





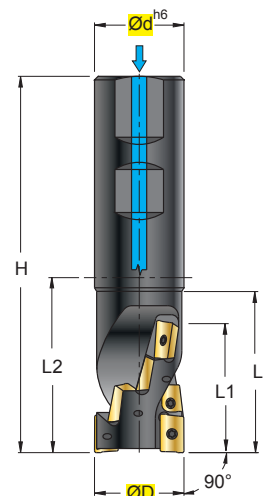
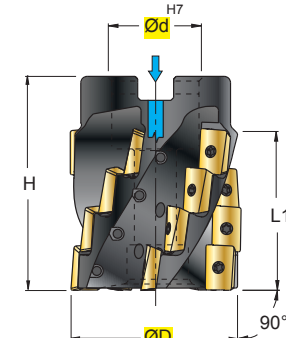


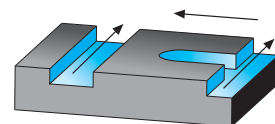
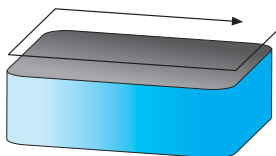


S1056 Pag. B 200		S1058 Pag. B 200		FW Pag. B 204		FA Pag. B 204	
	ØD = 20 - 40		ØD = 40 - 63		ØD = 12		ØD = 21 - 33
S 1056W .. 10		S 1058W .. 10 S 1058WF .. 10		FW .. 00		FW .. 01	
	AP..1003				NFL..00		NFL..01 NFL..02
S1656 Pag. B 202		S1658 Pag. B 202		S666 Pag. B 206		S668 Pag. B 206	
	ØD = 25 - 40		ØD = 50 - 125		ØD = 19 - 34		ØD = 48 - 63
S 1656W .. 16		S 1658 .. 16		S 666 .. 16		S 668 .. 16	
	AP..1604				156.15.16..		
				S976		Pag. B 208	
							ØD = 21 - 50
				S 976W ..			
					SP..0603 SP..09T3 SP..1204		

S 1056W .. 10	$\varnothing 20-40$	S 1058W .. 10 S 1058WF .. 10	$\varnothing 40-63$	<p>APKT 1003 .I52 </p> <p>APKT 1003 .L52 </p> <p>APKT 1003 .S52 </p> <p>APKX 1003 .S52 </p> <p>APKT 1003 .Z54  NEW</p> <p>APHT 1003 .S57 </p>
		<p style="text-align: center;">ISO 6462 ...</p> <p style="text-align: center;">A B C-D</p> 		 <p>INSERTI - INSERTS PAG. B 262</p>

(mm)																
ART.	$\varnothing D$	$\varnothing d$	H	L	L1	L2	Z	N	K	kg			Nm	ISO 6462		
S 1056W 020-10	20	20	87	37	28	37	2	4	1	0,200	1,1+1,3	-	1003	12255P	5608P	-
S 1056W 020.2-10(**)	20	20	87	37	28	37	2	6	2	0,200	1,1+1,3	-	1003	12255P	5608P	VBSF08L
S 1056W 025-10	25	25	105	49	37	49	2	8	2	0,340	1,1+1,3	-	1003	12255P	5608P	VBSF10L
S 1056W 032-10(***)	32	32	115	55	46	55	4	12	2	0,605	1,1+1,3	-	1003	12255P	5608P	VBSF12L
S 1056W 032.2-10(**)	32	32	115	55	46	55	2	10	2	0,605	1,1+1,3	-	1003	12255P	5608P	VBSF12L
S 1056W 032.3-10(*)	32	32	115	55	46	55	3	15	3	0,600	1,1+1,3	-	1003	12255P	5608P	VBSF12L
S 1056W 040-10	40	32	130	70	55	70	3	18	3	0,810	1,1+1,3	-	1003	12255P	5608P	VBSF12L
S 1056W 040.2-10(**)	40	32	130	70	55	70	2	12	2	0,810	1,1+1,3	-	1003	12255P	5608P	VBSF12L
S 1058W 040-10	40	16	50	-	37	-	3	12	3	0,250	1,1+1,3	A	1003	12255P	5608P	VBSF08L
S 1058W 050-10	50	22	60	-	46	-	3	15	3	0,510	1,1+1,3	A	1003	12255P	5608P	VBSF10L
S 1058W 063-10	63	27	60	-	46	-	4	20	4	0,800	1,1+1,3	A	1003	12255P	5608P	VBSF12L
S 1058WF 040-10	40	16	50	-	37	-	5	20	5	0,240	1,1+1,3	A	1003	12255P	5608P	VBSF08L
S 1058WF 050-10	50	22	60	-	46	-	5	25	5	0,510	1,1+1,3	A	1003	12255P	5608P	VBSF10L
S 1058WF 063-10	63	27	60	-	46	-	7	35	7	0,840	1,1+1,3	A	1003	12255P	5608P	VBSF12L



