
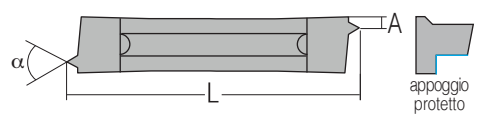
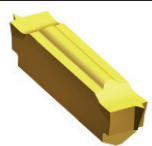
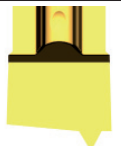


FILETTATURA **Sistema P92 P - Inserti**

<p>OTX ER filettatura esterna destra inserti a profilo completo</p>																					
<p>▽▽▽ inserto rettificato</p> 						<p>ISO 513</p>	<p>PM</p>														
 						<p>P ★</p> <p>M ★</p> <p>K</p> <p>N</p> <p>S</p> <p>H</p>															
<p>Velocità di taglio Vc [m/min]</p>	<p>ACCAI</p>					<p>P ★</p> <p>60÷180</p>															
<p>Vc [m/min]</p>	<p>ACCAI INOSSIDABILI</p>					<p>M ★</p> <p>40÷140</p>															
<p>S</p>	DESCRIZIONE	PASSO	L	A	α	STOCK															
<p>4</p>	OTX 4 ER ISO 100	1.00	19.20 ^{±0.1}	0.8	60°	●															
	ER ISO 125	1.25	19.20 ^{±0.1}	0.8	60°	●															
	ER ISO 150	1.50	19.20 ^{±0.1}	1.0	60°	●															
	ER ISO 175	1.75	19.20 ^{±0.1}	1.1	60°	●															
	ER ISO 200	2.00	19.20 ^{±0.1}	1.4	60°	●															
	ER ISO 250	2.50	19.20 ^{±0.1}	1.5	60°	●															
	ER ISO 300	3.00	19.20 ^{±0.1}	1.8	60°	●															
	OTX 4 ER 14W	14 filetti/pollice	19.20 ^{±0.1}	1.3	55°	○															
	ER 11W	11 filetti/pollice	19.20 ^{±0.1}	1.5	55°	○															

○ lavorazione stabile ○ uso generico ⚙️ condizioni difficili ★ prima scelta - ☆ seconda scelta

	<p>Numero di passate</p>	Passo	Inserto		Passo	Inserto	
			OTX 4 ER ISO □□□			OTX 4 ER □□W	
		1.00 mm	5÷8		14 filetti/pollice	8÷11	
		1.25 mm	6÷9		11 filetti/pollice	9÷12	
		1.50 mm	6÷9				
		1.75 mm	8÷11				
		2.00 mm	8÷11				
		3.00 mm	12÷15				

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