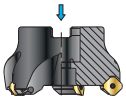
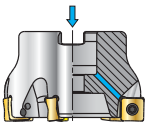
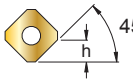
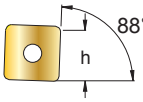
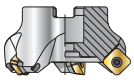
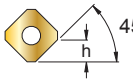
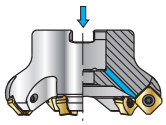
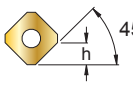
SAU
QUALITY TOOLS ENGINEERING

FRESE PER SPIANATURA E SMUSSI
FACE AND CHAMFERING MILLING CUTTERS
FRÄSER ZUM PLANEN UND FASEN
FRAISES À SURFACER ET ARRONDIR
FRESAS PARA PLANEAR Y BISELES

S406	Pag. B 158	S409	Pag. B 158	S8801-8W	Pag. B 164		
 ØD = 6 - 32		 ØD = 32 - 100		 ØD = 50 - 250			
S 406W .. 09		S 409W .. 09 S 409WF .. 09 S 409GW .. 09		S 8801-8W .. 12			
 45° h **SD..0903** **h = 4**				 88° h **SN..1206** **h = 11,5**			

S438	Pag. B 160				
 ØD = 50 - 315					
S 438 .. 13 S438F .. 13 S438G .. 13					
 45° h **SE..13T3** **h = 6**					

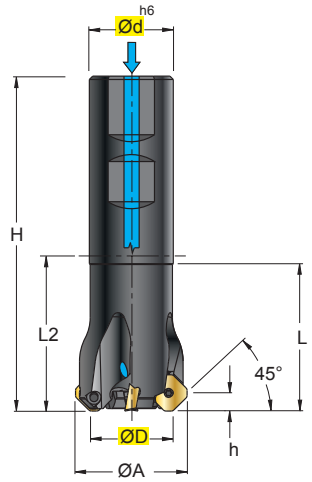
S4501	Pag. B 162				
 ØD = 50 - 250					
S 4501-8W .. 12					
 45° h **SN..1206** **h = 6**					

SAU QUALITY TOOLS ENGINEERING

S 406W .. 09

Ø 06-32

γ_p 0°/+12°
γ_f -11°/-6,5°
γ_o -8°/+4°

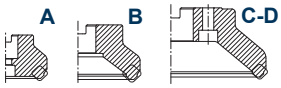


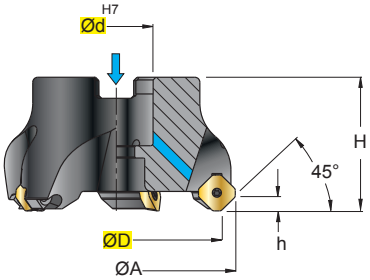
S 409W .. 09
S 409WF .. 09
S 409GW .. 09

Ø 32-100

γ_p +12°
γ_f -6,5°/-6°
γ_o +4°/+5°

ISO 6462 ...