- | | | |
|----------------|-----------------|---------------------------------------------|
| (*) 3 ELICHE | (**) 2 ELICHE | (***) 2 ELICHE N°4 INSERTI IN TESTA |
| (*) 3 FLUTES | (**) 2 FLUTES | (***) 2 FLUTES 4 FRONT INSERTS |
| (*) 3 SPIRALEN | (**) 2 SPIRALEN | (***) 2 SPIRALEN A STIRNWEENDEPLATTEN |
| (*) 3 HÉLICES | (**) 2 HÉLICES | (***) 2 HÉLICES 4 PLAQUETTES À L' EXTREMITÉ |

Z = Numero di eliche - Number of flutes - Spiralenanzahl - Nombre d' helices
 K = Fattore d' avanzamento - Factor of feed - Vorschubfaktor - Facteur d' avance
 N = Numero d' inserti - Insert number - Wendeplattenanzahl - Nombre des plaquettes
 W = Foro per liquido refrigerante - Coollant bore - Kühlmittelbohrung - Trou du liquide d'arrosage
 F = Passo fine - Fine pitch - Feine Zuhnteilung - Pas fin

SCELTA VELOCE - QUICK PICK												HT		HW	HC																																									
Tenacità + ↑ Toughness - ↓												Pag. B 238												CERMET	NON RIV. CEMENTED CARBIDE GRADES	RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS						l	d	s	d1	r	a°																			
												P			M			K			N					S			H									T120	T516	T518M	T526	T528N	T530	F1035	T533											
COD.		F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R																															
APKT	1003 PDR .I52	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																					
APKT	1003 PDER .L52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																					
APKT	1003 PDTR .S52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																					
APKX	1003 PDR .S52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																					
APKT	1003 PDSR .Z54	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																					
APKT	1003 PDER .Z54	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																					
APHT	1003 PDFR .S57	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○																					
CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY																						○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY																						○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

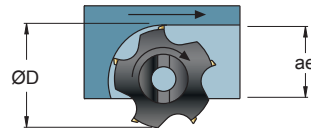
MATERIALI - MATERIALS Pag. H 73			VDI 3323 GR.	HB Rm1) HRC2)	fz0 mm			Vc m/min Pag. B 254									
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	0,1	0,15	0,2	T120	T516	T518M	T525	T526	T528N	T530	T533	F1035		
P	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350	0,06	0,1	0,15			220	250	220	220	230	240	125		
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,06	0,1	0,15			160	200	160	160	180	150	120		
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	0,06	0,08	0,1			140	170	150	150	150	140	100		
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,06	0,08	0,1	100		140	140	130	120	120	140			
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	0,1	0,15	0,2	120	250	160	200		180	160	160			
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	0,06	0,12	0,15	110	200	140	180		160	150	150			
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	0,06	0,12	0,15	120	220	150	200		170	160	160			
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130	0,06	0,15	0,2	500						600				
	RAME E SUE LEGHE - COPPER	26-28	90-110	0,06	0,12	0,18	300						300				
	NON METALLICI - PLASTICS	29-30	/	0,06	0,12	0,18											
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320	0,06	0,08	0,1	20		60	40		40	40	50			
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ⁿ	0,06	0,08	0,1	30		40	50		60	50	50			
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ⁿ	0,06	0,08	0,1				40							

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

$$fz = fz0 \cdot Kae \cdot Kap = \text{mm}$$

$$fn = fz \cdot K = \text{mm}$$

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



ae/D	0,5-1 50-100%	0,3 30%	0,2 20%	0,1 10%	0,05 5%	0,02 2%
Kae	1	1,2	1,5	2,1	3	4,8

ae/D	0,5-1 50-100%	0,2 20%	0,1 10%	0,05 5%
Vc	Vc (min)-----Vc(max) R-----M-----F			

Pag. B 254

























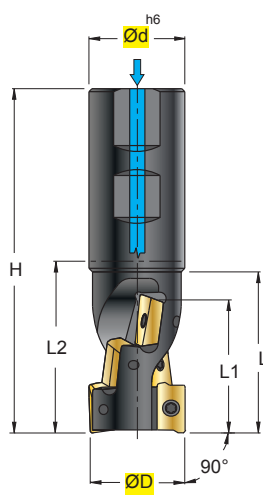
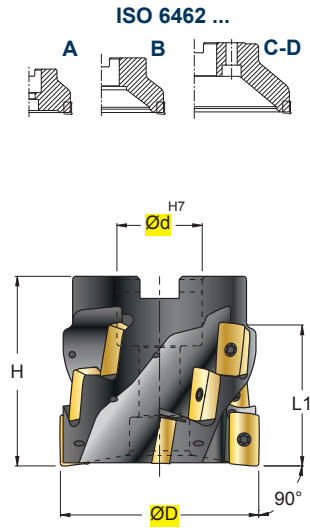

