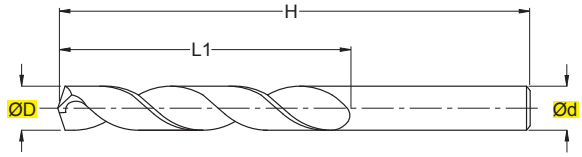
SDR0341

ØD = 3 - 12



TOLLERANZE TOLLERANCE RANGE	D h7	d h7

RIVESTIM. COATED **TIALN**

3xD

DIN 1897

MG

(mm)

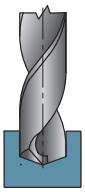
ART.	ØD	Ød	H	L1
SDR0341030	3,0	3,0	46	16
SDR0341031	3,1	3,1	49	18
SDR0341032	3,2	3,2	49	18
SDR0341033	3,3	3,3	49	18
SDR0341034	3,4	3,4	52	20
SDR0341035	3,5	3,5	52	20
SDR0341036	3,6	3,6	52	20
SDR0341037	3,7	3,7	52	20
SDR0341038	3,8	3,8	55	22
SDR0341039	3,9	3,9	55	22
SDR0341040	4,0	4,0	55	22
SDR0341041	4,1	4,1	55	22
SDR0341042	4,2	4,2	55	22
SDR0341043	4,3	4,3	58	24
SDR0341044	4,4	4,4	58	24
SDR0341045	4,5	4,5	58	24
SDR0341046	4,6	4,6	58	24
SDR0341047	4,7	4,7	58	24
SDR0341048	4,8	4,8	62	26
SDR0341049	4,9	4,9	62	26
SDR0341050	5,0	5,0	62	26
SDR0341051	5,1	5,1	62	26
SDR0341052	5,2	5,2	62	26
SDR0341053	5,3	5,3	62	26
SDR0341054	5,4	5,4	66	28
SDR0341055	5,5	5,5	66	28
SDR0341056	5,6	5,6	66	28
SDR0341057	5,7	5,7	66	28
SDR0341058	5,8	5,8	66	28
SDR0341059	5,9	5,9	66	28
SDR0341060	6,0	6,0	66	28
SDR0341061	6,1	6,1	70	31
SDR0341062	6,2	6,2	70	31
SDR0341063	6,3	6,3	70	31
SDR0341064	6,4	6,4	70	31
SDR0341065	6,5	6,5	70	31
SDR0341066	6,6	6,6	70	31
SDR0341067	6,7	6,7	70	31
SDR0341068	6,8	6,8	74	34
SDR0341069	6,9	6,9	74	34
SDR0341070	7,0	7,0	74	34
SDR0341071	7,1	7,1	74	34
SDR0341072	7,2	7,2	74	34
SDR0341073	7,3	7,3	74	34
SDR0341074	7,4	7,4	74	34

(mm)

ART.	ØD	Ød	H	L1
SDR0341075	7,5	7,5	74	34
SDR0341076	7,6	7,6	79	37
SDR0341077	7,7	7,7	79	37
SDR0341078	7,8	7,8	79	37
SDR0341079	7,9	7,9	79	37
SDR0341080	8,0	8,0	79	37
SDR0341081	8,1	8,1	79	37
SDR0341082	8,2	8,2	79	37
SDR0341083	8,3	8,3	79	37
SDR0341084	8,4	8,4	79	37
SDR0341085	8,5	8,5	79	37
SDR0341086	8,6	8,6	84	40
SDR0341087	8,7	8,7	84	40
SDR0341088	8,8	8,8	84	40
SDR0341089	8,9	8,9	84	40
SDR0341090	9,0	9,0	84	40
SDR0341091	9,1	9,1	84	40
SDR0341092	9,2	9,2	84	40
SDR0341093	9,3	9,3	84	40
SDR0341094	9,4	9,4	84	40
SDR0341095	9,5	9,5	84	40
SDR0341096	9,6	9,6	89	43
SDR0341097	9,7	9,7	89	43
SDR0341098	9,8	9,8	89	43
SDR0341099	9,9	9,9	89	43
SDR0341100	10,0	10,0	89	43
SDR0341102	10,2	10,2	89	43
SDR0341105	10,5	10,5	89	43
SDR0341110	11,0	11,0	95	47
SDR0341115	11,5	11,5	95	47
SDR0341120	12,0	12,0	102	51

PAG. H 28

MATERIALI - MATERIALS Pag. H 73

Applicazione - Application	P				M	K			N			S		H	G					
	ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE	(mm) ØD	(m/min) Vc	(mm) fn	(giri/min) (min^{-1}) n	(mm/min) Vf
	●															3÷4	80	0,040	7279	291
	●															4÷5	80	0,050	5662	283
	●															5÷6	80	0,075	4632	347
	●															6÷7	80	0,090	3920	353
	●															7÷8	80	0,110	3397	374
	●															8÷9	80	0,125	2997	375
	●															9÷10	80	0,135	2682	362
	●															10÷12	80	0,150	2316	347
		●														3÷4	60	0,040	5460	218
		●														4÷5	60	0,050	4246	212
		●														5÷6	60	0,075	3474	261
		●														6÷7	60	0,090	2940	265
		●														7÷8	60	0,110	2548	280
		●														8÷9	60	0,125	2248	281
		●														9÷10	60	0,135	2011	272
		●														10÷12	60	0,150	1737	261
						○										3÷4	84	0,045	7643	344
						○										4÷5	84	0,070	5945	416
						○										5÷6	84	0,090	4864	438
						○										6÷7	84	0,110	4116	453
						○										7÷8	84	0,130	3567	464
						○										8÷9	84	0,145	3147	456
						○										9÷10	84	0,155	2816	436
						○										10÷12	84	0,170	2432	413
							○									3÷4	70	0,045	6369	287
							○									4÷5	70	0,070	4954	347
							○									5÷6	70	0,090	4053	365
							○									6÷7	70	0,110	3430	377
							○									7÷8	70	0,130	2972	386
							○									8÷9	70	0,145	2623	380
							○									9÷10	70	0,155	2347	364
							○									10÷12	70	0,170	2027	345
									○							3÷4	130	0,014	11829	166
									○							4÷5	130	0,018	9200	166
									○							5÷6	130	0,025	7528	188
									○							6÷7	130	0,045	6369	287
									○							7÷8	130	0,055	5520	304
									○							8÷9	130	0,065	4871	317
									○							9÷10	130	0,075	4358	327
									○							10÷12	130	0,090	3764	339
										○						3÷4	100	0,006	9099	55
										○						4÷5	100	0,012	7077	85
										○						5÷6	100	0,016	5790	93
										○						6÷7	100	0,025	4900	122
										○						7÷8	100	0,040	4246	170
										○						8÷9	100	0,055	3747	206
										○						9÷10	100	0,065	3352	218
										○						10÷12	100	0,085	2895	246

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

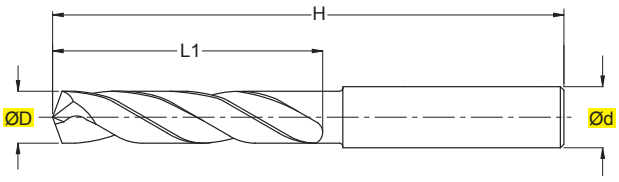
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDR0302

ØD = 3 - 20

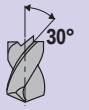
NEW



TOLLERANZE TOLLERANCE RANGE	D m7	d h6

RIVESTIM. COATED
TIALN

3xD



DIN 6535

MG

(mm)

ART.	ØD	Ød	H	L1
SDR0302030	3,0	6	62	20
SDR0302031	3,1	6	62	20
SDR0302032	3,2	6	62	20
SDR0302033	3,3	6	62	20
SDR0302034	3,4	6	62	20
SDR0302035	3,5	6	62	20
SDR0302036	3,6	6	62	20
SDR0302037	3,7	6	62	20
SDR0302038	3,8	6	66	24
SDR0302039	3,9	6	66	24
SDR0302040	4,0	6	66	24
SDR0302041	4,1	6	66	24
SDR0302042	4,2	6	66	24
SDR0302043	4,3	6	66	24
SDR0302044	4,4	6	66	24
SDR0302045	4,5	6	66	24
SDR0302046	4,6	6	66	24
SDR0302047	4,7	6	66	24
SDR0302048	4,8	6	66	28
SDR0302049	4,9	6	66	28
SDR0302050	5,0	6	66	28
SDR0302051	5,1	6	66	28
SDR0302052	5,2	6	66	28
SDR0302053	5,3	6	66	28
SDR0302054	5,4	6	66	28
SDR0302055	5,5	6	66	28
SDR0302056	5,6	6	66	28
SDR0302057	5,7	6	66	28
SDR0302058	5,8	6	66	28
SDR0302059	5,9	6	66	28
* SDR0302060	6,0	6	66	28
SDR0302061	6,1	8	79	34
SDR0302062	6,2	8	79	34
SDR0302063	6,3	8	79	34
SDR0302064	6,4	8	79	34
SDR0302065	6,5	8	79	34
SDR0302066	6,6	8	79	34
SDR0302067	6,7	8	79	34
SDR0302068	6,8	8	79	34
SDR0302069	6,9	8	79	34
SDR0302070	7,0	8	79	34
SDR0302071	7,1	8	79	41
SDR0302072	7,2	8	79	41
SDR0302073	7,3	8	79	41
SDR0302074	7,4	8	79	41

(mm)

ART.	ØD	Ød	H	L1
SDR0302075	7,5	8	79	41
SDR0302076	7,6	8	79	41
SDR0302077	7,7	8	79	41
SDR0302078	7,8	8	79	41
SDR0302079	7,9	8	79	41
* SDR0302080	8,0	8	79	41
SDR0302081	8,1	10	89	47
SDR0302082	8,2	10	89	47
SDR0302083	8,3	10	89	47
SDR0302084	8,4	10	89	47
SDR0302085	8,5	10	89	47
SDR0302086	8,6	10	89	47
SDR0302087	8,7	10	89	47
SDR0302088	8,8	10	89	47
SDR0302089	8,9	10	89	47
SDR0302090	9,0	10	89	47
SDR0302091	9,1	10	89	47
SDR0302092	9,2	10	89	47
SDR0302093	9,3	10	89	47
SDR0302094	9,4	10	89	47
SDR0302095	9,5	10	89	47
SDR0302096	9,6	10	89	47
SDR0302097	9,7	10	89	47
SDR0302098	9,8	10	89	47
SDR0302099	9,9	10	89	47
* SDR0302100	10,0	10	89	47
SDR0302102	10,2	12	102	55
SDR0302105	10,5	12	102	55
SDR0302108	10,8	12	102	55
SDR0302110	11,0	12	102	55
SDR0302112	11,2	12	102	55
SDR0302115	11,5	12	102	55
SDR0302118	11,8	12	102	55
* SDR0302120	12,0	12	102	55
SDR0302122	12,2	14	107	60
SDR0302125	12,5	14	107	60
SDR0302128	12,8	14	107	60
SDR0302130	13,0	14	107	60
SDR0302135	13,5	14	107	60
SDR0302138	13,8	14	107	60
* SDR0302140	14,0	14	107	60
SDR0302142	14,2	16	115	65
SDR0302145	14,5	16	115	65
SDR0302148	14,8	16	115	65
SDR0302150	15,0	16	115	65