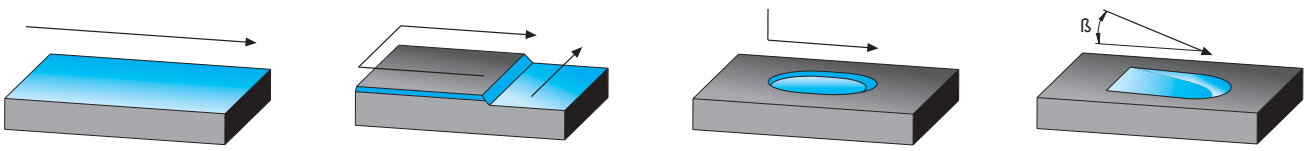




SDHW 0903 .Z42	
SDHT 0903 .L51	 NEW
SDNT 0903 .L54	 NEW
SDKT 0903 .L56	 NEW
SDEX 0903 .L58	 NEW

INSERTI - INSERTS
PAG. B 267

ART.		(mm) ØD	Ød	ØA	H	h	L	L2	ß	Z	kg	Nm	ISO 6462				
S 406W	006 - 09	6	16	14,2	80	4	32	32	10,5°	1	0,12	1,2÷1,5	–	0903	123006	5608	–
S 406W	012 - 09	12	16	20,2	80	4	32	32	3°	1	0,13	1,2÷1,5	–				
S 406W	016 - 09	16	20	24,2	90	4	40	40	28,5°	2	0,19	1,2÷1,5	–	0903	123008P	5608	–
S 406W	020 - 09	20	20	28,2	90	4	40	40	19,5°	3	0,20	1,2÷1,5	–				
S 406W	025 - 09	25	25	33,2	100	4	44	44	13,5°	4	0,35	1,2÷1,5	–				
S 406W	032 - 09	32	25	40,2	95	4	39	39	9,5°	5	0,36	1,2÷1,5	–				
S 409W	032 - 09	32	16	40,2	40	4	–	–	9,5°	3	0,19	1,2÷1,5	A	0903	123008P	5608P	VBSF08C
S 409W	040 - 09	40	16	48,2	40	4	–	–	7°	4	0,26	1,2÷1,5	A				
S 409W	050 - 09	50	22	58,2	40	4	–	–	5,5°	6	0,37	1,2÷1,5	A	0903	123008P	5608P	VBSF10
S 409W	063 - 09	63	22	71,2	40	4	–	–	4°	8	0,55	1,2÷1,5	A				
S 409W	080 - 09	80	27	88,2	50	4	–	–	3°	10	1,09	1,2÷1,5	A	0903	123008P	5608P	VBSF12
S 409W	100 - 09	100	32	108,2	50	4	–	–	2,5°	12	1,74	1,2÷1,5	A	0903	123008P	5608P	AL16x35
S 409WF	032 - 09	32	16	40,2	40	4	–	–	9,5°	5	0,19	1,2÷1,5	A	0903	123008P	5608P	VBSF08C
S 409WF	040 - 09	40	16	48,2	40	4	–	–	7°	6	0,26	1,2÷1,5	A				
S 409WF	050 - 09	50	22	58,2	40	4	–	–	5,5°	8	0,36	1,2÷1,5	A	0903	123008P	5608P	VBSF10
S 409WF	063 - 09	63	22	71,2	40	4	–	–	4°	10	0,55	1,2÷1,5	A				
S 409WF	080 - 09	80	27	88,2	50	4	–	–	3°	12	1,20	1,2÷1,5	A	0903	123008P	5608P	VBSF12
S 409WF	100 - 09	100	32	108,2	50	4	–	–	2,5°	14	1,76	1,2÷1,5	A	0903	123008P	5608P	AL16x35
S 409GW	063 - 09	63	22	71,2	40	4	–	–	4°	5	0,60	1,2÷1,5	A	0903	123008P	5608P	VBSF10
S 409GW	080 - 09	80	27	88,2	50	4	–	–	3°	6	1,06	1,2÷1,5	A	0903	123008P	5608P	VBSF12
S 409GW	100 - 09	100	32	108,2	50	4	–	–	2,5°	7	1,71	1,2÷1,5	A	0903	123008P	5608P	AL16x35



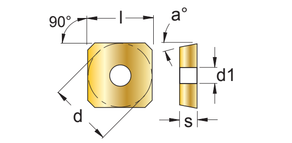
W = FORO PER LIQUIDO REFRIGERANTE - COOLANT BORE - KÜHLMITTELBOHRUNG - TROU DU LIQUIDE D'ARROSAGE
G = PASSO GROSSO - LARGE TEETH DISTANCE - NORMALE ZAHNTEILUNG - GRANDE DISTANCE DENTS.
F = PASSO FINE - FINE PITCH - FEINE ZAHNTEILUNG - PAS FIN

SCELTA VELOCE - QUICK PICK

Tenacità + / Toughness -

Pag. B 238

HT: CERMET — HW: NON RIV. CEMENTED CARBIDE GRADES — HC: RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS



COD.	P F	P M	P R	M F	M M	M R	K F	K M	K R	N F	N M	N R	S F	S M	S R	H F	H M	H R	DT61 (HT)	N3105 (HW, NEW)	T518M (HC)	F1040 (HC, NEW)	T533 (HC)	l	d	s	d1	r	a°
SDHW 0903 AESN .Z42	●	○																	■					9,52	9,52	3,2	3,4	–	15
SDHT 0903 AESN .L51	○	○	○	●	●	○							●	●	○								■	9,52	9,52	3,2	3,4	–	15
SDNT 0903 AESN .L54	●	●	●				●	●	●												■			9,52	9,52	3,2	3,4	–	15
	○	●	●																			■							
SDKT 0903 AESN .L56	○	●	●	○	○	○	●	○	○												■			9,52	9,52	3,2	3,4	–	15
SDEX 0903 AEFN .L58										●	●									■				9,52	9,52	3,2	3,4	–	15

