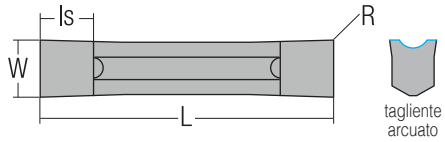
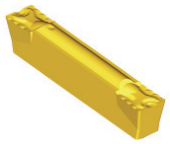
MTNZ
ottimo controllo truciolo in tornitura

tagliente secondario ondulato





ISO 513	KM TILOX rivestimento PVD	KM NANOSPEED rivestimento PVD	PM TILOX rivestimento PVD	PM NANOSPEED rivestimento PVD	PM ALOX rivestimento PVD
P	★	☆	★	☆	☆
M	☆	★	☆	★	
K	☆				★
N					
S		☆			
H					

S	DESCRIZIONE	W	R	L	ls	KM TILOX	KM NANOSPEED	PM TILOX	PM NANOSPEED	PM ALOX
30	MTNZ 304	$3.075^{\pm0.075}$	0.4	20.00	3.5	●	●	●	●	●
35	MTNZ 3.5	$3.55^{\pm0.08}$	0.2	20.00	3.5			○	○	○
40	MTNZ 402	$4.00^{+0.20}$	0.2	20.00	3.5	○	○	○	○	○
	404	$4.10^{\pm0.10}$	0.4	20.00	3.5	●	●	●	●	●
50	MTNZ 504	$5.00^{\pm0.25}$	0.4	25.00	4.2	○	○	○	○	○
	508	$5.125^{\pm0.125}$	0.8	25.00	4.2	●	●	●	●	●
60	MTNZ 604	$6.125^{\pm0.125}$	0.4	30.00	4.9	○	○	○	○	○
	608	$6.125^{\pm0.125}$	0.8	30.00	4.9	●	●	●	●	●
80	MTNZ 808	$8.125^{\pm0.125}$	0.8	30.00	6.4	○	○	○	○	○
	812	$8.125^{\pm0.125}$	1.2	30.00	6.4	○	○	○	○	○

Velocità di taglio Vc [m/min]		KM TILOX	KM NANOSPEED	PM TILOX	PM NANOSPEED	PM ALOX
ACCIAI	P	★ 70÷200	☆ 70÷200	★ 60÷180	☆ 60÷180	☆ 60÷180
ACCIAI INOSSIDABILI	M	☆ 50÷160	★ 50÷160	☆ 40÷140	★ 40÷140	
GHISE	K	☆ 80÷220				★ 100÷200
LEGHE RESISTENTI AL CALORE	S		☆ 30÷80			

◯ lavorazione stabile ◯ uso generico ◯ condizioni difficili

★ prima scelta - ☆ seconda scelta

		Raggio inserto	Larghezza inserto W 3	3.5	4	5	6	8
Scanalatura	Avanzamento fn [mm/giro]	R 0.2	-	0.08÷0.13	0.09÷0.14	-	-	-
		R 0.4	0.07÷0.13	-	0.09÷0.15	0.11÷0.19	0.13÷0.23	-
		R 0.8	-	-	-	0.11÷0.21	0.13÷0.25	0.18÷0.34
		R 1.2	-	-	-	-	-	0.18÷0.35
Tornitura	Avanzamento fn [mm/giro]	R 0.2	-	0.15÷0.19	0.16÷0.21	-	-	-
		R 0.4	0.16÷0.20	-	0.18÷0.24	0.20÷0.30	0.22÷0.36	-
		R 0.8	-	-	-	0.23÷0.35	0.24÷0.42	0.32÷0.56
		R 1.2	-	-	-	-	-	0.32÷0.62
	Asportazione radiale ap [mm]	R 0.2	-	0.25÷2.00	0.25÷2.50	-	-	-
		R 0.4	0.50÷2.00	-	0.50÷2.50	0.50÷3.00	0.50÷3.50	-
		R 0.8	-	-	-	1.00÷3.00	1.00÷3.50	1.00÷4.50
		R 1.2	-	-	-	-	-	1.50÷4.50

M S considerare dal valore minimo al valore medio

P K considerare dal valore medio al valore massimo

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