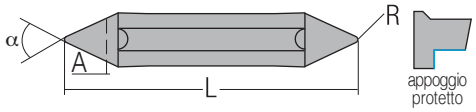
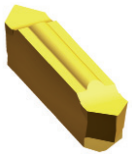
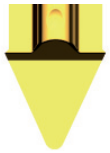
OTX EIR

filettatura esterna e interna destra
inserti a profilo parziale

▽▽▽ inserto rettificato







ISO 513

PM

NANOSPEED rivestimento PVD

P	★
M	★
K	
N	
S	
H	

S	DESCRIZIONE		PASSO	L	R	A	α	STOCK
4	OTX 4	EIR 60 050	0.5÷1.00	19.20$^{-0.1}$	0.10	2.7	60°	○
		EIR 60 125	1.25÷1.75	19.20$^{-0.1}$	0.20	2.7	60°	●
		EIR 60 200	2.00÷3.00	19.20$^{-0.1}$	0.30	2.7	60°	●
	OTX 4	EIR 55 28W	28-20 filetti/pollice	19.20$^{-0.1}$	0.10	2.7	55°	○
		EIR 55 19W	19-14 filetti/pollice	19.20$^{-0.1}$	0.20	2.7	55°	○
		EIR 55 12W	12-10 filetti pollice	19.20$^{-0.1}$	0.30	2.7	55°	○

Velocità di taglio Vc [m/min]			
ACCIAI	P	★	60÷180
ACCIAI INOSSIDABILI	M	★	40÷140

◯ lavorazione stabile ◯ uso generico ◯ condizioni difficili

★ prima scelta - ☆ seconda scelta

		Passo	Inserto OTX 4 EIR60 □□□	Passo	Inserto OTX 4 EIR55 □□□
Filettatura	Numero di passate	0.50 mm	4÷7	28 filetti/pollice	5÷8
		1.00 mm	5÷8	19 filetti/pollice	6÷9
		1.25 mm	6÷9	14 filetti/pollice	8÷11
		1.50 mm	6÷9	11 filetti/pollice	9÷12
		1.75 mm	8÷11		
		2.00 mm	8÷11		
		2.50 mm	10÷13		
		3.00 mm	12÷15		

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MATERIALI P M K N S H p. 263

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