	DT61	N3105	T518M	F1040	T533
CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY		○	●	○	○
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY	●	○	○	●	○

	MATERIALI - MATERIALS Pag. H 73	VDI 3323 GR.	HB Rm 1) HRC 2)	fz0 mm F	fz0 mm M	fz0 mm R	Vc m/min DT61	F1040	N3105	T518M	T533
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1---5	125-300	0,1	0,2		260	260		350	275
P	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6--9	180-350	0,08	0,15		250	220		270	210
P	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,08	0,15		250	175		200	160
P	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	0,06	0,12		230	110		180	100
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,06	0,1					200	240
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	0,12	0,25					280	
K	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	0,1	0,2					230	
K	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	0,1	0,2					200	
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21---25	60-130	0,06	0,15	0,25			950		
N	RAME E SUE LEGHE - COPPER	26--28	90-110	0,06	0,12	0,2			475		
N	NON METALLICI - PLASTICS	29-30	/	0,06	0,12	0,2			950		
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31---35	200-320	0,05	0,08						85
S	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 1)	0,05	0,08						60
H	ACCIAIO TEMPRATO - HARDENED STEEL	38--41	45-60 2)								

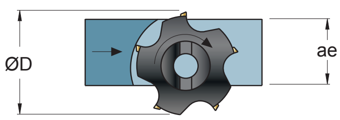
Vc m/min Pag. B 254

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

$$fz = fz0 \cdot Kae = mm$$

$$fn = fz \cdot z = mm$$

$$Vf = fz \cdot z \cdot n = mm/min$$



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

Vc Pag. B 254	ae/D	0,5-1 50-100%	0,2 20%	0,1 10%	0,05 5%
	Vc (min)---------Vc(max)				
	R--------M--------------------F				

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 = FATTORE DI CORREZIONE - CORRECTION FACTOR

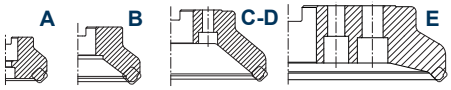
■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES
●● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE
○○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

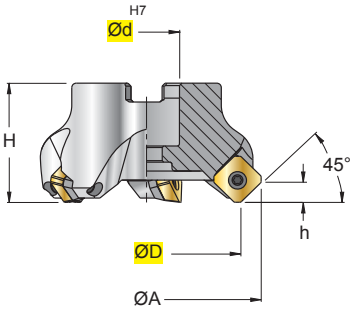
S 438 .. 13
S 438F .. 13
S 438G .. 13

Ø 50-315

γ_p +20°/+22,5°
γ_f -15°/-7°
γ_o +4°/+10°

ISO 6462 ...

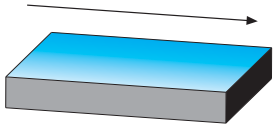


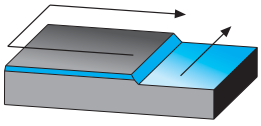


SEEX 13T3.. .M12	
SEKT 13T3.. .L44	 NEW
SEKT 13T3.. .L44	 NEW
SEKT 13T3.. .L54	 NEW
SEKT 13T3.. .L55	 NEW
SEKW 13T3.. .L51	 NEW
SEKX 1305.. .Z52	 ALTI AVANZAMENTI HIGH FEED