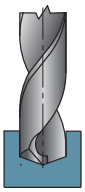
(mm)

ART.	ØD	Ød	H	L1
SDR0302152	15,2	16	115	65
SDR0302155	15,5	16	115	65
SDR0302158	15,8	16	115	65
* SDR0302160	16,0	16	115	65
SDR0302165	16,5	18	123	73
SDR0302168	16,8	18	123	73
SDR0302170	17,0	18	123	73
SDR0302175	17,5	18	123	73
* SDR0302180	18,0	18	123	73
SDR0302185	18,5	20	131	79
SDR0302188	18,8	20	131	79
SDR0302190	19,0	20	131	79
SDR0302195	19,5	20	131	79
* SDR0302200	20,0	20	131	79

* = COSTRUITI IN TOLLERANZA h7
* = MADE WITH h7 TOLERANCE
* = GEBAUT MIT TOLERANZ h7
* = RÉALISÉS EN TOLÉRANCE h7

PAG. H 28

MATERIALI - MATERIALS Pag. H 73

Applicazione - Application	P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
		●														3÷4	90	0,035	8189	287
		●														4÷5	90	0,045	6369	287
		●														5÷6	90	0,060	5211	313
		●														6÷7	90	0,070	4410	309
		●														7÷8	90	0,080	3822	306
		●														8÷9	90	0,100	3372	337
		●														9÷10	90	0,110	3017	332
		●														10÷12	90	0,120	2606	313
		●														12÷14	90	0,130	2205	287
		●														14÷16	90	0,165	1911	315
		●														16÷18	90	0,190	1686	320
		●														18÷20	90	0,210	1509	317
			●													3÷4	80	0,035	7279	255
			●													4÷5	80	0,045	5662	255
			●													5÷6	80	0,060	4632	278
			●													6÷7	80	0,070	3920	274
			●													7÷8	80	0,080	3397	272
			●													8÷9	80	0,100	2997	300
			●													9÷10	80	0,110	2682	295
			●													10÷12	80	0,120	2316	278
			●													12÷14	80	0,130	1960	255
			●													14÷16	80	0,165	1699	280
			●													16÷18	80	0,190	1499	285
			●													18÷20	80	0,210	1341	282
					○											3÷4	40	0,080	3640	291
					○											4÷5	40	0,080	2831	226
					○											5÷6	40	0,120	2316	278
					○											6÷7	40	0,120	1960	235
					○											7÷8	40	0,120	1699	204
					○											8÷9	40	0,150	1499	225
					○											9÷10	40	0,150	1341	201
					○											10÷12	40	0,150	1158	174
					○											12÷14	40	0,200	980	196
					○											14÷16	40	0,200	849	170
					○											16÷18	40	0,250	749	187
					○											18÷20	40	0,250	670	168
						●										3÷4	110	0,090	10009	901
						●										4÷5	110	0,120	7785	934
						●										5÷6	110	0,150	6369	955
						●										6÷7	110	0,170	5390	916
						●										7÷8	110	0,190	4671	887
						●										8÷9	110	0,210	4121	865
						●										9÷10	110	0,230	3688	848
						●										10÷12	110	0,260	3185	828
						●										12÷14	110	0,300	2695	808
						●										14÷16	110	0,340	2335	794
						●										16÷18	110	0,370	2061	762
						●										18÷20	110	0,410	1844	756
							●									3÷4	90	0,090	8189	737
							●									4÷5	90	0,120	6369	764
							●									5÷6	90	0,150	5211	782
							●									6÷7	90	0,170	4410	750
							●									7÷8	90	0,190	3822	726
							●									8÷9	90	0,210	3372	708
							●									9÷10	90	0,230	3017	694
							●									10÷12	90	0,260	2606	677
							●									12÷14	90	0,300	2205	661
							●									14÷16	90	0,340	1911	650
							●									16÷18	90	0,370	1686	624
							●									18÷20	90	0,410	1509	619

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

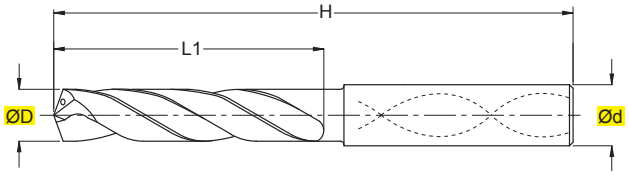
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF0302

ØD = 3 - 20

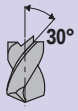
NEW



TOLLERANZE TOLLERANCE RANGE	D m7	d h6

RIVESTIM. COATED **TIALN**

3xD



DIN 6535

MG

(mm)

ART.	ØD	Ød	H	L1
SDF0302030	3,0	6,0	62,0	20,0
SDF0302031	3,1	6,0	62,0	20,0
SDF0302032	3,2	6,0	62,0	20,0
SDF0302033	3,3	6,0	62,0	20,0
SDF0302034	3,4	6,0	62,0	20,0
SDF0302035	3,5	6,0	62,0	20,0
SDF0302036	3,6	6,0	62,0	20,0
SDF0302037	3,7	6,0	62,0	20,0
SDF0302038	3,8	6,0	66,0	24,0
SDF0302039	3,9	6,0	66,0	24,0
SDF0302040	4,0	6,0	66,0	24,0
SDF0302041	4,1	6,0	66,0	24,0
SDF0302042	4,2	6,0	66,0	24,0
SDF0302043	4,3	6,0	66,0	24,0
SDF0302044	4,4	6,0	66,0	24,0
SDF0302045	4,5	6,0	66,0	24,0
SDF0302046	4,6	6,0	66,0	24,0
SDF0302047	4,7	6,0	66,0	24,0
SDF0302048	4,8	6,0	66,0	28,0
SDF0302049	4,9	6,0	66,0	28,0
SDF0302050	5,0	6,0	66,0	28,0
SDF0302051	5,1	6,0	66,0	28,0
SDF0302052	5,2	6,0	66,0	28,0
SDF0302053	5,3	6,0	66,0	28,0
SDF0302054	5,4	6,0	66,0	28,0
SDF0302055	5,5	6,0	66,0	28,0
SDF0302056	5,6	6,0	66,0	28,0
SDF0302057	5,7	6,0	66,0	28,0
SDF0302058	5,8	6,0	66,0	28,0
SDF0302059	5,9	6,0	66,0	28,0
* SDF0302060	6,0	6,0	66,0	28,0
SDF0302061	6,1	8,0	79,0	34,0
SDF0302062	6,2	8,0	79,0	34,0
SDF0302063	6,3	8,0	79,0	34,0
SDF0302064	6,4	8,0	79,0	34,0
SDF0302065	6,5	8,0	79,0	34,0
SDF0302066	6,6	8,0	79,0	34,0
SDF0302067	6,7	8,0	79,0	34,0
SDF0302068	6,8	8,0	79,0	34,0
SDF0302069	6,9	8,0	79,0	34,0
SDF0302070	7,0	8,0	79,0	34,0
SDF0302071	7,1	8,0	79,0	41,0
SDF0302072	7,2	8,0	79,0	41,0
SDF0302073	7,3	8,0	79,0	41,0
SDF0302074	7,4	8,0	79,0	41,0

(mm)

ART.	ØD	Ød	H	L1
SDF0302075	7,5	8,0	79,0	41,0
SDF0302076	7,6	8,0	79,0	41,0
SDF0302077	7,7	8,0	79,0	41,0
SDF0302078	7,8	8,0	79,0	41,0
SDF0302079	7,9	8,0	79,0	41,0
* SDF0302080	8,0	8,0	79,0	41,0
SDF0302081	8,1	10,0	89,0	47,0
SDF0302082	8,2	10,0	89,0	47,0
SDF0302083	8,3	10,0	89,0	47,0
SDF0302084	8,4	10,0	89,0	47,0
SDF0302085	8,5	10,0	89,0	47,0
SDF0302086	8,6	10,0	89,0	47,0
SDF0302087	8,7	10,0	89,0	47,0
SDF0302088	8,8	10,0	89,0	47,0
SDF0302089	8,9	10,0	89,0	47,0
SDF0302090	9,0	10,0	89,0	47,0
SDF0302091	9,1	10,0	89,0	47,0
SDF0302092	9,2	10,0	89,0	47,0
SDF0302093	9,3	10,0	89,0	47,0
SDF0302094	9,4	10,0	89,0	47,0
SDF0302095	9,5	10,0	89,0	47,0
SDF0302096	9,6	10,0	89,0	47,0
SDF0302097	9,7	10,0	89,0	47,0
SDF0302098	9,8	10,0	89,0	47,0
SDF0302099	9,9	10,0	89,0	47,0
* SDF0302100	10,0	10,0	89,0	47,0
SDF0302102	10,2	12,0	102,0	55,0
SDF0302105	10,5	12,0	102,0	55,0
SDF0302108	10,8	12,0	102,0	55,0
SDF0302110	11,0	12,0	102,0	55,0
SDF0302112	11,2	12,0	102,0	55,0
SDF0302115	11,5	12,0	102,0	55,0
SDF0302118	11,8	12,0	102,0	55,0
* SDF0302120	12,0	12,0	102,0	55,0
SDF0302122	12,2	14,0	107,0	60,0
SDF0302125	12,5	14,0	107,0	60,0
SDF0302128	12,8	14,0	107,0	60,0
SDF0302130	13,0	14,0	107,0	60,0
SDF0302135	13,5	14,0	107,0	60,0
SDF0302138	13,8	14,0	107,0	60,0
* SDF0302140	14,0	14,0	107,0	60,0
SDF0302142	14,2	16,0	115,0	65,0
SDF0302145	14,5	16,0	115,0	65,0
SDF0302148	14,8	16,0	115,0	65,0
SDF0302150	15,0	16,0	115,0	65,0

