

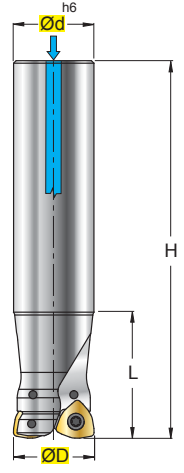
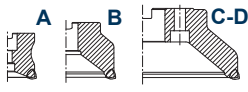
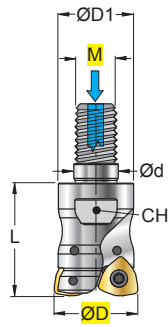



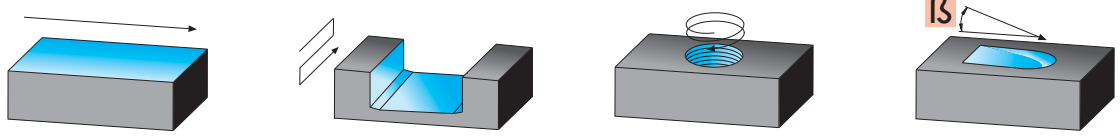


S 846..W .. 06 S 846..W .. 08	γ_p +5°/4° γ_f -2,8° γ_o -5,8°	S 848..W .. 06 S 848..W .. 08 S 848..WF .. 08	γ_p +5° γ_f -3,5° γ_o -6,2°	S 849..W .. 06 S 849..W .. 08	γ_p +4°/5° γ_f -2,8° γ_o -5,7°	WPMT .. .G42	
$\varnothing 25-40$		$\varnothing 40-100$		$\varnothing 25-40$		WPMT .. .G52	
		ISO 6462 ... 				WPMW .. .G52	
 INSERTI - INSERTS PAG. B 272							

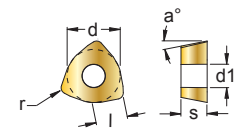
ART.		(mm)											ISO 6462					
		$\varnothing D$	M	$\varnothing d$	$\varnothing D1$	H	L	β	Z	CH	kg	Nm						
S 846LW	025 - 06	25	-	25	-	140	60	5°	2	-	0,43	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 846LW	026 - 06	26	-	25	-	140	60	4,5°	2	-	0,44	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 846LW	032 - 06	32	-	32	-	150	70	3,5°	3	-	0,79	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 846LW	033 - 06	33	-	32	-	150	70	3°	3	-	0,80	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 846XLW	025 - 06	25	-	25	-	200	120	5°	2	-	0,60	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 846XLW	026 - 06	26	-	25	-	200	120	4,5°	2	-	0,62	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 846XLW	032 - 06	32	-	32	-	250	170	3,5°	3	-	1,29	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 846XLW	033 - 06	33	-	32	-	250	170	3°	3	-	1,32	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 846LW	032 - 08	32	-	32	-	150	50	10°	2	-	0,77	4,0+5,0	-	08...	124512	5620	-	2445
S 846LW	033 - 08	33	-	32	-	150	50	8°	2	-	0,78	4,0+5,0	-	08...	124512	5620	-	2445
S 846LW	040 - 08	40	-	32	-	150	50	6°	3	-	0,84	4,0+5,0	-	08...	124512	5620	-	2445
S 846GLW	040 - 08	40	-	32	-	150	50	6°	2	-	0,85	4,0+5,0	-	08...	124512	5620	-	2445
S 846XLW	032 - 08	32	-	32	-	250	50	10°	2	-	1,38	4,0+5,0	-	08...	124512	5620	-	2445
S 846XLW	033 - 08	33	-	32	-	250	50	8°	2	-	1,40	4,0+5,0	-	08...	124512	5620	-	2445
S 846XLW	040 - 08	40	-	32	-	250	50	6°	3	-	1,45	4,0+5,0	-	08...	124512	5620	-	2445
S 846GXLW	040 - 08	40	-	32	-	250	50	6°	2	-	1,46	4,0+5,0	A	08...	124512	5620	-	2445
S 848W	040 - 06	40	-	16	38	40	-	2°	3	-	0,21	3,8+5,0	A	06...	C04008P	5615P	VBSF08L	2440
S 848W	050 - 08	50	-	22	48	50	-	4°	3	-	0,39	4,0+5,0	A	08...	124513P	5520P	VBSF10AV	2445
S 848W	052 - 08	52	-	22	50	50	-	4°	3	-	0,45	4,0+5,0	A	08...	124513P	5520P	VBSF10	2445
S 848W	063 - 08	63	-	22	59	50	-	2,5°	4	-	0,65	4,0+5,0	A	08...	124513P	5520P	VBSF12	2445
S 848W	066 - 08	66	-	27	63	50	-	2,5°	4	-	0,70	4,0+5,0	A	08...	124513P	5520P	VBSF12L	2445
S 848W	080 - 08	80	-	27	76	63	-	1,5°	5	-	1,47	4,0+5,0	A	08...	124513P	5520P	VBSF16L	2445
S 848W	100 - 08	100	-	32	96	63	-	1°	6	-	2,45	4,0+5,0	A	08...	124513P	5520P	VBSF16L	2445
S 848WF	050 - 08 New	50	-	22	48	50	-	4°	4	-	0,38	4,0+5,0	A	08...	124513P	5520P	VBSF10AV	2445
S 848WF	052 - 08 New	52	-	22	50	50	-	4°	4	-	0,43	4,0+5,0	A	08...	124513P	5520P	VBSF10	2445
S 848WF	063 - 08 New	63	-	22	59	50	-	2,5°	5	-	0,67	4,0+5,0	A	08...	124513P	5520P	VBSF12	2445
S 848WF	066 - 08 New	66	-	27	63	50	-	2,5°	5	-	0,73	4,0+5,0	A	08...	124513P	5520P	VBSF12	2445
S 848WF	080 - 08 New	80	-	27	76	63	-	1,5°	6	-	1,51	4,0+5,0	A	08...	124513P	5520P	VBSF12L	2445
S 848WF	100 - 08 New	100	-	32	96	63	-	1°	8	-	2,49	4,0+5,0	A	08...	124513P	5520P	VBSF16L	2445
S 849W	025 - 06	25	12	12,5	21	-	35	5°	2	17	0,09	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 849W	026 - 06	26	12	12,5	21	-	35	4,5°	2	17	0,09	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 849W	032 - 06	32	16	17	29	-	43	3,5°	3	24	0,20	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 849W	033 - 06	33	16	17	29	-	43	3°	3	24	0,20	3,8+5,0	-	06...	C04008P	5615P	-	2440
S 849W	032 - 08	32	16	17	29	-	43	10°	2	24	0,17	4,0+5,0	-	08...	124512	5620	-	2445
S 849W	033 - 08	33	16	17	29	-	43	8°	2	24	0,18	4,0+5,0	-	08...	124512	5620	-	2445
S 849W	040 - 08	40	16	17	29	-	43	6°	3	24	0,22	4,0+5,0	-	08...	124512	5620	-	2445
S 849GW	040 - 08	40	16	17	29	-	43	6°	2	24	0,24	4,0+5,0	-	08...	124512	5620	-	2445



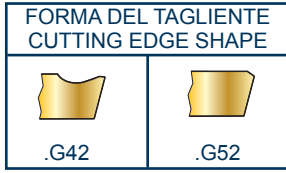
PAG. H 11



SCelta VELOCE - QUICK PICK



COD.	P			M			K			N			S			H			HT	HW	HC					l	d	s	d1	r	a°
	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R			F7030	F2040	T1030	T1330	smn						
WPMT 06X415 ZPR .G42	●			●																					6	9,525	4,20	4,3	1,5	11°	
WPMW 06X415 ZPR .G52	●			●			○									○									6	9,525	4,20	4,3	1,5	11°	
WPMT 080615 ZPR .G42	●			●																					8	12,7	6,35	5,4	1,5	11°	
WPMT 080615 ZSR .G52	●			●			○						○			○									8	12,7	6,35	5,4	1,5	11°	



CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

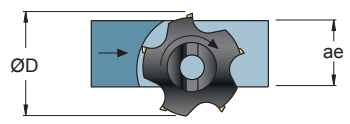
MATERIALI - MATERIALS Pag. H 73	VDI 3323 GR.	HB Rm1) HRC2)	fz0 mm		fz mm	Vc m/min Pag. B 254					
			WP..06	WP..08		F7030	F2040	T1030	T1330		
P ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	0,5-1,5	0,5-2	0,2	200		200	250		
	6-9	180-350	0,5-1,5	0,5-2	0,2	170		170	230		
	10-11	200-325	0,4-0,8	0,5-1	0,15	140		140	200		
	12-13	200-240	0,5-1,5	0,5-2	0,2	140	140	140	150		
M INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,5-1,3	0,5-1,8	0,2	130	130				
K GHISA GRIGIA - GREY CAST IRON	15-16	180-260	0,8-2	1-2,5	0,2	160					
	17-18	160-250	0,8-2	1-2,5	0,2	140					
	19-20	130-230	0,8-2	1-2,5	0,2	150					
N ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130									
	26-28	90-110									
	29-30	/									
S LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320									
	36-37	400-1050 ^{b)}									
H ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ^{a)}	0,3-0,6	0,4-0,8	0,1	80		80	80		

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

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

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

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



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

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. B 254

- 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

Inserto Insert	W (mm)	t (mm)	R (mm)
WPM..06	4,3	0,7	2,5
WPM..08	5,7	0,7	2,0

t = Materiale residuo ap = Profondità massima di passata
t = Residual Material ap = Maximum cutting depth

S 1502.8W .. 14

Ø 50-80

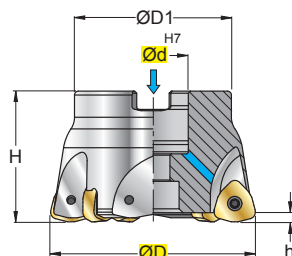
γ_p +15°
 γ_f -12°/-9°
 γ_o +12°



WNMT
1405..
.X52

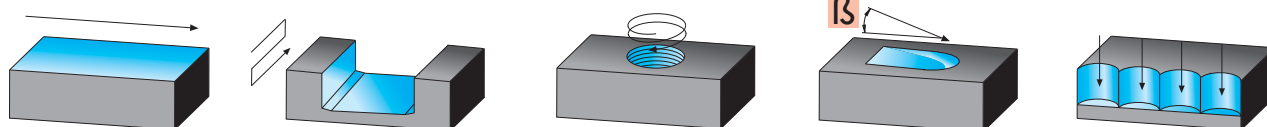


NEW



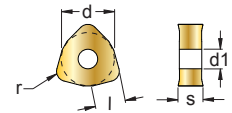
INSERTI - INSERTS
PAG. B 272

ART.	(mm)							kg	Nm	ISO 6462			
	ØD	Ød	ØD1	H	h	β	Z						
S 1502.8W-050-03-14	50	22	40	40	2	4,3°	3	0,24	3,8+5,0	A	1405		
S 1502.8W-050-04-14	50	22	40	40	2	4,3°	4	0,21	3,8+5,0	A			
S 1502.8W-052-03-14	52	22	40	40	2	4°	3	0,27	3,8+5,0	A			
S 1502.8W-052-04-14	52	22	40	40	2	4°	4	0,24	3,8+5,0	A			
S 1502.8W-063-04-14	63	22	49	40	2	2,7°	4	0,44	3,8+5,0	A			
S 1502.8W-063-05-14	63	22	49	40	2	2,7°	5	0,42	3,8+5,0	A			
S 1502.8W-066-04-14	66	22	49	40	2	2,5°	4	0,48	3,8+5,0	A			
S 1502.8W-066-05-14	66	22	49	40	2	2,5°	5	0,46	3,8+5,0	A			
S 1502.8W-080-05-14	80	27	60	50	2	1,9°	5	1,02	3,8+5,0	A	1405		
S 1502.8W-080-06-14	80	27	60	50	2	1,9°	6	0,99	3,8+5,0	A			



W = FORO PER LIQUIDO REFRIGERANTE - COOLANT BORE - KÜHLMITTELBOHRUNG - TROU DU LIQUIDE D'ARROSAGE

SCelta VELOCE - QUICK PICK



COD.	P			M			K			N			S			H			HT	HW	HC		l	d	s	d1	r	a°
	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R			F4130	T5120						
WNMT 140525 .X52	●	●	●	●	●	●	○	○	○														7	13,7	5,5	4,9	2,5	-

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY																													
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY																													

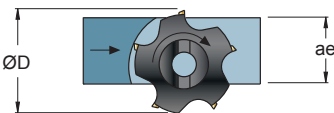
MATERIALI - MATERIALS Pag. H 73		VDI 3323 GR.	HB Rm ¹ HRC ²	fz0 mm	fz mm	Vc m/min		Pag. B 254													
							F4130	T5120													
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	0,5-2	0,1-0,2	240	250														
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350	0,5-2	0,1-0,2	220	250														
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,5-1,5	0,1-0,2	200	230														
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	0,5-1,5	0,1-0,2	180	180														
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,5-1,5	0,1-0,2	170															
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	0,8-2	0,1-0,2	190	250														
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	0,8-2	0,1-0,2	170	220														
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	0,8-2	0,1-0,2	130	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																		
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ¹⁾																		
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ²⁾	0,3-1,4	0,1-0,2	120															

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

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

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

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



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

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. B 254				

- 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

Inserto	W (mm)	t (mm)	R (mm)
WNMT 14	6,6	0,85	3,5

t = Materiale residuo
t = Residual Material
ap = Profondità massima di passata
ap = Maximum cutting depth