INSERTI - INSERTS
PAG. B 268

ART.		(mm) ØD	Ød	ØA	H	h	Z	kg	Nm	ISO 6462								
S 438	050 - 13	50	22	63	40	6	4	0,405	3,0÷3,5	A	13T3	13T3	PA13M	BCL7	123512P	5035	5615P	AL10x30
S 438	063 - 13	63	22	76	40	6	5	0,60	3,0÷3,5	A								
S 438	080 - 13	80	27	93	50	6	6	1,120	3,0÷3,5	A	13T3	13T3	PA13M	BCL7	123512P	5035	5615P	AL12x35
S 438	100 - 13	100	32	113	50	6	7	1,786	3,0÷3,5	A	13T3	13T3	PA13M	BCL7	123512P	5035	5615P	AL16x35
S 438	125 - 13	125	40	138	63	6	8	3,310	3,0÷3,5	A	13T3	13T3	PA13M	BCL7	123512P	5035	5615P	AL20x45
S 438	160 - 13	160	40	173	63	6	10	4,070	3,0÷3,5	C	13T3	13T3	PA13M	BCL7	123512P	5035	5615P	–
S 438	200 - 13	200	60	213	63	6	12	6,800	3,0÷3,5	B								
S 438	250 - 13	250	60	263	63	6	14	9,700	3,0÷3,5	D								
S 438	315 - 13	315	60	334	80	6	18	25,30	3,0÷3,5	E								
S 438F	050 - 13	50	22	63	40	6	5	0,4	3,0÷3,5	A	13T3	13T3	PA13M	BCL7	123512P	5035	5615P	AL10x30
S 438F	063 - 13	63	22	76	40	6	6	0,6	3,0÷3,5	A								
S 438F	080 - 13	80	27	93	50	6	8	1,10	3,0÷3,5	A	13T3	13T3	PA13M	BCL7	123512P	5035	5615P	AL12x35
S 438F	100 - 13	100	32	113	50	6	10	1,74	3,0÷3,5	A	13T3	13T3	PA13M	BCL7	123512P	5035	5615P	AL16x35
S 438F	125 - 13	125	40	138	63	6	12	3,250	3,0÷3,5	A	13T3	13T3	PA13M	BCL7	123512P	5035	5615P	AL20x45
S 438G	160 - 13	160	40	173	63	6	7	4,3	3,0÷3,5	C	13T3	13T3	PA13M	BCL7	123512P	5035	5615P	–
S 438G	200 - 13	200	60	213	63	6	8	7,0	3,0÷3,5	B								
S 438G	250 - 13	250	60	263	63	6	10	10,0	3,0÷3,5	D								
S 438G	315 - 13	315	60	334	80	6	12	25,6	3,0÷3,5	E								





F = PASSO FINE - FINE PITCH - FEINE ZAHNTEILUNG - PAS FIN

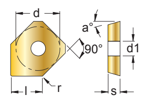
SAU QUALITY TOOLS ENGINEERING

SCELTA VELOCE - QUICK PICK

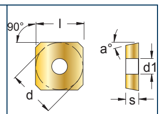
Tenacità / Toughness + / -

Pag. B 238

HT: CERMET · HW: NON RIV. CEMENTED · HC: RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS



SEEX..



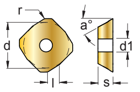
SEHT..

COD.				P F	P M	P R	M F	M M	M R	K F	K M	K R	N F	N M	N R	S F	S M	S R	H F	H M	H R	DT63		N3005	N3105 (NEW)	T518M	T528N	T3215 (NEW)	F1040 (NEW)	F7010 (NEW)		T533	F8115 (NEW)				l	d	s	d1	r	a°
SEEX	13T3	AGTR	.M12	●						●												■															8,2	13,4	3,97	4,1	1,5	20
										●														■																		
SEKT	13T3	AZFN	.L44							○	○		●	●											■												13,4	13,4	3,97	4,1	–	20
SEKT	13T3	AZEN	.L44				○	○					○	○		●	●																■				13,4	13,4	3,97	4,1	–	20
SEKT	13T3	AZEN	.L54	○	●	●	○	○	○	○	○	○														■											13,4	13,4	3,97	4,1	–	20
				○	○	○	●	●	○							○	○	○														■										
				○	●	●	○	○	○																				■													
SEKT	13T3	AZTN	.L55							●	●	●	○	○																■							13,4	13,4	3,97	4,1	–	20
SEKW	13T3	AZTN	.L51							●	●	●																■									13,4	13,4	3,97	4,1	–	20
SEKX	1305	AGSR	.Z52	○	●	●	○	○	○	○	○	○				○	○	○									■										3,9	15,17	5,58	4,1	1,0	20