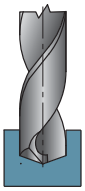
(mm)

ART.	ØD	Ød	H	L1
SDF0302152	15,2	16,0	115,0	65,0
SDF0302155	15,5	16,0	115,0	65,0
SDF0302158	15,8	16,0	115,0	65,0
* SDF0302160	16,0	16,0	115,0	65,0
SDF0302165	16,5	18,0	123,0	73,0
SDF0302170	17,0	18,0	123,0	73,0
SDF0302175	17,5	18,0	123,0	73,0
* SDF0302180	18,0	18,0	123,0	73,0
SDF0302185	18,5	20,0	131,0	79,0
SDF0302190	19,0	20,0	131,0	79,0
SDF0302195	19,5	20,0	131,0	79,0
* SDF0302200	20,0	20,0	131,0	79,0

* = COSTRUITI IN TOLLERANZA h7
* = MADE WITH h7 TOLERANCE
* = GEBAUT MIT TOLERANZ h7
* = RÉALISÉS EN TOLÉRANCE h7

PAG. H 28

MATERIALI - MATERIALS Pag. B 73

Applicazione - Application	P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALLUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●															3÷4	120	0,160	10919	1747
	●															4÷5	120	0,160	8493	1359
	●															5÷6	120	0,220	6948	1529
	●															6÷7	120	0,220	5879	1293
	●															7÷8	120	0,220	5096	1121
	●															8÷9	120	0,280	4496	1259
	●															9÷10	120	0,280	4023	1126
	●															10÷12	120	0,280	3474	973
	●															12÷14	120	0,340	2940	1000
	●															14÷16	120	0,340	2548	866
	●															16÷18	120	0,380	2248	854
	●															18÷20	120	0,380	2011	764
		●														3÷4	110	0,080	10009	801
		●														4÷5	110	0,080	7785	623
		●														5÷6	110	0,120	6369	764
		●														6÷7	110	0,120	5390	647
		●														7÷8	110	0,120	4671	561
		●														8÷9	110	0,150	4121	618
		●														9÷10	110	0,150	3688	553
		●														10÷12	110	0,150	3185	478
		●														12÷14	110	0,200	2695	539
		●														14÷16	110	0,200	2335	467
		●														16÷18	110	0,250	2061	515
		●														18÷20	110	0,250	1844	461
			●													3÷4	70	0,080	6369	510
			●													4÷5	70	0,080	4954	396
			●													5÷6	70	0,120	4053	486
			●													6÷7	70	0,120	3430	412
			●													7÷8	70	0,120	2972	357
			●													8÷9	70	0,150	2623	393
			●													9÷10	70	0,150	2347	352
			●													10÷12	70	0,150	2027	304
			●													12÷14	70	0,200	1715	343
			●													14÷16	70	0,200	1486	297
			●													16÷18	70	0,250	1311	328
			●													18÷20	70	0,250	1173	293
					●											3÷4	45	0,080	4095	328
					●											4÷5	45	0,080	3185	255
					●											5÷6	45	0,120	2606	313
					●											6÷7	45	0,120	2205	265
					●											7÷8	45	0,120	1911	229
					●											8÷9	45	0,150	1686	253
					●											9÷10	45	0,150	1509	226
					●											10÷12	45	0,150	1303	195
					●											12÷14	45	0,200	1102	220
					●											14÷16	45	0,200	955	191
					●											16÷18	45	0,250	843	211
					●											18÷20	45	0,250	754	189
							●									3÷4	110	0,125	10009	1251
							●									4÷5	110	0,125	7785	973
							●									5÷6	110	0,175	6369	1115
							●									6÷7	110	0,175	5390	943
							●									7÷8	110	0,175	4671	817
							●									8÷9	110	0,225	4121	927
							●									9÷10	110	0,225	3688	830
							●									10÷12	110	0,225	3185	717
							●									12÷14	110	0,300	2695	808
							●									14÷16	110	0,300	2335	701
							●									16÷18	110	0,375	2061	773
							●									18÷20	110	0,375	1844	691
													○			3÷4	30	0,040	2730	109
													○			4÷5	30	0,040	2123	85
													○			5÷6	30	0,080	1737	139
													○			6÷7	30	0,080	1470	118
													○			7÷8	30	0,080	1274	102
													○			8÷9	30	0,120	1124	135
													○			9÷10	30	0,120	1006	121
													○			10÷12	30	0,120	869	104
													○			12÷14	30	0,160	735	118
													○			14÷16	30	0,160	637	102
													○			16÷18	30	0,200	562	112
													○			18÷20	30	0,200	503	101

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

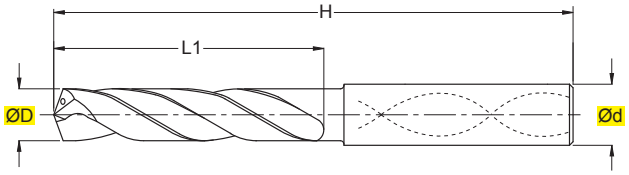
Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF0371

DISPONIBILE DA SETTEMBRE 2014
AVAILABLE FROM SEPTEMBER 2014
AB SEPTEMBER 2014 LIEFERBAR
DISPONIBLE À PARTIR DE SEPTEMBRE 2014

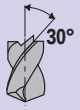
ØD = 2 - 12

NEW



RIVESTIM. COATED
TIALN

3xD



DIN 6535

MG

PER PREPARAZIONE FORI ≥ 16xD
FOR THE PREPARATION OF BORES ≥ 16xD
ZUR VORBEREITUNG VON BOHRUNGEN ≥ 16xD
POUR LA PRÉPARATION DE TROUS ≥ 16xD

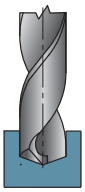
TOLLERANZE	D	d
TOLLERANCE RANGE	+0,030 +0,005	h6

(mm)

ART.	ØD	Ød	H	L1
SDF0371020	2,0	4	50,0	12,0
SDF0371022	2,2	4	50,0	12,0
SDF0371023	2,3	4	50,0	12,0
SDF0371024	2,4	4	50,0	12,0
SDF0371025	2,5	4	50,0	12,0
SDF0371027	2,7	4	50,0	12,0
SDF0371028	2,8	4	50,0	12,0
SDF0371030	3,0	6	62,0	20,0
SDF0371032	3,2	6	62,0	20,0
SDF0371033	3,3	6	62,0	20,0
SDF0371035	3,5	6	62,0	20,0
SDF0371038	3,8	6	66,0	24,0
SDF0371040	4,0	6	66,0	24,0
SDF0371042	4,2	6	66,0	24,0
SDF0371045	4,5	6	66,0	24,0
SDF0371048	4,8	6	66,0	28,0
SDF0371050	5,0	6	66,0	28,0
SDF0371055	5,5	6	66,0	28,0
SDF0371058	5,8	6	66,0	28,0
SDF0371060	6,0	6	66,0	28,0
SDF0371065	6,5	8	79,0	34,0
SDF0371068	6,8	8	79,0	34,0
SDF0371070	7,0	8	79,0	34,0
SDF0371075	7,5	8	79,0	41,0
SDF0371078	7,8	8	79,0	41,0
SDF0371080	8,0	8	79,0	41,0
SDF0371085	8,5	10	89,0	47,0
SDF0371088	8,8	10	89,0	47,0
SDF0371090	9,0	10	89,0	47,0
SDF0371098	9,8	10	89,0	47,0
SDF0371100	10,0	10	89,0	47,0
SDF0371102	10,2	12	102,0	55,0
SDF0371108	10,8	12	102,0	55,0
SDF0371118	11,8	12	102,0	55,0
SDF0371120	12,0	12	102,0	55,0

PAG. H 28

MATERIALI - MATERIALS Pag. H 73

Applicazione - Application	P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●															2÷3	120	0,130	15287	1987
	●															3÷4	120	0,150	10919	1638
	●															4÷5	120	0,170	8493	1444
	●															5÷6	120	0,200	6948	1390
	●															6÷7	120	0,230	5879	1352
	●															7÷8	120	0,260	5096	1325
	●															8÷9	120	0,300	4496	1349
	●															9÷10	120	0,330	4023	1328
	●															10÷11	120	0,350	3640	1274
	●															11÷12	120	0,380	3323	1263
		●														2÷3	110	0,130	14013	1822
		●														3÷4	110	0,150	10009	1501
		●														4÷5	110	0,170	7785	1323
		●														5÷6	110	0,200	6369	1274
		●														6÷7	110	0,230	5390	1240
		●														7÷8	110	0,260	4671	1214
		●														8÷9	110	0,300	4121	1236
		●														9÷10	110	0,330	3688	1217
		●														10÷11	110	0,350	3336	1168
		●														11÷12	110	0,380	3046	1158
					●											2÷3	45	0,100	5732	573
					●											3÷4	45	0,110	4095	450
					●											4÷5	45	0,130	3185	414
					●											5÷6	45	0,150	2606	391
					●											6÷7	45	0,170	2205	375
					●											7÷8	45	0,200	1911	382
					●											8÷9	45	0,220	1686	371
					●											9÷10	45	0,250	1509	377
					●											10÷11	45	0,270	1365	369
					●											11÷12	45	0,280	1246	349
						●										2÷3	120	0,130	15287	1987
						●										3÷4	120	0,150	10919	1638
						●										4÷5	120	0,170	8493	1444
						●										5÷6	120	0,200	6948	1390
						●										6÷7	120	0,230	5879	1352
						●										7÷8	120	0,260	5096	1325
						●										8÷9	120	0,300	4496	1349
						●										9÷10	120	0,330	4023	1328
						●										10÷11	120	0,350	3640	1274
						●										11÷12	120	0,380	3323	1263
							●									2÷3	110	0,100	14013	1401
							●									3÷4	110	0,110	10009	1101
							●									4÷5	110	0,130	7785	1012
							●									5÷6	110	0,150	6369	955
							●									6÷7	110	0,170	5390	916
							●									7÷8	110	0,200	4671	934
							●									8÷9	110	0,220	4121	907
							●									9÷10	110	0,250	3688	922
							●									10÷11	110	0,270	3336	901
							●									11÷12	110	0,280	3046	853