- F = FINITURA, LAV. LEGGERA - FINISHING, LIGHT MACHINING
- M = LAV. MEDIA, GENERICA - MEDIUM MACHINING, GENERIC
- R = SGROSSATURA, LAV. PESANTE - ROUGHING, HEAVY MACHINING




- Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
- n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
- fz = mm AVANZAMENTO AL DENTE - TOOTH FEED
- fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
- Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
- Kae / Kap = FATTORE DI CORREZIONE - CORRECTION FACTOR

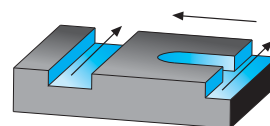
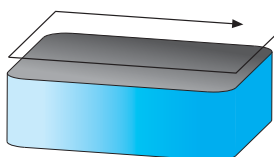
ap/D	0,25	0,5	0,75	1,0	ap max=L1
Kap	1	1	0,8	0,7	0,5

■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES
●● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFÖHLENER EINSATZ - APPLICATION CONSEILLÉE

□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE
○○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

S 1656W .. 16	\varnothing 25-40	S 1658 .. 16	\varnothing 50-125	<table border="1"> <tr><td>APKT 1604 .S51/.S54</td><td></td></tr> <tr><td>APMT 1604 .I52</td><td></td></tr> <tr><td>APKT 1604 .Z52</td><td></td></tr> <tr><td>APFT 1604 .S52</td><td></td></tr> <tr><td>APKX 1604 .S52</td><td></td></tr> <tr><td>APKT 1604 .F53</td><td></td></tr> <tr><td>APKT 1604 .Z54</td><td></td></tr> <tr><td>APKT 1604 .K57P</td><td></td></tr> </table>	APKT 1604 .S51/.S54		APMT 1604 .I52		APKT 1604 .Z52		APFT 1604 .S52		APKX 1604 .S52		APKT 1604 .F53		APKT 1604 .Z54		APKT 1604 .K57P	
APKT 1604 .S51/.S54																				
APMT 1604 .I52																				
APKT 1604 .Z52																				
APFT 1604 .S52																				
APKX 1604 .S52																				
APKT 1604 .F53																				
APKT 1604 .Z54																				
APKT 1604 .K57P																				
		<p style="text-align: center;">ISO 6462 ...</p> 		 INSERTI - INSERTS PAG. B 263																

(mm)											 kg  Nm ISO 6462					  			
ART.	\varnothing D	\varnothing d	H	L	L1	L2	Z	N	K	kg	Nm	ISO 6462							
S 1656W	025-16	25	25	95	38	29	39	1	2	1	0,29	3,8+5,0	-	1604	C04008P	5615P	-		
S 1656W	032-16	32	32	115	53	44	55	2	6	2	0,52	3,8+5,0	-						
S 1656W	040-16	40	32	130	65	58	70	2	8	2	0,73	3,8+5,0	-	1604	C04011P	5615P	-		
S 1658	050-16	50	27	50	-	30	-	3	6	3	0,36	3,8+5,0	A	1604	C04011P	5615P	VBSF12		
S 1658	063-16	63	27	60	-	44	-	4	12	4	0,74	3,8+5,0	A	1604	C04011P	5615P	VBSF12L		
S 1658	080-16	80	32	60	-	44	-	5	15	5	1,20	3,8+5,0	A	1604	C04011P	5615P	VBSF16L		
S 1658	100-16	100	40	60	-	44	-	6	18	6	1,70	3,8+5,0	A	1604	C04011P	5615P	VBSF20		
S 1658	125-16	125	40	60	-	44	-	7	21	7	3,15	3,8+5,0	A						



Z = Numero di eliche - Number of flutes - Spiralenanzahl - Nombre d' helices
 K = Fattore d' avanzamento - Factor of feed - Vorschubfaktor - Facteur d' avance
 N = Numero d' inserti - Insert number - Wendeplattenanzahl - Nombre des plaquettes
 W = Foro per liquido refrigerante - Coolant bore - Kühlmittelbohrung - Trou du liquide d'arrosage