⚠ - CON INSERTI **SEKX 1305.. .Z52** PROFONDITÀ MASSIMA DI LAVORO = 2 (mm) PER ALTI AVANZAMENTI
PROFONDITÀ MASSIMA DI LAVORO = 6 (mm) PER AVANZAMENTI STANDARD

- WITH INSERTS **SEKX 1305.. .Z52** MAXIMUM MACHINING DEPTH = 2 (mm) FOR HIGH FEED
MAXIMUM MACHINING DEPTH = 6 (mm) FOR STANDARD FEED

	DT63		N3005	N3105	T518M	T528N	T3215	F1040	F7010		T533	F8115			
CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY	●		○	○	●	○	●	○	○		○	●			
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY	○		○	○	○	●		●	●		○				



SEKX..

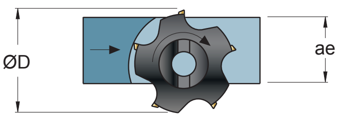
MATERIALI - MATERIALS Pag. H 73		VDI 3323 GR.	HB Rm 1) HRC 2)	fz0 mm F	fz0 mm M	fz0 mm R	Vc m/min Pag. B 254 DT63	F1040	F7010	F8115	N3105	T518M	T533	T3215				
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1---5	125-300	0,12	0,15	0,19	280	190				240	200					
P	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6--9	180-350	0,12	0,15	0,19	250	170				230	180					
P	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,12	0,15	0,19	220	150				190	160					
P	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	0,12	0,15	0,19		80				140	100					
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,1	0,15	0,17		190		180		150	180					
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	0,1	0,15	0,19	220		200		240	250		270				
K	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	0,1	0,15	0,19	200		180			200		230				
K	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	0,1	0,15	0,19	220		120			180		190				
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21---25	60-130	0,1	0,13	0,16			400	380	500							
N	RAME E SUE LEGHE - COPPER	26--28	90-110	0,1	0,13	0,16			400	350	500							
N	NON METALLICI - PLASTICS	29-30	/	0,1	0,13	0,16			950	630	950							
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31---35	200-320	0,08	0,14					60			50					
S	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 1)	0,08	0,14					40			30					
H	ACCIAIO TEMPRATO - HARDENED STEEL	38--41	45-60 2)															

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

$fz = fz0 \cdot Kae$ = mm

$fn = fz \cdot z$ = mm

$Vf = fz \cdot z \cdot n$ = mm/min



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

	ae/D	0,5-1 50-100%	0,2 20%	0,1 10%	0,05 5%
Vc Pag. B 254	Vc (min)---------Vc (max)				
	R-------M------------------F				

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 = FATTORE DI CORREZIONE - CORRECTION FACTOR

⚠ INSERTO SEKX.. IN GRADO T528N / INSERT SEKX.. WITH QUALITY T528N	MATERIALI MATERIALS pag. H 73	P: ACCIAIO NON LEGATO NOT ALLOY STEEL	P: ACCIAIO POCO LEGATO LOW ALLOY STEEL	P: ACCIAIO ALTO LEGATO ALLOY STEEL	P: INOX MARTENSITICO STAINLESS STEEL MART	M: INOX AUST. DUPLEX STAINLESS STEEL AUST	K: GHISA GRIGIA GREY CAST IRON	K: GHISA SFEROIDALE SPHEROIDAL GRAPHITE	K: GHISA MALLEABILE MALLEABLE CAST IRON	S: LEGHE RESIST. CALORE HIG. TEMP. ALLOY	S: TITANIO E SUE LEGHE TITANIUM
ALTI AVANZAMENTI HIGH FEED	fz0 mm ap<2	0,2-0,6	0,2-0,5	0,2-0,4	0,2-0,4	0,2-0,5	0,2-0,6	0,2-0,6	0,2-0,6	0,1-0,4	0,1-0,4
AVANZAMENTI STAND. STANDARD FEED	fz0 mm ap>2	0,25	0,25	0,25	0,25	0,25	0,25	0,25	0,25		
VELOCITÀ DI TAGLIO CUTTING SPEED	Vc m/min	100-220	80-220	80-180	70-180	60-200	80-180	70-160	70-170	20-60	40-70