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

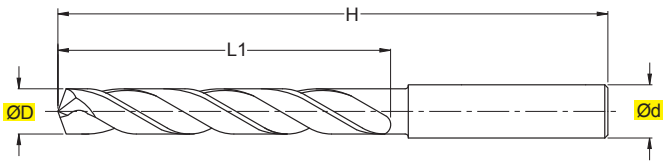
○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDR0502

ØD = 3 - 20

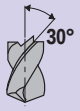
NEW



TOLLERANZE TOLLERANCE RANGE	D m7	d h6

RIVESTIM. COATED **TIALN**

5xD



DIN 6535

MG

(mm)

ART.	ØD	Ød	H	L1
SDR0502030	3,0	6,0	66,0	28,0
SDR0502031	3,1	6,0	66,0	28,0
SDR0502032	3,2	6,0	66,0	28,0
SDR0502033	3,3	6,0	66,0	28,0
SDR0502034	3,4	6,0	66,0	28,0
SDR0502035	3,5	6,0	66,0	28,0
SDR0502036	3,6	6,0	66,0	28,0
SDR0502037	3,7	6,0	66,0	28,0
SDR0502038	3,8	6,0	74,0	36,0
SDR0502039	3,9	6,0	74,0	36,0
SDR0502040	4,0	6,0	74,0	36,0
SDR0502041	4,1	6,0	74,0	36,0
SDR0502042	4,2	6,0	74,0	36,0
SDR0502043	4,3	6,0	74,0	36,0
SDR0502044	4,4	6,0	74,0	36,0
SDR0502045	4,5	6,0	74,0	36,0
SDR0502046	4,6	6,0	74,0	36,0
SDR0502047	4,7	6,0	74,0	36,0
SDR0502048	4,8	6,0	82,0	44,0
SDR0502049	4,9	6,0	82,0	44,0
SDR0502050	5,0	6,0	82,0	44,0
SDR0502051	5,1	6,0	82,0	44,0
SDR0502052	5,2	6,0	82,0	44,0
SDR0502053	5,3	6,0	82,0	44,0
SDR0502054	5,4	6,0	82,0	44,0
SDR0502055	5,5	6,0	82,0	44,0
SDR0502056	5,6	6,0	82,0	44,0
SDR0502057	5,7	6,0	82,0	44,0
SDR0502058	5,8	6,0	82,0	44,0
SDR0502059	5,9	6,0	82,0	44,0
* SDR0502060	6,0	6,0	82,0	44,0
SDR0502061	6,1	8,0	91,0	53,0
SDR0502062	6,2	8,0	91,0	53,0
SDR0502063	6,3	8,0	91,0	53,0
SDR0502064	6,4	8,0	91,0	53,0
SDR0502065	6,5	8,0	91,0	53,0
SDR0502066	6,6	8,0	91,0	53,0
SDR0502067	6,7	8,0	91,0	53,0
SDR0502068	6,8	8,0	91,0	53,0
SDR0502069	6,9	8,0	91,0	53,0
SDR0502070	7,0	8,0	91,0	53,0
SDR0502071	7,1	8,0	91,0	53,0
SDR0502072	7,2	8,0	91,0	53,0
SDR0502073	7,3	8,0	91,0	53,0
SDR0502074	7,4	8,0	91,0	53,0

(mm)

ART.	ØD	Ød	H	L1
SDR0502075	7,5	8,0	91,0	53,0
SDR0502076	7,6	8,0	91,0	53,0
SDR0502077	7,7	8,0	91,0	53,0
SDR0502078	7,8	8,0	91,0	53,0
SDR0502079	7,9	8,0	91,0	53,0
* SDR0502080	8,0	8,0	91,0	53,0
SDR0502081	8,1	10,0	103,0	61,0
SDR0502082	8,2	10,0	103,0	61,0
SDR0502083	8,3	10,0	103,0	61,0
SDR0502084	8,4	10,0	103,0	61,0
SDR0502085	8,5	10,0	103,0	61,0
SDR0502086	8,6	10,0	103,0	61,0
SDR0502087	8,7	10,0	103,0	61,0
SDR0502088	8,8	10,0	103,0	61,0
SDR0502089	8,9	10,0	103,0	61,0
SDR0502090	9,0	10,0	103,0	61,0
SDR0502091	9,1	10,0	103,0	61,0
SDR0502092	9,2	10,0	103,0	61,0
SDR0502093	9,3	10,0	103,0	61,0
SDR0502094	9,4	10,0	103,0	61,0
SDR0502095	9,5	10,0	103,0	61,0
SDR0502096	9,6	10,0	103,0	61,0
SDR0502097	9,7	10,0	103,0	61,0
SDR0502098	9,8	10,0	103,0	61,0
SDR0502099	9,9	10,0	103,0	61,0
* SDR0502100	10,0	10,0	103,0	61,0
SDR0502102	10,2	12,0	118,0	71,0
SDR0502105	10,5	12,0	118,0	71,0
SDR0502108	10,8	12,0	118,0	71,0
SDR0502110	11,0	12,0	118,0	71,0
SDR0502112	11,2	12,0	118,0	71,0
SDR0502115	11,5	12,0	118,0	71,0
SDR0502118	11,8	12,0	118,0	71,0
* SDR0502120	12,0	12,0	118,0	71,0
SDR0502122	12,2	14,0	124,0	77,0
SDR0502125	12,5	14,0	124,0	77,0
SDR0502128	12,8	14,0	124,0	77,0
SDR0502130	13,0	14,0	124,0	77,0
SDR0502132	13,2	14,0	124,0	77,0
SDR0502135	13,5	14,0	124,0	77,0
SDR0502138	13,8	14,0	124,0	77,0
* SDR0502140	14,0	14,0	124,0	77,0
SDR0502142	14,2	16,0	133,0	83,0
SDR0502145	14,5	16,0	133,0	83,0
SDR0502148	14,8	16,0	133,0	83,0

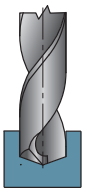
(mm)

ART.	ØD	Ød	H	L1
SDR0502150	15,0	16,0	133,0	83,0
SDR0502152	15,2	16,0	133,0	83,0
SDR0502155	15,5	16,0	133,0	83,0
SDR0502158	15,8	16,0	133,0	83,0
* SDR0502160	16,0	16,0	133,0	83,0
SDR0502165	16,5	18,0	143,0	93,0
SDR0502170	17,0	18,0	143,0	93,0
SDR0502175	17,5	18,0	143,0	93,0
* SDR0502180	18,0	18,0	143,0	93,0
SDR0502185	18,5	20,0	153,0	101,0
SDR0502190	19,0	20,0	153,0	101,0
SDR0502195	19,5	20,0	153,0	101,0
* SDR0502200	20,0	20,0	153,0	101,0

* = COSTRUITI IN TOLLERANZA h7
* = MADE WITH h7 TOLERANCE
* = GEBAUT MIT TOLERANZ h7
* = RÉALISÉS EN TOLÉRANCE h7

PAG. H 28

MATERIALI - MATERIALS Pag. H 73

Applicazione - Application	P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
		●														3÷4	90	0,035	8189	287
		●														4÷5	90	0,045	6369	287
		●														5÷6	90	0,060	5211	313
		●														6÷7	90	0,070	4410	309
		●														7÷8	90	0,080	3822	306
		●														8÷9	90	0,100	3372	337
		●														9÷10	90	0,110	3017	332
		●														10÷12	90	0,120	2606	313
		●														12÷14	90	0,130	2205	287
		●														14÷16	90	0,165	1911	315
		●														16÷18	90	0,190	1686	320
		●														18÷20	90	0,210	1509	317
			●													3÷4	80	0,035	7279	255
			●													4÷5	80	0,045	5662	255
			●													5÷6	80	0,060	4632	278
			●													6÷7	80	0,070	3920	274
			●													7÷8	80	0,080	3397	272
			●													8÷9	80	0,100	2997	300
			●													9÷10	80	0,110	2682	295
			●													10÷12	80	0,120	2316	278
			●													12÷14	80	0,130	1960	255
			●													14÷16	80	0,165	1699	280
			●													16÷18	80	0,190	1499	285
			●													18÷20	80	0,210	1341	282
					○											3÷4	40	0,080	3640	291
					○											4÷5	40	0,080	2831	226
					○											5÷6	40	0,120	2316	278
					○											6÷7	40	0,120	1960	235
					○											7÷8	40	0,120	1699	204
					○											8÷9	40	0,150	1499	225
					○											9÷10	40	0,150	1341	201
					○											10÷12	40	0,150	1158	174
					○											12÷14	40	0,200	980	196
					○											14÷16	40	0,200	849	170
					○											16÷18	40	0,250	749	187
					○											18÷20	40	0,250	670	168
						○										3÷4	110	0,090	10009	901
						○										4÷5	110	0,120	7785	934
						○										5÷6	110	0,150	6369	955
						○										6÷7	110	0,170	5390	916
						○										7÷8	110	0,190	4671	887
						○										8÷9	110	0,210	4121	865
						○										9÷10	110	0,230	3688	848
						○										10÷12	110	0,260	3185	828
						○										12÷14	110	0,300	2695	808
						○										14÷16	110	0,340	2335	794
						○										16÷18	110	0,370	2061	762
						○										18÷20	110	0,410	1844	756
							○									3÷4	90	0,090	8189	737
							○									4÷5	90	0,120	6369	764
							○									5÷6	90	0,150	5211	782
							○									6÷7	90	0,170	4410	750
							○									7÷8	90	0,190	3822	726
							○									8÷9	90	0,210	3372	708
							○									9÷10	90	0,230	3017	694
							○									10÷12	90	0,260	2606	677
							○									12÷14	90	0,300	2205	661
							○									14÷16	90	0,340	1911	650
							○									16÷18	90	0,370	1686	624
							○									18÷20	90	0,410	1509	619

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

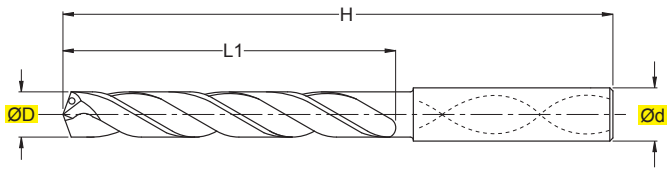
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

QUALITY TOOLS ENGINEERING

SDF0502

ØD = 3 - 20

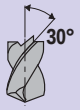
NEW



TOLLERANZE TOLLERANCE RANGE	D m7	d h6

RIVESTIM. COATED
TIALN

5xD



DIN 6535

MG

(mm)

ART.	ØD	Ød	H	L1
SDF0502030	3,0	6	66	28
SDF0502031	3,1	6	66	28
SDF0502032	3,2	6	66	28
SDF0502033	3,3	6	66	28
SDF0502034	3,4	6	66	28
SDF0502035	3,5	6	66	28
SDF0502036	3,6	6	66	28
SDF0502037	3,7	6	66	28
SDF0502038	3,8	6	74	36
SDF0502039	3,9	6	74	36
SDF0502040	4,0	6	74	36
SDF0502041	4,1	6	74	36
SDF0502042	4,2	6	74	36
SDF0502043	4,3	6	74	36
SDF0502044	4,4	6	74	36
SDF0502045	4,5	6	74	36
SDF0502046	4,6	6	74	36
SDF0502047	4,7	6	74	36
SDF0502048	4,8	6	82	44
SDF0502049	4,9	6	82	44
SDF0502050	5,0	6	82	44
SDF0502051	5,1	6	82	44
SDF0502052	5,2	6	82	44
SDF0502053	5,3	6	82	44
SDF0502054	5,4	6	82	44
SDF0502055	5,5	6	82	44
SDF0502056	5,6	6	82	44
SDF0502057	5,7	6	82	44
SDF0502058	5,8	6	82	44
SDF0502059	5,9	6	82	44
* SDF0502060	6,0	6	82	44
SDF0502061	6,1	8	91	53
SDF0502062	6,2	8	91	53
SDF0502063	6,3	8	91	53
SDF0502064	6,4	8	91	53
SDF0502065	6,5	8	91	53
SDF0502066	6,6	8	91	53
SDF0502067	6,7	8	91	53
SDF0502068	6,8	8	91	53
SDF0502069	6,9	8	91	53
SDF0502070	7,0	8	91	53
SDF0502071	7,1	8	91	53
SDF0502072	7,2	8	91	53
SDF0502073	7,3	8	91	53
SDF0502074	7,4	8	91	53

(mm)

ART.	ØD	Ød	H	L1
SDF0502075	7,5	8	91	53
SDF0502076	7,6	8	91	53
SDF0502077	7,7	8	91	53
SDF0502078	7,8	8	91	53
SDF0502079	7,9	8	91	53
* SDF0502080	8,0	8	91	53
SDF0502081	8,1	10	103	61
SDF0502082	8,2	10	103	61
SDF0502083	8,3	10	103	61
SDF0502084	8,4	10	103	61
SDF0502085	8,5	10	103	61
SDF0502086	8,6	10	103	61
SDF0502087	8,7	10	103	61
SDF0502088	8,8	10	103	61
SDF0502089	8,9	10	103	61
SDF0502090	9,0	10	103	61
SDF0502091	9,1	10	103	61
SDF0502092	9,2	10	103	61
SDF0502093	9,3	10	103	61
SDF0502094	9,4	10	103	61
SDF0502095	9,5	10	103	61
SDF0502096	9,6	10	103	61
SDF0502097	9,7	10	103	61
SDF0502098	9,8	10	103	61
SDF0502099	9,9	10	103	61
* SDF0502100	10,0	10	103	61
SDF0502102	10,2	12	118	71
SDF0502103	10,3	12	118	71
SDF0502105	10,5	12	118	71
SDF0502108	10,8	12	118	71
SDF0502110	11,0	12	118	71
SDF0502112	11,2	12	118	71
SDF0502115	11,5	12	118	71
SDF0502118	11,8	12	118	71
* SDF0502120	12,0	12	118	71
SDF0502122	12,2	14	124	77
SDF0502125	12,5	14	124	77
SDF0502128	12,8	14	124	77
SDF0502130	13,0	14	124	77
SDF0502132	13,2	14	124	77
SDF0502135	13,5	14	124	77
SDF0502138	13,8	14	124	77
* SDF0502140	14,0	14	124	77
SDF0502142	14,2	16	133	83
SDF0502145	14,5	16	133	83

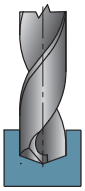
(mm)

ART.	ØD	Ød	H	L1
SDF0502148	14,8	16	133	83
SDF0502150	15,0	16	133	83
SDF0502152	15,2	16	133	83
SDF0502155	15,5	16	133	83
SDF0502158	15,8	16	133	83
* SDF0502160	16,0	16	133	83
SDF0502165	16,5	18	143	93
SDF0502170	17,0	18	143	93
SDF0502175	17,5	18	143	93
* SDF0502180	18,0	18	143	93
SDF0502185	18,5	20	153	101
SDF0502190	19,0	20	153	101
SDF0502195	19,5	20	153	101
* SDF0502200	20,0	20	153	101

* = COSTRUITI IN TOLLERANZA h7
* = MADE WITH h7 TOLERANCE
* = GEBAUT MIT TOLERANZ h7
* = RÉALISÉS EN TOLÉRANCE h7

PAG. H 28

MATERIALI - MATERIALS Pag. H 73

Applicazione - Application	P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALLUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●															3÷4	120	0,160	10919	1747
	●															4÷5	120	0,160	8493	1359
	●															5÷6	120	0,220	6948	1529
	●															6÷7	120	0,220	5879	1293
	●															7÷8	120	0,220	5096	1121
	●															8÷9	120	0,280	4496	1259
	●															9÷10	120	0,280	4023	1126
	●															10÷12	120	0,280	3474	973
	●															12÷14	120	0,340	2940	1000
	●															14÷16	120	0,340	2548	866
	●															16÷18	120	0,380	2248	854
	●															18÷20	120	0,380	2011	764
		●														3÷4	110	0,080	10009	801
		●														4÷5	110	0,080	7785	623
		●														5÷6	110	0,120	6369	764
		●														6÷7	110	0,120	5390	647
		●														7÷8	110	0,120	4671	561
		●														8÷9	110	0,150	4121	618
		●														9÷10	110	0,150	3688	553
		●														10÷12	110	0,150	3185	478
		●														12÷14	110	0,200	2695	539
		●														14÷16	110	0,200	2335	467
		●														16÷18	110	0,250	2061	515
		●														18÷20	110	0,250	1844	461
			●													3÷4	70	0,080	6369	510
			●													4÷5	70	0,080	4954	396
			●													5÷6	70	0,120	4053	486
			●													6÷7	70	0,120	3430	412
			●													7÷8	70	0,120	2972	357
			●													8÷9	70	0,150	2623	393
			●													9÷10	70	0,150	2347	352
			●													10÷12	70	0,150	2027	304
			●													12÷14	70	0,200	1715	343
			●													14÷16	70	0,200	1486	297
			●													16÷18	70	0,250	1311	328
			●													18÷20	70	0,250	1173	293
					○											3÷4	45	0,080	4095	328
					○											4÷5	45	0,080	3185	255
					○											5÷6	45	0,120	2606	313
					○											6÷7	45	0,120	2205	265
					○											7÷8	45	0,120	1911	229
					○											8÷9	45	0,150	1686	253
					○											9÷10	45	0,150	1509	226
					○											10÷12	45	0,150	1303	195
					○											12÷14	45	0,200	1102	220
					○											14÷16	45	0,200	955	191
					○											16÷18	45	0,250	843	211
					○											18÷20	45	0,250	754	189
							○									3÷4	110	0,125	10009	1251
							○									4÷5	110	0,125	7785	973
							○									5÷6	110	0,175	6369	1115
							○									6÷7	110	0,175	5390	943
							○									7÷8	110	0,175	4671	817
							○									8÷9	110	0,225	4121	927
							○									9÷10	110	0,225	3688	830
							○									10÷12	110	0,225	3185	717
							○									12÷14	110	0,300	2695	808
							○									14÷16	110	0,300	2335	701
							○									16÷18	110	0,375	2061	773
							○									18÷20	110	0,375	1844	691
													○			3÷4	30	0,040	2730	109
													○			4÷5	30	0,040	2123	85
													○			5÷6	30	0,080	1737	139
													○			6÷7	30	0,080	1470	118
													○			7÷8	30	0,080	1274	102
													○			8÷9	30	0,120	1124	135
													○			9÷10	30	0,120	1006	121
													○			10÷12	30	0,120	869	104
													○			12÷14	30	0,160	735	118
													○			14÷16	30	0,160	637	102
													○			16÷18	30	0,200	562	112
													○			18÷20	30	0,200	503	101

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

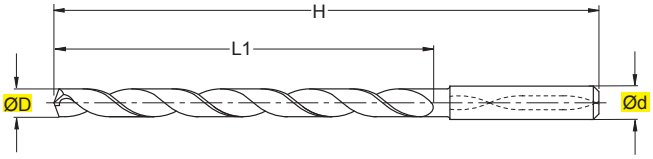
○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF0802

ØD = 3 - 16

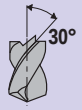
NEW



TOLLERANZE TOLLERANCE RANGE	D m7	d h6

RIVESTIM. COATED **TIALN**

8xD



DIN 6535

MG

(mm)

ART.	ØD	Ød	H	L1
SDF0802030	3,0	6	74	34
SDF0802031	3,1	6	74	34
SDF0802032	3,2	6	74	34
SDF0802033	3,3	6	74	34
SDF0802034	3,4	6	74	34
SDF0802035	3,5	6	74	34
SDF0802036	3,6	6	74	34
SDF0802037	3,7	6	74	34
SDF0802038	3,8	6	85	45
SDF0802039	3,9	6	85	45
SDF0802040	4,0	6	85	45
SDF0802041	4,1	6	85	45
SDF0802042	4,2	6	85	45
SDF0802043	4,3	6	85	45
SDF0802044	4,4	6	85	45
SDF0802045	4,5	6	85	45
SDF0802046	4,6	6	85	45
SDF0802047	4,7	6	85	45
SDF0802048	4,8	6	97	57
SDF0802049	4,9	6	97	57
SDF0802050	5,0	6	97	57
SDF0802051	5,1	6	97	57
SDF0802052	5,2	6	97	57
SDF0802053	5,3	6	97	57
SDF0802054	5,4	6	97	57
SDF0802055	5,5	6	97	57
SDF0802056	5,6	6	97	57
SDF0802057	5,7	6	97	57
SDF0802058	5,8	6	97	57
SDF0802059	5,9	6	97	57
* SDF0802060	6,0	6	97	57
SDF0802061	6,1	8	106	66
SDF0802062	6,2	8	106	66
SDF0802063	6,3	8	106	66
SDF0802064	6,4	8	106	66
SDF0802065	6,5	8	106	66
SDF0802066	6,6	8	106	66
SDF0802067	6,7	8	106	66
SDF0802068	6,8	8	106	66
SDF0802069	6,9	8	106	66
SDF0802070	7,0	8	106	66
SDF0802071	7,1	8	116	76
SDF0802072	7,2	8	116	76
SDF0802073	7,3	8	116	76
SDF0802074	7,4	8	116	76

(mm)

ART.	ØD	Ød	H	L1
SDF0802075	7,5	8	116	76
SDF0802076	7,6	8	116	76
SDF0802077	7,7	8	116	76
SDF0802078	7,8	8	116	76
SDF0802079	7,9	8	116	76
* SDF0802080	8,0	8	116	76
SDF0802081	8,1	10	139	95
SDF0802082	8,2	10	139	95
SDF0802083	8,3	10	139	95
SDF0802084	8,4	10	139	95
SDF0802085	8,5	10	139	95
SDF0802086	8,6	10	139	95
SDF0802087	8,7	10	139	95
SDF0802088	8,8	10	139	95
SDF0802089	8,9	10	139	95
SDF0802090	9,0	10	139	95
SDF0802091	9,1	10	139	95
SDF0802092	9,2	10	139	95
SDF0802093	9,3	10	139	95
SDF0802094	9,4	10	139	95
SDF0802095	9,5	10	139	95
SDF0802096	9,6	10	139	95
SDF0802097	9,7	10	139	95
SDF0802098	9,8	10	139	95
SDF0802099	9,9	10	139	95
* SDF0802100	10,0	10	139	95
SDF0802101	10,1	12	163	114
SDF0802102	10,2	12	163	114
SDF0802103	10,3	12	163	114
SDF0802104	10,4	12	163	114
SDF0802105	10,5	12	163	114
SDF0802106	10,6	12	163	114
SDF0802107	10,7	12	163	114
SDF0802108	10,8	12	163	114
SDF0802109	10,9	12	163	114
SDF0802110	11,0	12	163	114
SDF0802111	11,1	12	163	114
SDF0802112	11,2	12	163	114
SDF0802113	11,3	12	163	114
SDF0802114	11,4	12	163	114
SDF0802115	11,5	12	163	114
SDF0802116	11,6	12	163	114
SDF0802117	11,7	12	163	114
SDF0802118	11,8	12	163	114
SDF0802119	11,9	12	163	114

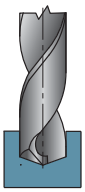
(mm)

ART.	ØD	Ød	H	L1
* SDF0802120	12,0	12	163	114
SDF0802125	12,5	14	182	133
SDF0802128	12,8	14	178	133
SDF0802130	13,0	14	182	133
SDF0802135	13,5	14	182	133
SDF0802138	13,8	14	178	133
* SDF0802140	14,0	14	182	133
SDF0802145	14,5	16	204	152
SDF0802148	14,8	16	203	152
SDF0802150	15,0	16	204	152
SDF0802155	15,5	16	203	152
SDF0802158	15,8	16	203	152
* SDF0802160	16,0	16	204	152

* = COSTRUITI IN TOLLERANZA h7
* = MADE WITH h7 TOLERANCE
* = GEBAUT MIT TOLERANZ h7
* = RÉALISÉS EN TOLÉRANCE h7

PAG. H 28

MATERIALI - MATERIALS Pag. H 73

Applicazione - Application	P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●															3÷4	85	0,050	7734	387
	●															4÷5	85	0,080	6016	481
	●															5÷6	85	0,110	4922	541
	●															6÷7	85	0,130	4165	541
	●															7÷8	85	0,150	3609	541
	●															8÷9	85	0,170	3185	541
	●															9÷10	85	0,190	2849	541
	●															10÷11	85	0,200	2707	541
	●															11÷12	85	0,210	2461	517
	●															12÷13	85	0,220	2256	496
	●															13÷14	85	0,230	2082	479
	●															14÷15	85	0,240	1934	464
	●															15÷16	85	0,250	1805	451
		●														3÷4	75	0,035	6824	239
		●														4÷5	75	0,045	5308	239
		●														5÷6	75	0,060	4343	261
		●														6÷7	75	0,075	3675	276
		●														7÷8	75	0,085	3185	271
		●														8÷9	75	0,095	2810	267
		●														9÷10	75	0,105	2514	264
		●														10÷11	75	0,110	2275	250
		●														11÷12	75	0,115	2077	239
		●														12÷13	75	0,120	1911	229
		●														13÷14	75	0,130	1769	230
		●														14÷15	75	0,140	1647	231
		●														15÷16	75	0,150	1541	231
			●													3÷4	55	0,035	5005	175
			●													4÷5	55	0,045	3892	175
			●													5÷6	55	0,060	3185	191
			●													6÷7	55	0,075	2695	202
			●													7÷8	55	0,085	2335	199
			●													8÷9	55	0,095	2061	196
			●													9÷10	55	0,105	1844	194
			●													10÷11	55	0,110	1668	184
			●													11÷12	55	0,115	1523	175
			●													12÷13	55	0,120	1401	168
			●													13÷14	55	0,130	1297	169
			●													14÷15	55	0,140	1208	169
			●													15÷16	55	0,150	1130	170
					●											3÷4	50	0,035	4550	159
					●											4÷5	50	0,045	3539	159
					●											5÷6	50	0,060	2895	174
					●											6÷7	50	0,075	2450	184
					●											7÷8	50	0,085	2123	180
					●											8÷9	50	0,095	1873	178
					●											9÷10	50	0,105	1676	176
					●											10÷11	50	0,110	1517	167
					●											11÷12	50	0,115	1385	159
					●											12÷13	50	0,120	1274	153
					●											13÷14	50	0,120	1180	142
					●											14÷15	50	0,125	1098	137
					●											15÷16	50	0,125	1027	128
							●									3÷4	80	0,075	7279	546
							●									4÷5	80	0,100	5662	566
							●									5÷6	80	0,130	4632	602
							●									6÷7	80	0,150	3920	588
							●									7÷8	80	0,170	3397	577
							●									8÷9	80	0,190	2997	570
							●									9÷10	80	0,215	2682	577
							●									10÷11	80	0,230	2548	586
							●									11÷12	80	0,255	2316	591
							●									12÷13	80	0,280	2123	594
							●									13÷14	80	0,290	1960	568
							●									14÷15	80	0,300	1820	546
							●									15÷16	80	0,310	1699	527

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

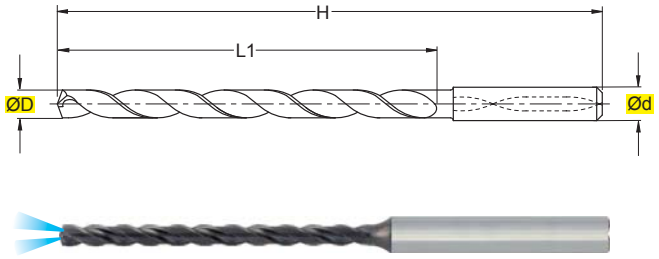
n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF1201

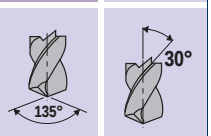
ØD = 3 - 16



TOLLERANZE	D	d
TOLLERANCE RANGE	h7	h6

RIVESTIM. COATED **TIALN**

12xD



DIN 6535

MG

(mm)

ART.	ØD	Ød	H	L1
SDF1201030	3,0	6	92	54
SDF1201031	3,1	6	92	54
SDF1201032	3,2	6	92	54
SDF1201033	3,3	6	92	54
SDF1201034	3,4	6	92	54
SDF1201035	3,5	6	92	54
SDF1201036	3,6	6	92	54
SDF1201037	3,7	6	92	54
SDF1201038	3,8	6	102	64
SDF1201039	3,9	6	102	64
SDF1201040	4,0	6	102	64
SDF1201041	4,1	6	102	64
SDF1201042	4,2	6	102	64
SDF1201043	4,3	6	102	64
SDF1201044	4,4	6	102	64
SDF1201045	4,5	6	102	64
SDF1201046	4,6	6	102	64
SDF1201047	4,7	6	102	64
SDF1201048	4,8	6	116	78
SDF1201049	4,9	6	116	78
SDF1201050	5,0	6	116	78
SDF1201051	5,1	6	116	78
SDF1201052	5,2	6	116	78
SDF1201053	5,3	6	116	78
SDF1201054	5,4	6	116	78
SDF1201055	5,5	6	116	78
SDF1201056	5,6	6	116	78
SDF1201057	5,7	6	116	78
SDF1201058	5,8	6	116	78
SDF1201059	5,9	6	116	78
SDF1201060	6,0	6	116	78
SDF1201061	6,1	8	146	108
SDF1201062	6,2	8	146	108
SDF1201063	6,3	8	146	108
SDF1201064	6,4	8	146	108
SDF1201065	6,5	8	146	108
SDF1201066	6,6	8	146	108
SDF1201067	6,7	8	146	108
SDF1201068	6,8	8	146	108
SDF1201069	6,9	8	146	108
SDF1201070	7,0	8	146	108
SDF1201071	7,1	8	146	108
SDF1201072	7,2	8	146	108
SDF1201073	7,3	8	146	108
SDF1201074	7,4	8	146	108

(mm)

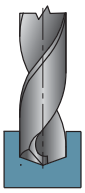
ART.	ØD	Ød	H	L1
SDF1201075	7,5	8	146	108
SDF1201076	7,6	8	146	108
SDF1201077	7,7	8	146	108
SDF1201078	7,8	8	146	108
SDF1201079	7,9	8	146	108
SDF1201080	8,0	8	146	108
SDF1201081	8,1	10	162	120
SDF1201082	8,2	10	162	120
SDF1201083	8,3	10	162	120
SDF1201084	8,4	10	162	120
SDF1201085	8,5	10	162	120
SDF1201086	8,6	10	162	120
SDF1201087	8,7	10	162	120
SDF1201088	8,8	10	162	120
SDF1201089	8,9	10	162	120
SDF1201090	9,0	10	162	120
SDF1201091	9,1	10	162	120
SDF1201092	9,2	10	162	120
SDF1201093	9,3	10	162	120
SDF1201094	9,4	10	162	120
SDF1201095	9,5	10	162	120
SDF1201096	9,6	10	162	120
SDF1201097	9,7	10	162	120
SDF1201098	9,8	10	162	120
SDF1201099	9,9	10	162	120
SDF1201100	10,0	10	162	120
SDF1201101	10,1	12	204	156
SDF1201102	10,2	12	204	156
SDF1201103	10,3	12	204	156
SDF1201104	10,4	12	204	156
SDF1201105	10,5	12	204	156
SDF1201106	10,6	12	204	156
SDF1201107	10,7	12	204	156
SDF1201108	10,8	12	204	156
SDF1201109	10,9	12	204	156
SDF1201110	11,0	12	204	156
SDF1201111	11,1	12	204	156
SDF1201112	11,2	12	204	156
SDF1201113	11,3	12	204	156
SDF1201114	11,4	12	204	156
SDF1201115	11,5	12	204	156
SDF1201116	11,6	12	204	156
SDF1201117	11,7	12	204	156
SDF1201118	11,8	12	204	156
SDF1201119	11,9	12	204	156

(mm)

ART.	ØD	Ød	H	L1
SDF1201120	12,0	12	204	156
SDF1201125	12,5	14	230	182
SDF1201128	12,8	14	230	182
SDF1201130	13,0	14	230	182
SDF1201135	13,5	14	230	182
SDF1201138	13,8	14	230	182
SDF1201140	14,0	14	230	182
SDF1201145	14,5	16	260	208
SDF1201148	14,8	16	260	208
SDF1201150	15,0	16	260	208
SDF1201155	15,5	16	260	208
SDF1201158	15,8	16	260	208
SDF1201160	16,0	16	260	208

PAG. H 28

MATERIALI - MATERIALS Pag. H 73

Applicazione - Application	P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●															3÷4	80	0,050	7279	364
	●															4÷5	80	0,080	5662	453
	●															5÷6	80	0,110	4632	510
	●															6÷7	80	0,130	3920	510
	●															7÷8	80	0,150	3397	510
	●															8÷9	80	0,170	2997	510
	●															9÷10	80	0,190	2682	510
	●															10÷11	80	0,200	2548	510
	●															11÷12	80	0,210	2316	486
	●															12÷13	80	0,220	2123	467
	●															13÷14	80	0,230	1960	451
	●															14÷15	80	0,240	1820	437
	●															15÷16	80	0,250	1699	425
		●														3÷4	50	0,035	4550	159
		●														4÷5	50	0,045	3539	159
		●														5÷6	50	0,060	2895	174
		●														6÷7	50	0,075	2450	184
		●														7÷8	50	0,085	2123	180
		●														8÷9	50	0,095	1873	178
		●														9÷10	50	0,105	1676	176
		●														10÷11	50	0,110	1592	175
		●														11÷12	50	0,115	1448	166
		●														12÷13	50	0,120	1327	159
		●														13÷14	50	0,130	1225	159
		●														14÷15	50	0,140	1137	159
		●														15÷16	50	0,150	1062	159
			●													3÷4	30	0,035	2730	96
			●													4÷5	30	0,045	2123	96
			●													5÷6	30	0,060	1737	104
			●													6÷7	30	0,075	1470	110
			●													7÷8	30	0,085	1274	108
			●													8÷9	30	0,095	1124	107
			●													9÷10	30	0,105	1006	106
			●													10÷11	30	0,110	955	105
			●													11÷12	30	0,115	869	100
			●													12÷13	30	0,120	796	96
			●													13÷14	30	0,130	735	96
			●													14÷15	30	0,140	682	96
			●													15÷16	30	0,150	637	96
					●											3÷4	50	0,035	4550	159
					●											4÷5	50	0,045	3539	159
					●											5÷6	50	0,060	2895	174
					●											6÷7	50	0,075	2450	184
					●											7÷8	50	0,085	2123	180
					●											8÷9	50	0,095	1873	178
					●											9÷10	50	0,105	1676	176
					●											10÷11	50	0,110	1517	167
					●											11÷12	50	0,115	1385	159
					●											12÷13	50	0,120	1274	153
					●											13÷14	50	0,120	1180	142
					●											14÷15	50	0,125	1098	137
					●											15÷16	50	0,125	1027	128
							●									3÷4	75	0,075	6824	512
							●									4÷5	75	0,100	5308	531
							●									5÷6	75	0,130	4343	565
							●									6÷7	75	0,150	3675	551
							●									7÷8	75	0,170	3185	541
							●									8÷9	75	0,190	2810	534
							●									9÷10	75	0,215	2514	541
							●									10÷11	75	0,230	2389	549
							●									11÷12	75	0,255	2171	554
							●									12÷13	75	0,280	1990	557
							●									13÷14	75	0,290	1837	533
							●									14÷15	75	0,300	1706	512
							●									15÷16	75	0,310	1592	494

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

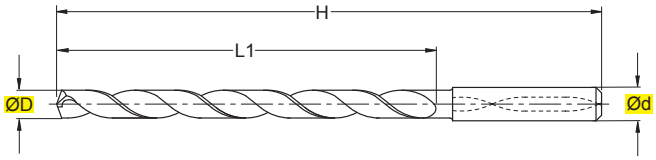
n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF1601

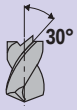
ØD = 3 - 12



TOLLERANZE	D	d
TOLLERANCE RANGE	h7	h5

RIVESTIM. COATED **TIALN**

16xD



DIN 6535

MG

(mm)

ART.	ØD	Ød	H	L1
SDF1601030	3,0	6	100	60
SDF1601032	3,2	6	100	60
SDF1601033	3,3	6	100	60
SDF1601035	3,5	6	100	60
SDF1601038	3,8	6	115	75
SDF1601040	4,0	6	115	75
SDF1601042	4,2	6	115	75
SDF1601045	4,5	6	130	90
SDF1601048	4,8	6	130	90
SDF1601050	5,0	6	130	90
SDF1601055	5,5	6	150	108
SDF1601058	5,8	6	150	108
SDF1601060	6,0	6	150	108
SDF1601065	6,5	8	165	125
SDF1601068	6,8	8	165	125
SDF1601070	7,0	8	165	125
SDF1601075	7,5	8	180	140
SDF1601078	7,8	8	180	140
SDF1601080	8,0	8	180	140
SDF1601085	8,5	10	205	160
SDF1601088	8,8	10	205	160
SDF1601090	9,0	10	205	160
SDF1601098	9,8	10	225	180
SDF1601100	10,0	10	225	180
SDF1601102	10,2	12	240	190
SDF1601108	10,8	12	240	190
SDF1601118	11,8	12	265	215
SDF1601120	12,0	12	265	215

-PRIMA DELL'UTILIZZO DELLA PUNTA LEGGERE GLI ACCORGIMENTI DI PAG H 31
-PER ESEGUIRE IL PREFORO UTILIZZARE ART. SDF0371 PAG C 32

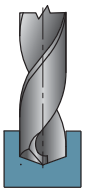
-BEFORE USING THE DRILL READ THE TIPS ON PAGE H 31
-USE ART. SDF0371 PAGE C 32 TO MAKE THE PRE-BORE

-VOR DEM GEBRAUCH SIEHE DIE HINWEISE AUF SEITE H 31
-ZUM VORBOHREN ART. SDF0371, SEITE C 32 VERWENDEN

-AVANT D'UTILISER LA POINTE, LIRE LES CONSIGNES DE PAGE H 31
-POUR EXECUTER LE PRE-TROU, UTILISER ART. SDF0371 PAGE C 32

PAG. H 28

MATERIALI - MATERIALS Pag. H 73

Applicazione - Application	P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●															3÷4	105	0,070	9554	669
	●															4÷5	105	0,090	7431	669
	●															5÷6	105	0,110	6080	669
	●															6÷7	105	0,125	5145	643
	●															7÷8	105	0,140	4459	624
	●															8÷9	105	0,160	3934	629
	●															9÷10	105	0,185	3412	631
	●															10÷12	105	0,200	3096	619
		●														3÷4	80	0,050	7279	364
		●														4÷5	80	0,065	5662	368
		●														5÷6	80	0,075	4632	347
		●														6÷7	80	0,090	3920	353
		●														7÷8	80	0,110	3397	374
		●														8÷9	80	0,125	2997	375
		●														9÷10	80	0,140	2600	364
		●														10÷12	80	0,150	2359	354
					●											3÷4	50	0,035	4550	159
					●											4÷5	50	0,045	3539	159
					●											5÷6	50	0,060	2895	174
					●											6÷7	50	0,075	2450	184
					●											7÷8	50	0,085	2123	180
					●											8÷9	50	0,095	1873	178
					●											9÷10	50	0,105	1625	171
					●											10÷12	50	0,115	1474	170
						●										3÷4	120	0,110	10919	1201
						●										4÷5	120	0,140	8493	1189
						●										5÷6	120	0,170	6948	1181
						●										6÷7	120	0,215	5879	1264
						●										7÷8	120	0,245	5096	1248
						●										8÷9	120	0,280	4496	1259
						●										9÷10	120	0,300	4023	1207
						●										10÷12	120	0,320	3474	1112
							●									3÷4	100	0,110	9099	1001
							●									4÷5	100	0,140	7077	991
							●									5÷6	100	0,170	5790	984
							●									6÷7	100	0,215	4900	1053
							●									7÷8	100	0,245	4246	1040
							●									8÷9	100	0,280	3747	1049
							●									9÷10	100	0,300	3250	975
							●									10÷12	100	0,320	2949	944

NEL CASO DI FORI PASSANTI RIDURRE L'AVANZAMENTO IN USCITA DEL 40%
IN CASE OF THROUGH BORES REDUCE EXIT FEED BY 40%

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

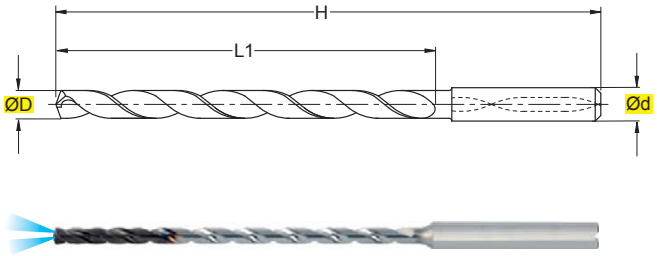
n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF2001

ØD = 2 - 12



TOLLERANZE	D	d
TOLLERANCE RANGE	h7	h5

RIVESTIM. COATED **TIALN**

20xD

135°

30°

DIN 6535

MG

(mm)

ART.	ØD	Ød	H	L1
SDF2001020	2,0	4	92	50
SDF2001022	2,2	4	92	50
SDF2001023	2,3	4	92	50
SDF2001024	2,4	4	112	70
SDF2001025	2,5	4	112	70
SDF2001027	2,7	4	112	70
SDF2001028	2,8	4	112	70
SDF2001030	3,0	6	120	80
SDF2001032	3,2	6	120	80
SDF2001033	3,3	6	120	80
SDF2001035	3,5	6	120	80
SDF2001038	3,8	6	130	90
SDF2001040	4,0	6	130	90
SDF2001042	4,2	6	160	110
SDF2001045	4,5	6	160	110
SDF2001048	4,8	6	160	120
SDF2001050	5,0	6	160	120
SDF2001055	5,5	6	185	140
SDF2001058	5,8	6	185	140
SDF2001060	6,0	6	185	140
SDF2001065	6,5	8	210	160
SDF2001068	6,8	8	210	160
SDF2001070	7,0	8	210	160
SDF2001075	7,5	8	230	180
SDF2001078	7,8	8	230	180
SDF2001080	8,0	8	230	180
SDF2001085	8,5	10	260	195
SDF2001088	8,8	10	290	230
SDF2001090	9,0	10	290	230
SDF2001098	9,8	10	290	230
SDF2001100	10,0	10	290	230
SDF2001102	10,2	12	315	268
SDF2001108	10,8	12	315	268
SDF2001118	11,8	12	315	268
SDF2001120	12,0	12	315	268

-PRIMA DELL'UTILIZZO DELLA PUNTA LEGGERE GLI ACCORGIMENTI DI PAG H 31
-PER ESEGUIRE IL PREFORO UTILIZZARE ART. SDF0371 PAG C 32

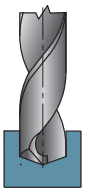
-BEFORE USING THE DRILL READ THE TIPS ON PAGE H 31
-USE ART. SDF0371 PAGE C 32 TO MAKE THE PRE-BORE

-VOR DEM GEBRAUCH SIEHE DIE HINWEISE AUF SEITE H 31
-ZUM VORBOHREN ART. SDF0371, SEITE C 32 VERWENDEN

-AVANT D'UTILISER LA POINTE, LIRE LES CONSIGNES DE PAGE H 31
-POUR EXECUTER LE PRE-TROU, UTILISER ART. SDF0371 PAGE C 32

PAG. H 28

MATERIALI - MATERIALS Pag. H 73

Applicazione - Application	P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●															2÷3	105	0,050	13376	669
	●															3÷4	105	0,070	9554	669
	●															4÷5	105	0,090	7431	669
	●															5÷6	105	0,110	6080	669
	●															6÷7	105	0,125	5145	643
	●															7÷8	105	0,140	4459	624
	●															8÷9	105	0,160	3934	629
	●															9÷10	105	0,185	3412	631
	●															10÷12	105	0,200	3096	619
		●														2÷3	80	0,035	10191	357
		●														3÷4	80	0,050	7279	364
		●														4÷5	80	0,065	5662	368
		●														5÷6	80	0,075	4632	347
		●														6÷7	80	0,090	3920	353
		●														7÷8	80	0,110	3397	374
		●														8÷9	80	0,125	2997	375
		●														9÷10	80	0,140	2600	364
		●														10÷12	80	0,150	2359	354
					●											2÷3	50	0,025	6369	159
					●											3÷4	50	0,035	4550	159
					●											4÷5	50	0,045	3539	159
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					●											6÷7	50	0,075	2450	184
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					●											8÷9	50	0,095	1873	178
					●											9÷10	50	0,105	1625	171
					●											10÷12	50	0,115	1474	170
						●										2÷3	120	0,075	15287	1146
						●										3÷4	120	0,110	10919	1201
						●										4÷5	120	0,140	8493	1189
						●										5÷6	120	0,170	6948	1181
						●										6÷7	120	0,215	5879	1264
						●										7÷8	120	0,245	5096	1248
						●										8÷9	120	0,280	4496	1259
						●										9÷10	120	0,300	4023	1207
						●										10÷12	120	0,320	3474	1112
							●									2÷3	100	0,075	12739	955
							●									3÷4	100	0,110	9099	1001
							●									4÷5	100	0,140	7077	991
							●									5÷6	100	0,170	5790	984
							●									6÷7	100	0,215	4900	1053
							●									7÷8	100	0,245	4246	1040
							●									8÷9	100	0,280	3747	1049
							●									9÷10	100	0,300	3250	975
							●									10÷12	100	0,320	2949	944

NEL CASO DI FORI PASSANTI RIDURRE L'AVANZAMENTO IN USCITA DEL 40%
IN CASE OF THROUGH BORES REDUCE EXIT FEED BY 40%

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

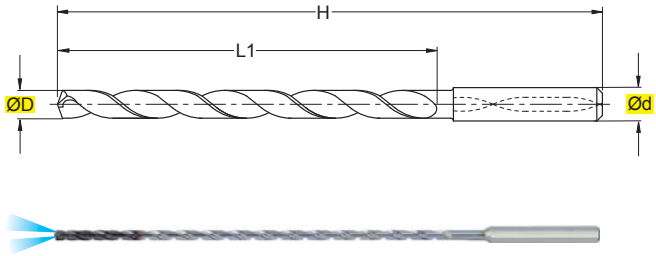
n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF3001

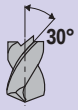
ØD = 2 - 12



TOLLERANZE	D	d
TOLLERANCE RANGE	h7	h5

RIVESTIM. COATED **TIALN**

30xD



DIN 6535

MG

(mm)

ART.	ØD	Ød	H	L1
SDF3001020	2,0	4	115	70
SDF3001022	2,2	4	115	70
SDF3001023	2,3	4	115	70
SDF3001024	2,4	4	138	90
SDF3001025	2,5	4	138	90
SDF3001027	2,7	4	138	90
SDF3001028	2,8	4	138	90
SDF3001030	3,0	6	150	105
SDF3001032	3,2	6	150	105
SDF3001033	3,3	6	185	135
SDF3001035	3,5	6	185	135
SDF3001038	3,8	6	185	135
SDF3001040	4,0	6	185	135
SDF3001042	4,2	6	185	135
SDF3001045	4,5	6	215	165
SDF3001048	4,8	6	215	165
SDF3001050	5,0	6	215	165
SDF3001055	5,5	6	230	180
SDF3001058	5,8	6	230	180
SDF3001060	6,0	6	230	180
SDF3001065	6,5	8	280	215
SDF3001068	6,8	8	280	230
SDF3001070	7,0	8	280	230
SDF3001075	7,5	8	280	230
SDF3001078	7,8	8	315	265
SDF3001080	8,0	8	315	265
SDF3001085	8,5	10	350	295
SDF3001088	8,8	10	380	330
SDF3001090	9,0	10	380	330
SDF3001098	9,8	10	380	330
SDF3001100	10,0	10	380	330
SDF3001102	10,2	12	430	380
SDF3001108	10,8	12	430	380
SDF3001118	11,8	12	430	380
SDF3001120	12,0	12	430	380

-PRIMA DELL'UTILIZZO DELLA PUNTA LEGGERE GLI ACCORGIMENTI DI PAG H 31
-PER ESEGUIRE IL PREFORO UTILIZZARE ART. SDF0371 PAG C 32

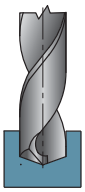
-BEFORE USING THE DRILL READ THE TIPS ON PAGE H 31
-USE ART. SDF0371 PAGE C 32 TO MAKE THE PRE-BORE

-VOR DEM GEBRAUCH SIEHE DIE HINWEISE AUF SEITE H 31
-ZUM VORBOHREN ART. SDF0371, SEITE C 32 VERWENDEN

-AVANT D'UTILISER LA POINTE, LIRE LES CONSIGNES DE PAGE H 31
-POUR EXECUTER LE PRE-TROU, UTILISER ART. SDF0371 PAGE C 32

PAG. H 28

MATERIALI - MATERIALS Pag. H 73

Applicazione - Application	P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●															2÷3	90	0,050	11465	573
	●															3÷4	90	0,070	8189	573
	●															4÷5	90	0,090	6369	573
	●															5÷6	90	0,110	5211	573
	●															6÷7	90	0,125	4410	551
	●															7÷8	90	0,140	3822	535
	●															8÷9	90	0,160	3372	540
	●															9÷10	90	0,185	2925	541
	●															10÷12	90	0,200	2654	531
		●														2÷3	70	0,035	8917	312
		●														3÷4	70	0,050	6369	318
		●														4÷5	70	0,065	4954	322
		●														5÷6	70	0,075	4053	304
		●														6÷7	70	0,090	3430	309
		●														7÷8	70	0,110	2972	327
		●														8÷9	70	0,125	2623	328
		●														9÷10	70	0,140	2275	318
		●														10÷12	70	0,150	2064	310
					●											2÷3	45	0,025	5732	143
					●											3÷4	45	0,035	4095	143
					●											4÷5	45	0,045	3185	143
					●											5÷6	45	0,060	2606	156
					●											6÷7	45	0,075	2205	165
					●											7÷8	45	0,085	1911	162
					●											8÷9	45	0,095	1686	160
					●											9÷10	45	0,105	1462	154
					●											10÷12	45	0,115	1327	153
						●										2÷3	102	0,075	12994	975
						●										3÷4	102	0,110	9281	1021
						●										4÷5	102	0,140	7219	1011
						●										5÷6	102	0,170	5906	1004
						●										6÷7	102	0,215	4998	1074
						●										7÷8	102	0,245	4331	1061
						●										8÷9	102	0,280	3822	1070
						●										9÷10	102	0,300	3419	1026
						●										10÷12	102	0,320	2953	945
							●									2÷3	85	0,075	10828	812
							●									3÷4	85	0,110	7734	851
							●									4÷5	85	0,140	6016	842
							●									5÷6	85	0,170	4922	837
							●									6÷7	85	0,215	4165	895
							●									7÷8	85	0,245	3609	884
							●									8÷9	85	0,280	3185	892
							●									9÷10	85	0,300	2762	829
							●									10÷12	85	0,320	2506	802

NEL CASO DI FORI PASSANTI RIDURRE L'AVANZAMENTO IN USCITA DEL 40%
IN CASE OF THROUGH BORES REDUCE EXIT FEED BY 40%

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED