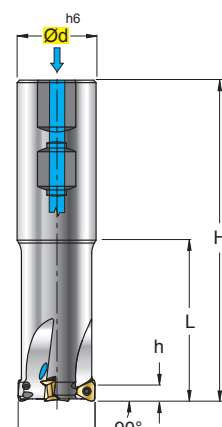
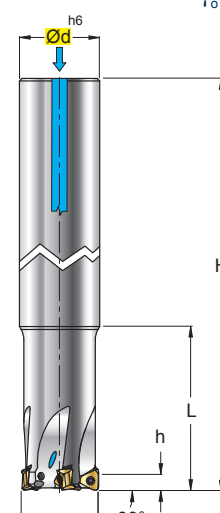
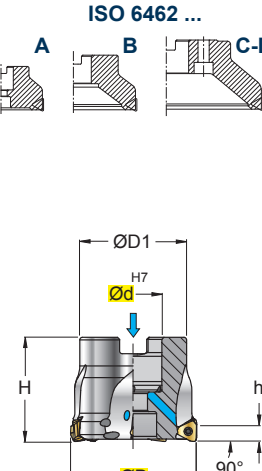
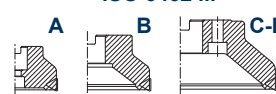
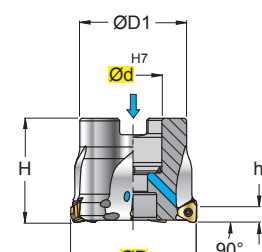
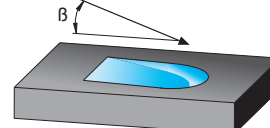
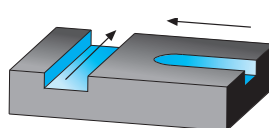
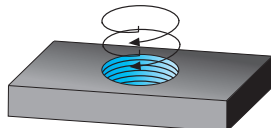
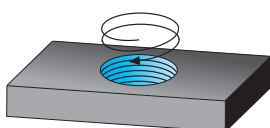


S 9006.6W- .. -06	S 9006.6XLW- .. -06	S 9006.8W- .. -06	TNGX 0604.. .X42		NEW
Ø 20-40	Ø 20-40	Ø 40-100	TNGX 0604.. .X54		NEW
NEW	NEW	NEW			
$\gamma_p -11^\circ$ $\gamma_f -16,5^\circ/-15^\circ$ $\gamma_o -16,5^\circ/-15^\circ$	$\gamma_p -11^\circ$ $\gamma_f -16,5^\circ/-15^\circ$ $\gamma_o -16,5^\circ/-15^\circ$	$\gamma_p -11^\circ$ $\gamma_f -15^\circ$ $\gamma_o -15^\circ$			
			ISO 6462 ... 		
					
INSERTI - INSERTS PAG. 518					

(mm)													ISO 6462				
ART.	ØD	Ød	ØD1	H	L	h	β	Z		kg	Nm						
S 9006.6W 020-03-06	20	20	—	100	40	6	2°	3	—	0,20	1,1+1,3	—	0604...	12256P	5608P	—	
S 9006.6W 025-03-06	25	25	—	115	50	6	1,5°	3	—	0,37	1,1+1,3	—					
S 9006.6W 025-04-06	25	25	—	115	50	6	1,5°	4	✓	0,35	1,1+1,3	—					
S 9006.6W 032-04-06	32	32	—	130	60	6	1°	4	✓	0,71	1,1+1,3	—					
S 9006.6W 040-05-06	40	32	—	140	70	6	0,8°	5	✓	0,80	1,1+1,3	—					
S 9006.6XLW 020-03-06	20	20	—	160	40	6	2°	3	—	0,34	1,1+1,3	—	0604...	12256P	5608P	—	
S 9006.6XLW 025-03-06	25	25	—	170	50	6	1,5°	3	✓	0,57	1,1+1,3	—					
S 9006.6XLW 032-04-06	32	32	—	180	60	6	1°	4	✓	1,02	1,1+1,3	—					
S 9006.6XLW 032-05-06	32	32	—	180	60	6	1°	5	✓	1,01	1,1+1,3	—					
S 9006.6XLW 040-05-06	40	32	—	200	70	6	0,8°	5	✓	1,17	1,1+1,3	—					
S 9006.8W 040-05-06	40	16	36	40	—	6	0,8°	5	✓	0,23	1,1+1,3	—	0604...	12256P	5608P	VDST2008	
S 9006.8W 040-06-06	40	16	36	40	—	6	0,8°	6	✓	0,23	1,1+1,3	—					
S 9006.8W 050-05-06	50	22	41	40	—	6	0,5°	5	✓	0,33	1,1+1,3	A					
S 9006.8W 050-07-06	50	22	41	40	—	6	0,5°	7	✓	0,31	1,1+1,3	A					
S 9006.8W 063-06-06	63	22	44	40	—	6	0,5°	6	✓	0,47	1,1+1,3	A-B					
S 9006.8W 063-09-06	63	22	44	40	—	6	0,5°	9	✓	0,44	1,1+1,3	A-B	0604...	12256P	5608P	VBSF10	
S 9006.8W 080-10-06	80	27	61	50	—	6	0,5°	10	✓	1,01	1,1+1,3	A-B					
S 9006.8W 100-12-06	100	32	75	50	—	6	0,5°	12	✓	1,61	1,1+1,3	A-B					



W = FORO PER LIQUIDO REFRIGERANTE - COOLANT BORE - KÜHLMITTELBOHRUNG - TROU DU LIQUIDE D'ARROSAGE
L = LUNGA, STELO CILINDRICO - LONG, CYLINDRICAL SHANK - LANG, ZYLINDERSCHAFT - LONGUE, QUEUE CYLINDRIQUE
↻ = PASSO DIFFERENZIATO - DIFFERENTIAL PITCH - UNGLEICHE TEILUNG - PAS DIFFERENCIE

SCELTA VELOCE - QUICK PICK																	Tenacità + Toughness -						Pag. 486		HT	HW	HC								
COD.		P			M			K			N			S			H			CERMET	NON RIV. CEMENTED CARBIDE GRADES	RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS	F5105	F2330 -RZ	F2335 -RZ	l	d	s	d1	r	a°				
		F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R																
TNGX	060404 .X42	●	○		●	●			○	○				○	○								■			11	6,35	3,42	2,8	0,4	-				
TNGX	060408 .X42	●	○		●	●			○	○				○	○								■			11	6,35	3,42	2,8	0,8	-				
TNGX	060404 .X54	●	○		●	○			○					○	○								■			11	6,35	3,42	2,8	0,4	-				
TNGX	060408 .X54	●	○		●	○			○					○	○								■			11	6,35	3,42	2,8	0,8	-				
CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY																													●		●	●			
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY																													●		●	○			

MATERIALI - MATERIALS Pag. 1119		VDI 3323 GR.	HB Rm1) HRC2)	fz0 mm			Vc m/min Pag. 500									
				F	M	R	F5105	F2330	F2335							
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	0,05	0,08	0,15	280	250	220							
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350	0,05	0,08	0,15	280	200	200							
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,05	0,08	0,15	230	180	160							
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	0,05	0,08	0,15	180	180	160							
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,05	0,08	0,12	160	170	140							
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	0,05	0,1	0,18	300		220							
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	0,05	0,1	0,18	250		200							
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	0,05	0,1	0,18	250		200							
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130													
	RAME E SUE LEGHE - COPPER	26-28	90-110													
	NON METALLICI - PLASTICS	29-30	/													
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320	0,05	0,08	0,12	60	60	60							
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ¹⁾	0,05	0,08	0,12	60	60	60							
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ²⁾													



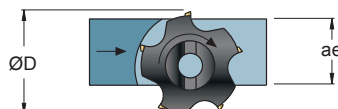
- SE LA SPORGENZA DELLA FRESA É **>3xD** RIDURRE I PARAMETRI DI LAVORO: **Vc, fz, ap** DEL 30%
- IF THE PROTRUSION OF THE CUTTER IS **>3xD**, REDUCE CUTTING PARAMETERS: **Vc, fz, ap** BY 30%

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

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

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

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



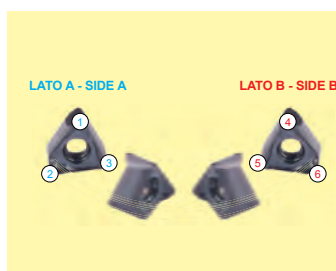
ae/D	0,5-1 50-100%	0,3 30%	0,2 20%	0,1 10%	0,05 5%	0,02 2%
Kae	1	1,2	1,5	2,1	3	4,8

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

Vc Pag. 500

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



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