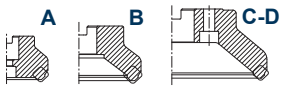
■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES
●● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE
○○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

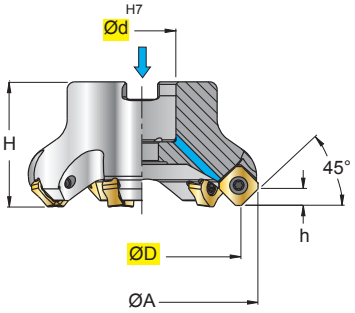
S 4501-8W .. 12

Ø 50-250

γ_p -6°
γ_f -9°/-2°
γ_o -11°/-6°

ISO 6462 ...

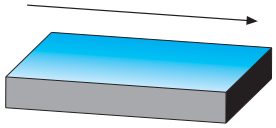


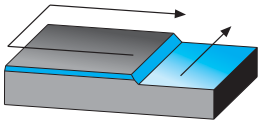


SNEX 1206NN .K11	 NEW
SNMX 1206NN .F52	 NEW
SNMX 120612 .F52	 NEW

INSERTI - INSERTS
PAG. B 269

ART.	(mm) ØD	Ød	ØA	H	h	Z	kg	Nm	ISO 6462				
S 4501-8W-050-04-12	50	22	63,4	40	6	4	0,41	3,8÷5	A	1206	124011	5620	AL10x30
S 4501-8W-050-06-12	50	22	63,4	40	6	6	0,41	3,8÷5	A				
S 4501-8W-063-06-12	63	22	76,4	40	6	6	0,55	3,8÷5	A				
S 4501-8W-063-08-12	63	22	76,4	40	6	8	0,55	3,8÷5	A				
S 4501-8W-080-07-12	80	27	93,4	50	6	7	0,98	3,8÷5	A	1206	124011	5620	AL12x35
S 4501-8W-080-10-12	80	27	93,4	50	6	10	0,98	3,8÷5	A				
S 4501-8W-100-08-12	100	32	113,4	50	6	8	1,60	3,8÷5	A	1206	124011	5620	AL16x35
S 4501-8W-100-12-12	100	32	113,4	50	6	12	1,60	3,8÷5	A				
S 4501-8W-125-10-12	125	40	138,4	63	6	10	3,25	3,8÷5	A	1206	124011	5620	AL20x45
S4501-8W-125-16-12 New	125	40	138,4	63	6	16	3,26	3,8÷5	A				
S4501-8-160-12-12 New	160	40	173,4	63	6	12	4,14	3,8÷5	C				
S4501-8-160-20-12 New	160	40	173,4	63	6	20	4,16	3,8÷5	C				
S4501-8-200-18-12 New	200	60	213,4	63	6	18	6,69	3,8÷5	D				
S4501-8-200-26-12 New	200	60	213,4	63	6	26	6,81	3,8÷5	D				
S4501-8-250-20-12 New	250	60	263,4	63	6	20	9,40	3,8÷5	D				
S4501-8-250-30-12 New	250	60	263,4	63	6	30	9,51	3,8÷5	D				





W = FORO PER LIQUIDO REFRIGERANTE - COOLANT BORE - KÜHLMITTELBOHRUNG - TROU DU LIQUIDE D'ARROSAGE

SAU QUALITY TOOLS ENGINEERING

SCELTA VELOCE - QUICK PICK

Tenacità + / Toughness -

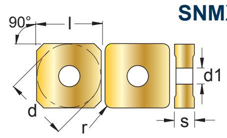
Pag. B 238

HT: CERMET — HW: NON RIV. CEMENTED CARBIDE GRADES — HC: RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS (F1135 NEW, F2430 NEW, T1025 NEW, T3415 NEW)

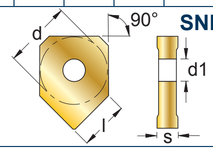
COD.	P F	P M	P R	M F	M M	M R	K F	K M	K R	N F	N M	N R	S F	S M	S R	H F	H M	H R	F1135	F2430	T1025	T3415	F3010	l	d	s	d1	r	a°
SNEX 1206NN .K11	○	○					●	●	○														■	8,5	12,7	6,35	4,5	–	–
SNMX 1206NN .F52	●	●	●																		■			12,7	12,7	6,35	4,5	–	–
							●	●	●													■							
	○	●	○	○	○	○													■										
				○	●	●							○	○	○					■									
SNMX 120612 .F52	○	●	○	○	○	○													■					12,7	12,7	6,35	4,5	1,2	–
							●	●	●													■							

	F1135	F2430	T1025	T3415	F3010
CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY	○	●	○	○	○
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY	○	●	○	○	○

SNMX..



SNEX..



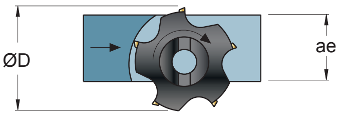
MATERIALI - MATERIALS Pag. H 73		VDI 3323 GR.	HB Rm 1) HRC 2)	fz0 mm F	fz0 mm M	fz0 mm R	Vc m/min Pag. B 254 F1135	F2430	F3010	T1025	T3415
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1---5	125-300	0,12	0,25	0,35	230		200	240	
P	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6--9	180-350	0,1	0,2	0,3	170		200	240	
P	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,1	0,2	0,3	160		180	220	
P	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	0,08	0,15	0,25	160	150	120	160	
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,06	0,10	0,20	140	150			
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	0,12	0,3	0,4			290		320
K	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	0,12	0,25	0,35			180		250
K	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	0,12	0,25	0,35			260		280
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21---25	60-130								
N	RAME E SUE LEGHE - COPPER	26--28	90-110								
N	NON METALLICI - PLASTICS	29-30	/								
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31---35	200-320	0,05	0,08	0,12		50			
S	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 1)	0,05	0,08	0,12		45			
H	ACCIAIO TEMPRATO - HARDENED STEEL	38--41	45-60 2)								

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

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

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

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



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

Vc Pag. B 254	ae/D	0,5-1 50-100%	0,2 20%	0,1 10%	0,05 5%
	Vc (min)---------Vc(max)				
	R-------M-------------------F				

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 = FATTORE DI CORREZIONE - CORRECTION FACTOR

LATO A - SIDE A — LATO B - SIDE B

- 8 Taglienti “Utili” disponibili grazie all'inserto bilaterale.
- 8 “Useful” cutting-edges thanks to two-sided insert
- 8 “Nützliche” schneidkanten dank zweiseitiger wendeschneidplatten
- 8 Tranchants “Utiles” disponibles grace a la plaquette bilaterale

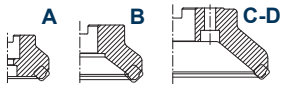
■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES
●● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE
○○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

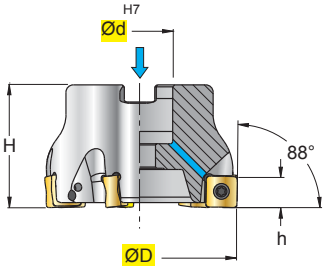
S 8801-8 .. 12
S 8801-8W .. 12

Ø 50-250

γ_p +6°
γ_f -8°/-5,5°
γ_o -8°/-5,5°

ISO 6462 ...



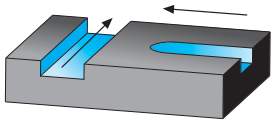


SNMX 120612 .F52 NEW

SNMX 1206QNN .F52 NEW

INSERTI - INSERTS
PAG. B 269

ART.	(mm) ØD	Ød	H	h	Z	kg	Nm	ISO 6462				
S 8801-8W-050-04-12	50	22	40	11,5	4	0,27	3,8÷5	A	1206	124011	5620	VBSF10
S 8801-8W-063-06-12	63	22	40	11,5	6	0,46	3,8÷5	A				
S 8801-8W-080-07-12	80	27	50	11,5	7	0,94	3,8÷5	A	1206	124011	5620	AL12x35
S 8801-8W-080-09-12	80	27	50	11,5	9	0,92	3,8÷5	A				
S 8801-8W-100-08-12	100	32	50	11,5	8	1,63	3,8÷5	A-B	1206	124011	5620	AL16x35
S 8801-8W-100-11-12	100	32	50	11,5	11	1,59	3,8÷5	A-B				
S 8801-8W-125-10-12	125	40	63	11,5	10	3,05	3,8÷5	A-B	1206	124011	5620	AL20x45
S 8801-8W-125-14-12	125	40	63	11,5	14	2,99	3,8÷5	A-B				
S 8801-8-160-12-12	160	40	63	11,5	12	4,00	3,8÷5	C	1206	124011	5620	–
S 8801-8-160-18-12	160	40	63	11,5	18	3,91	3,8÷5	C				
S 8801-8-200-14-12	200	60	63	11,5	14	6,61	3,8÷5	D				
S 8801-8-200-22-12	200	60	63	11,5	22	6,48	3,8÷5	D				
S 8801-8-250-16-12	250	60	63	11,5	16	9,68	3,8÷5	D				
S 8801-8-250-24-12	250	60	63	11,5	24	9,52	3,8÷5	D				

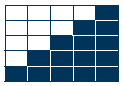


W = FORO PER LIQUIDO REFRIGERANTE - COOLANT BORE - KÜHLMITTELBOHRUNG - TROU DU LIQUIDE D'ARROSAGE

SAU QUALITY TOOLS ENGINEERING

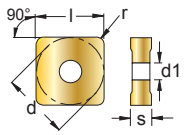
SCELTA VELOCE - QUICK PICK

Tenacità + / Toughness -



Pag. B 238

COD.			P F	P M	P R	M F	M M	M R	K F	K M	K R	N F	N M	N R	S F	S M	S R	H F	H M	H R	HT CERMET	HW NON RIV. CEMENTED CARBIDE GRADES	HC RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS F1135 NEW	HC T3415 NEW	l	d	s	d1	r	a°
SNMX	1206 QNN	.F52	○	●	○	○	○	○	●	●	●												■	■	12,7	12,7	6,35	4,5	0,8	–
SNMX	120612	.F52	○	●	○	○	○	○	●	●	●												■	■	12,7	12,7	6,35	4,5	1,2	–



CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY																							○	○						
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY																							○	○						

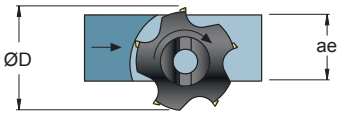
MATERIALI - MATERIALS Pag. H 73		VDI 3323 GR.	HB Rm[1] HRC[2]	fz0 mm F	fz0 mm M	fz0 mm R	Vc m/min Pag. B 254 F1135	Vc m/min T3415
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1---5	125-300	0,12	0,25	0,35	230	
P	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6--9	180-350	0,1	0,2	0,3	170	
P	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,1	0,2	0,3	160	
P	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	0,08	0,15	0,25	160	
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,06	0,10	0,15	140	
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	0,12	0,3	0,4		320
K	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	0,12	0,25	0,35		250
K	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	0,12	0,25	0,35		280
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21---25	60-130					
N	RAME E SUE LEGHE - COPPER	26--28	90-110					
N	NON METALLICI - PLASTICS	29-30	/					
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31---35	200-320					
S	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050[1]					
H	ACCIAIO TEMPRATO - HARDENED STEEL	38--41	45-60[2]					

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

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

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

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

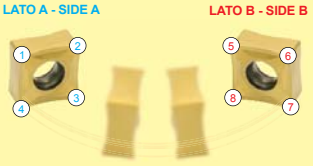


ae/D	0,5-1 50-100%	0,2 20%	0,1 10%	0,05 5%	0,02 2%
Kae	1	1,1	1,2	1,3	1,5

ae/D	0,5-1 50-100%	0,2 20%	0,1 10%	0,05 5%
Vc Pag. B 254	Vc (min)---------Vc(max)			
	R-------M----------F			

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 = FATTORE DI CORREZIONE - CORRECTION FACTOR



- 8 Taglienti "Utili" disponibili grazie all'inserto bilaterale.
- 8 "Useful" cutting-edges thanks to two-sided insert
- 8 "Nützliche" schneidkanten dank zweiseitiger wendeschneidplatten
- 8 Tranchants "Utiles" disponibles grace a la plaquette bilaterale

■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES
●● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE
○○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE