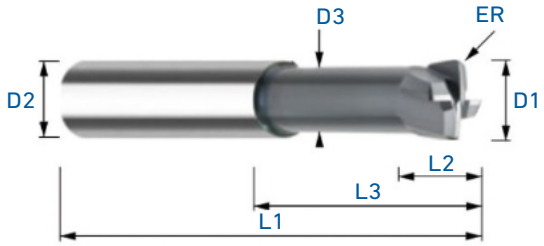
MATERIALI	ISO	SGROSSATURA	FINITURA
STEEL	03		HGH, 060
	05		030
	10		
	20	032, 035	035
	25		
	30		
	35	033, 034	
STAINLESS	03		TPG, 060
	05		030
	10	CRX	CRX
	20		
	25		
	30		
	35	033, 034	
CAST IRON	03	030	HGH
	05		030
	10	029	
	20	035	
	25		
	30		
	35	034	
ALLUMINIUM	03		HGH
	05	030	030
	10	029	029
	20		
	25		
	30		
	35		
TITANIUM	03		
	05		030
	10	030	
	20	CRX	CRX
	25		
	30		
	35		
TEMPERATED	03	TPG, HGH	HGH, TPG
	05	060	060
	10	030	030
	20		
	25		
	30		
	35		

332...



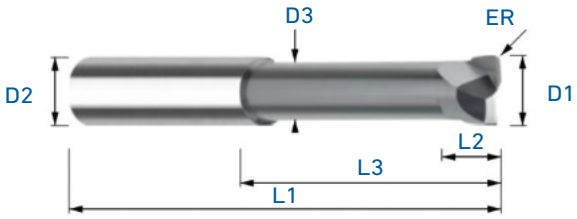
CODICE	D1	D2	L2	L1	D3	L3	ERth	ER	R	Z
332.040.00	4.00	6.00	1.5	57	3.40	20	0.40	0.32	6.0	2
332.060.00	6.00	6.00	2.5	57	5.00	25	0.60	0.50	9.0	2
332.080.00	8.00	8.00	3.0	63	6.70	25	0.80	0.65	12.0	2
332.100.00	10.00	10.00	4.0	72	8.70	35	1.00	0.80	15.0	2
332.120.00	12.00	12.00	5.0	83	10.00	40	1.20	1.00	18.0	2

336...



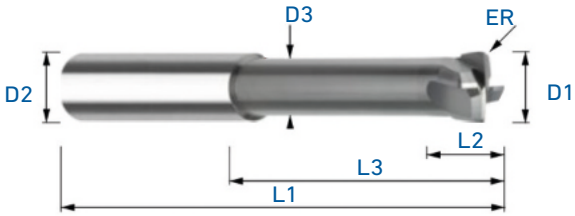
CODICE	D1	D2	L2	L1	D3	L3	ERth	ER	R	Z
336.040.00	4.00	6.00	1.5	57	3.40	20	0.40	0.32	6.0	4
336.050.00	5.00	6.00	2.0	57	4.20	20	0.50	0.40	7.5	4
336.060.00	6.00	6.00	2.5	57	5.00	25	0.60	0.50	9.0	4
336.080.00	8.00	8.00	3.0	63	6.70	25	0.80	0.65	12.0	4
336.100.00	10.00	10.00	4.0	72	8.70	35	1.00	0.80	15.0	4
336.120.00	12.00	12.00	5.0	83	10.00	40	1.20	1.00	18.0	4
336.160.00	16.00	16.00	6.0	92	13.50	45	1.60	1.30	24.0	4

333...

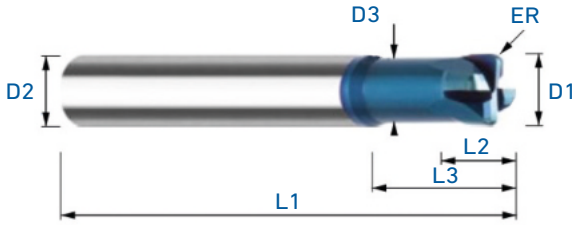


CODICE	D1	D2	L2	L1	D3	L3	ERth	ER	R	Z
333.040.00	4.00	6.00	1.5	80	3.40	40	0.40	0.32	6.0	2
333.060.00	6.00	6.00	2.5	80	5.00	45	0.60	0.50	9.0	2
333.080.00	8.00	8.00	3.0	90	6.70	55	0.80	0.65	12.0	2
333.100.00	10.00	10.00	4.0	100	8.70	60	1.00	0.80	15.0	2
333.120.00	12.00	12.00	5.0	110	10.00	65	1.20	1.00	18.0	2

337...



CODICE	D1	D2	L2	L1	D3	L3	ERth	ER	R	Z
337.040.00	4.00	6.00	1.5	80	3.40	40	0.40	0.32	6.0	4
337.050.00	5.00	6.00	2.0	80	4.20	40	0.50	0.40	7.5	4
337.060.00	6.00	6.00	2.5	80	5.00	45	0.60	0.50	9.0	4
337.080.00	8.00	8.00	3.0	90	6.70	55	0.80	0.65	12.0	4
337.100.00	10.00	10.00	4.0	100	8.70	60	1.00	0.80	15.0	4
337.120.00	12.00	12.00	5.0	110	10.00	65	1.20	1.00	18.0	4
337.160.00	16.00	16.00	6.0	130	13.50	80	1.60	1.30	24.0	4



338...

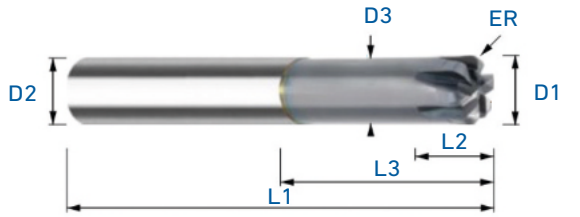
TYP H-N

HSC

HRC 45-65

STEEL

CODICE	D1	D2	L2	L1	D3	L3	ER	Z
338.020.05	2.00	6.00	1.5	50	1.90	6	0.5	4
338.030.05	3.00	6.00	2.0	50	2.80	8	0.5	4
338.040.05	4.00	6.00	4.5	50	3.80	20	0.5	4
338.050.05	5.00	6.00	2.0	60	4.80	10	0.5	4
338.060.05	6.00	6.00	2.5	75	5.40	25	0.5	4
338.060.10	6.00	6.00	2.5	60	5.40	30	1.0	4
338.080.10	8.00	8.00	3.5	75	7.60	40	1.0	4
338.100.10	10.00	10.00	4.0	70	9.00	45	1.0	4
338.100.20	10.00	10.00	4.0	70	9.00	45	2.0	4
338.120.10	12.00	12.00	5.0	100	11.00	62	1.0	4
338.121.20	12.00	12.00	5.0	100	11.00	62	2.0	4
338.120.20	12.00	12.00	5.0	80	11.00	45	2.0	4
338.160.10	16.00	16.00	7.0	120	15.00	70	1.0	4
338.160.20	16.00	16.00	7.0	120	15.00	70	2.0	4
338.200.20	20.00	20.00	8.0	130	19.00	75	2.0	4
338.200.30	20.00	20.00	8.0	130	19.00	75	3.0	4



339...

TYP H

ALTIN

HSC

HRC 45-65

CODICE	D1	D2	L2	L1	D3	L3	ER	Z
339.040.05	4.00	6.00	2.5	60	3.8	15	0.5	6
339.040.10	4.00	6.00	2.5	60	3.8	15	1.0	6
339.060.05	6.00	6.00	3.0	60	5.6	20	0.5	6
339.060.10	6.00	6.00	3.0	60	5.6	20	1.0	6
339.080.05	8.00	8.00	3.5	70	7.6	30	0.5	6
339.080.10	8.00	8.00	3.5	70	7.6	30	1.0	6
339.100.10	10.00	10.00	4.0	75	9.5	35	1.0	6
339.100.20	10.00	10.00	4.0	75	9.5	35	2.0	6
339.120.10	12.00	12.00	4.0	90	11.5	40	1.0	6
339.120.15	12.00	12.00	4.0	90	11.5	40	1.5	6

	MATERIALE	Materiale N.	DIN Descrizione	Rm/UTS (N/mm²)	Velocità di taglio V_c (m/min)	Diametro di taglio (mm) / Avanzamento per dente f_z (mm/z) D 1-4	D 5-10	D 12-20	Profondità di taglio a_p (mm/z)
P	ACCIAIO A BASSA RESISTENZA	1.0570 1.1730	St52-3 C45	-700 -800	300	0.30	0.70	1.00	0.05xd1
		1.0715	9SMn28	-700	11SMn30	0.30	0.70	1.00	
		1.1191 1.7219	Ck45 26CrMo4	500-950	300	0.30	0.70	1.00	
	ACCIAIO MEDIA RESISTENZA	1.7225 1.8159	42CrMo4 51CrV4	500-950	240	0.25	0.60	0.80	
	ACCIAIO	1.0416	GS40	-950	200	0.25	0.60	0.80	
	ACCIAIO TEMPRATO	1.7131	16 MnCr5	-950	240	0.25	0.60	0.80	
	ACCIAIO INOSSIDABILE, FERRITICO, MARTENSITICO	1.4006 1.4104 1.4122	X10Cr13 X12CrMoS17 X35CrMo17	500-950	200	0.25	0.60	0.80	0.045xd1
	ACCIAIO AD ALTA RESISTENZA	1.7225 1.6580	42CrMo4 30CrNiMo8	950-1400	200	0.25	0.60	0.80	
	ACCIAIO NITRURATO, TRATTATO	1.8504 1.2344	34CrAl6 X40CrMoV5.1	950-1400 -900	180	0.25	0.60	0.80	0.04xd1
	ACCIAIO PER UTENSILI	1.2343 1.2316	X38CrMoV51 X38CrMo16	950-1400 -1100	220	0.25	0.60	0.80	
		1.2379 1.2080	X155CrVM0121 X210Cr12	950 950-1400	200	0.20	0.50	0.70	
		1.2358 1.2714 1.2311 1.2312 1.2738	60CrMoV18-5 55NiCrMoV7 40CrMnMo7 40CrMnNiMo8.6 45CrMnNiMo8.6.4	850-1000 1100-1350 -1100 -1150 950-1150	200	0.25	0.60	0.80	
M	ACCIAIO INOSSIDABILE, AUSTENITICO	1.4301 1.4404 1.4571	X2CrNiMo17-12-2 X6CrNiMoTi17-12-2 X10CrNiMoTi18-9-5	500-950	230	0.20	0.50	0.70	0.02xd1
	ACCIAIO INOSSIDABILE, MARTENSITICO	1.2709 1.4542 1.4568	X3NiCoMoTi18-9-5 X5CrNrCuNb16-4 X7CrNiAl17-7	800-1000	230	0.20	0.50	0.70	
K	GHISA GRIGIA	0.6025	GG25	100-400 (120-260 HB)	250	0.50	0.90	1.30	0.04xd1
	GHISA GRIGIA LEGATA	0.6678	GGL-NiCr352	150-250 (160-230 HB)	250	0.45	0.80	1.20	
	GHISA NODULARE	0.7070	GGG70L	400-800 (120-310 HB)	180	0.20	0.50	0.70	
		0.7060	GGG60		180	0.30	0.70	1.00	
	GHISA MALLEABILE	0.8155	GTS55	350-700 (150-280 HB)	150	0.30	0.70	1.00	
H	GHISA SFEROIDALE		Ni-Hard, Ampco	300-600 HB	100	0.20	0.50	0.70	0.03xd1
	ACCIAIO TEMPRATO			45-52 HRC	160-180	0.15	0.30	0.50	
				53-56 HRC	120-160	0.10	0.25	0.40	