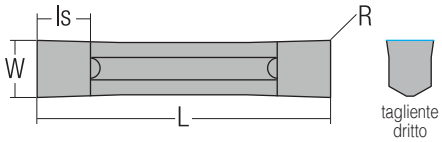
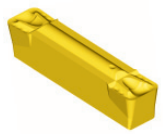
XTNS

impiego universale
taglio dolce





ISO 513	GF110	KM
	TILOX rivestimento PVD	TILOX rivestimento PVD
P	★	★
M	★	★
K	☆	☆
N		
S		
H		

S	DESCRIZIONE	W	R	L	ls	STOCK	STOCK
20	XTNS 202	$2.05^{+0.10}$	0.2	20.15	2.0	●	●
30	XTNS 302	$3.05^{+0.15}$	0.2	20.15	3.0	●	●
	304	$3.05^{+0.15}$	0.4	20.15	3.0	●	●
40	XTNS 404	$4.05^{+0.15}$	0.4	20.15	3.4	●	●
	408	$4.05^{+0.15}$	0.8	20.15	3.4	●	●
50	XTNS 504	$5.05^{+0.25}$	0.4	25.15	4.2	●	●
	508	$5.05^{+0.25}$	0.8	25.15	4.2	●	●
60	XTNS 604	$6.05^{+0.25}$	0.4	30.10	4.5	●	●
	608	$6.05^{+0.25}$	0.8	30.10	4.5	●	●
	612	$6.05^{+0.25}$	1.2	30.10	4.5	○	○
80	XTNS 808	$8.05^{+0.25}$	0.8	30.10	6.0	○	○
	812	$8.05^{+0.25}$	1.2	30.10	6.0	○	○
100	XTNS 1008	$10.05^{+0.25}$	0.8	30.10	6.1	○	○
	1012	$10.05^{+0.25}$	1.2	30.10	6.1	○	○

Velocità di taglio Vc [m/min]		GF110	KM
ACCIAI	P	★ 80÷220	★ 70÷200
ACCIAI INOSSIDABILI	M	★ 60÷180	★ 50÷160
GHISE	K	☆ 100÷240	☆ 80÷220

◯ lavorazione stabile ◯ uso generico ◯ condizioni difficili

★ prima scelta - ☆ seconda scelta

		Raggio inserto	Larghezza inserto W						
			2	3	4	5	6	8	10
Scanalatura	Avanzamento fn [mm/giro]	R 0.2	0.05÷0.10	0.07÷0.12	-	-	-	-	-
		R 0.4	-	0.07÷0.13	0.09÷0.15	0.11÷0.19	0.13÷0.23	-	-
		R 0.8	-	-	0.09÷0.17	0.11÷0.21	0.13÷0.25	0.18÷0.34	0.22÷0.38
		R 1.2	-	-	-	-	0.13÷0.26	0.18÷0.35	0.22÷0.40
Tornitura	Avanzamento fn [mm/giro]	R 0.2	0.10÷0.15	0.14÷0.18	-	-	-	-	-
		R 0.4	-	0.16÷0.20	0.18÷0.24	0.20÷0.30	0.22÷0.36	-	-
		R 0.8	-	-	0.20÷0.28	0.23÷0.35	0.24÷0.42	0.32÷0.56	0.32÷0.65
		R 1.2	-	-	-	-	0.24÷0.46	0.32÷0.62	0.32÷0.72
	Asportazione radiale ap [mm]	R 0.2	0.25÷1.50	0.25÷2.00	-	-	-	-	-
		R 0.4	-	0.50÷2.00	0.50÷2.50	0.50÷3.00	0.50÷3.50	-	-
		R 0.8	-	-	1.00÷2.50	1.00÷3.00	1.00÷3.50	1.00÷4.50	1.00÷5.00
		R 1.2	-	-	-	-	1.50÷3.50	1.50÷4.50	1.50÷5.00

M considerare dal valore minimo al valore medio

P K considerare dal valore medio al valore massimo

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