

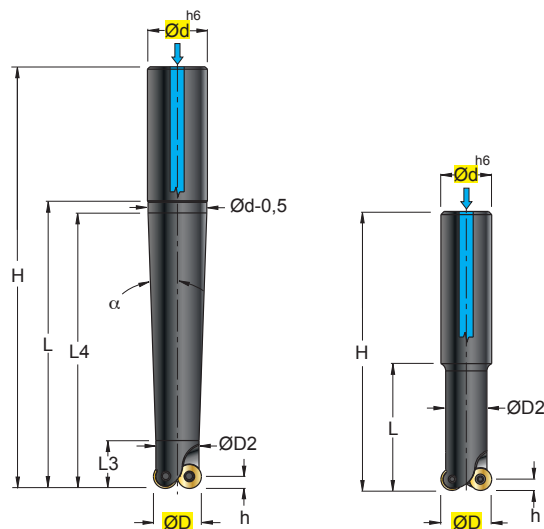
S 806W ..

Ø 12-20

FORM A

FORM B

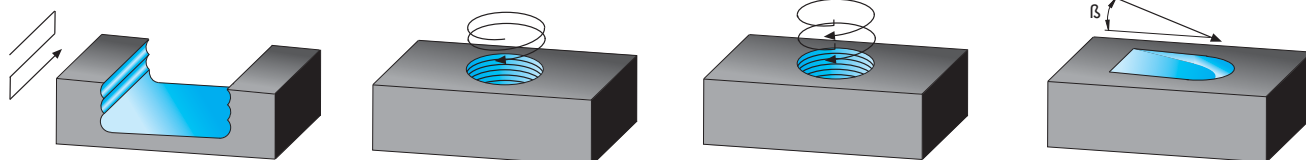
γ_p 0°
 γ_f 0°



RDHX.. .J34	
RDHX.. .J52	
RD..W.. .K52	

INSERTI - INSERTS
PAG. B 266

(mm)																			
ART.	FORM	ØD	Ød	ØD2	H	h	L	L3	L4	α	β	Z	kg	Nm					
S 806W 12 40 02.71	A	12	16	10	88	3,5	40	20	35	10,4°	22,7°	2	0,102	1,0+1,2	0701	122545	5607		
S 806W 12 60 02.71	A	12	16	10	108	3,5	60	20	55	4,3°	22,7°	2	0,120	1,0+1,2					
S 806W 12 80 02.71	A	12	16	10	128	3,5	80	20	75	2,9°	22,7°	2	0,139	1,0+1,2					
S 806W 15 40 02.72	B	15	16	13	88	3,5	40	-	-	-	20°	2	0,106	1,0+1,2	0702	122549	5607		
S 806W 15 60 02.72	A	15	16	13	108	3,5	60	20	55	2,0°	20°	2	0,135	1,0+1,2					
S 806W 15 80 02.72	A	15	20	13	130	3,5	80	20	75	3,4°	20°	2	0,232	1,0+1,2					
S 806W 15 100 02.72	A	15	20	13	150	3,5	100	20	95	2,5°	20°	2	0,263	1,0+1,2					
S 806W 15 120 02.72	A	15	25	13	176	3,5	120	20	115	3,5°	20°	2	0,447	1,0+1,2					
S 806W 16 40 02.72	B	16	16	13	88	3,5	40	-	-	-	16,8°	2	0,107	1,0+1,2					
S 806W 16 60 02.72	A	16	16	13	108	3,5	60	20	55	2,0°	16,8°	2	0,135	1,0+1,2	0702	122549	5607		
S 806W 16 80 02.72	A	16	20	13	130	3,5	80	20	75	3,4°	16,8°	2	0,232	1,0+1,2					
S 806W 16 100 02.72	A	16	20	13	150	3,5	100	20	95	2,5°	16,8°	2	0,263	1,0+1,2					
S 806W 16 120 02.72	A	16	25	13	176	3,5	120	20	115	3,5°	16,8°	2	0,449	1,0+1,2					
S 806W 20 40 02.10	A	20	20	18	90	5	40	20	35	2,9°	39°	2	0,181	3,0+3,5				1003	123507
S 806W 20 60 02.10	A	20	20	18	110	5	60	20	55	1,3°	39°	2	0,222	3,0+3,5					
S 806W 20 80 02.10	A	20	25	18	136	5	80	20	75	3,4°	39°	2	0,396	3,0+3,5					
S 806W 20 100 02.10	A	20	25	18	156	5	100	20	95	2,5°	39°	2	0,450	3,0+3,5					
S 806W 20 120 02.10	A	20	25	18	176	5	120	20	115	2,0°	39°	2	0,503	3,0+3,5					



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

SCelta VELOCE - QUICK PICK



Pag. B 238

COD.	P			M			K			N			S			H			HT	HW	HC				l	d	s	d1	r	a°	
	F	M	HSC	F	M	HSC	F	M	HSC	F	M	HSC	F	M	HSC	F	M	HSC			F7405	F1020	T535	F1320							
RDHX 0701 MOT .J34	●	●	○	○	○	○	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	1,99	2,8	-	15
RDHX 0702 MOT .J34	●	●	○	○	○	○	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	2,38	2,8	-	15
RDHX 1003 MOT .J34	●	●	○	○	○	○	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	10,0	3,18	4,4	-	15
RDHX 0701 MOT .J52	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	1,99	2,8	-	15
RDHX 0702 MOT .J52	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	2,38	2,8	-	15
RDHX 1003 MOT .J52	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	10,0	3,18	4,4	-	15
RDHW 0701 MOT .K52	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	1,99	2,8	-	15
RDHW 0702 MOT .K52	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	2,38	2,8	-	15
RDMW 1003 MOT .K52	○	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	10,0	3,18	4,4	-	15

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

MATERIALI - MATERIALS Pag. H 73		VDI 3323 GR.	HB Rm1 HRC2)	Km	F7405 Vc (m/min)			F1020 Vc (m/min)			F1320 Vc (m/min)			T535 Vc (m/min)		
					F	R	HSC	F	R	HSC	F	R	HSC	F	R	HSC
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	1	250	200	300	280	250	320	250	180	250	250	195	250
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350	0,9	270	270	290	270	240	290	240	180	230	220	170	220
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,8	220	220	240	220	190	240	190	150	210	180	140	180
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	1	180	150	180	150	120	180	180	130	180	140	110	140
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	1	100	100										
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	1	250	200	300									
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	1,1	180	200	250									
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	1,2	220	200	250									
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130	1,3												
	RAME E SUE LEGHE - COPPER	26-28	90-110	1,2												
	NON METALLICI - PLASTICS	29-30	/	1,3												
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320	0,9	30	30	40									
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ¹⁾	0,8	30	30	40									
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ²⁾	0,8	70	70	120									

d \ ap	0,3	0,5	0,7	0,8	1	1,2	2	3	4	5	6	8
07	F	0,17	0,13	0,11								
	R		0,22	0,21	0,19	0,17	0,13	0,11				
	HSC	0,57	0,44									
10	F	0,29	0,22	0,19	0,18	0,16						
	R			0,32	0,29	0,22	0,18	0,16	0,14			
	HSC	0,86	0,67	0,6	0,53							

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

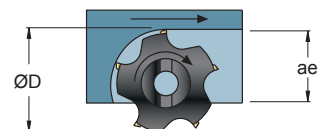
$$fz = fz0 \cdot Kae \cdot Km = \text{mm}$$

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

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

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

- F = FINITURA , LAV. LEGGERA - FINISHING , LIGHT MACHINING
- R = SGROSSATURA , LAV. PESANTE - ROUGHING , HEAVY MACHINING
- HSC = LAVORAZIONE ALTA VELOCITÀ - HIGH SPEED CUTTING
- Km = FATTORE DI AVANZAMENTO PER MATERIALE - FEED FACTOR FOR MATERIAL
- Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
- n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REV.
- 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



- DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES
- A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE
- APPLICAZIONE CONSIGLIATA - RECOMMENDED APPLICATION
- APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
- ○ EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
- ○ MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

S 808W ..

Ø 50-160

γ_p 0°
 γ_f 0°

ISO 6462 ...



RDHX..
.J34



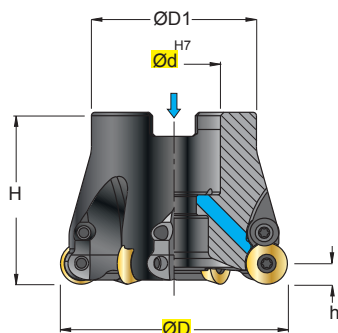
RDHX..
.J52



RDMW..
.K52

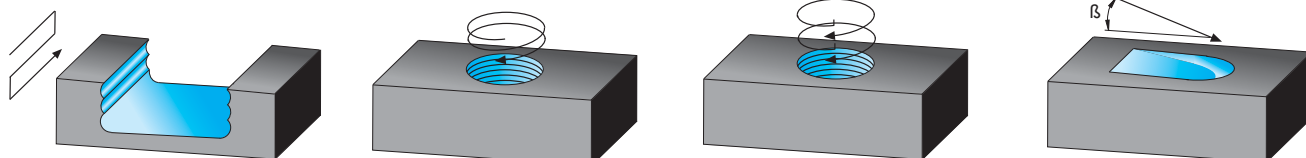


RDMX..
.J62



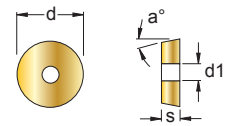
INSERTI - INSERTS
PAG. B 266

ART.	(mm)							kg	Nm	ISO 6462					
	ØD	Ød	ØD1	H	h	β	Z								
S 808W 50 50 05.12	50	22	40	50	6	6,1°	5	0,308	3,0+3,5	A	12T3	123509P	2435	5615P	VBSF10
S 808W 52 50 05.12	52	22	40	50	6	5,7°	5	0,337	3,0+3,5	A					
S 808W 63 50 06.12	63	27	48	50	6	4,3°	6	0,477	3,0+3,5	A					
S 808W 66 50 06.12	66	27	48	50	6	4,1°	6	0,524	3,0+3,5	A					
S 808W 80 52 07.12	80	27	60	52	6	3,2°	7	0,889	3,0+3,5	A					
S 808W 50 50 04.16	50	22	40	50	8	9,5°	4	0,273	4,0+5,0	A	1604	124510	2445	5620	VBSF10
S 808W 52 50 04.16	52	22	40	50	8	8,8°	4	0,299	4,0+5,0	A					
S 808W 63 50 05.16	63	27	48	50	8	7,1°	5	0,443	4,0+5,0	A					
S 808W 66 50 05.16	66	27	48	50	8	6,0°	5	0,493	4,0+5,0	A					
S 808W 80 52 06.16	80	27	60	52	8	4,5°	6	0,833	4,0+5,0	A					
S 808W 100 52 07.16	100	32	75	52	8	3,7°	7	1,276	4,0+5,0	A	1604	124510	2445	5620	VBSF16
S 808W 125 63 08.16	125	40	90	63	8	2,8°	8	2,664	4,0+5,0	A	1604	124510	2445	5620	VBSF20
S 808 160 63 09.16	160	40	120	63	8	1,8°	9	4,183	4,0+5,0	C	1604	124510	2445	5620	-



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	HSC	F	M	HSC	F	M	HSC	F	M	HSC	F	M	HSC	F	M	HSC			F7405	T535	F1320							
RDHX 12T3 MOT .J34	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	-	12,0	3,97	4,4	-	15
RDHX 1604 MOT .J34	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	-	16,0	4,76	5,5	-	15
RDHX 12T3 MOT .J52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	-	12,0	3,97	4,4	-	15
RDHX 1604 MOT .J52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	-	16,0	4,76	5,5	-	15
RDMX 12T3 MOT .J62	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	-	12,0	3,97	4,4	-	15
RDMX 1604 MOT .J62	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	-	16,0	4,76	5,5	-	15
RDMW 12T3 MOT .K52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	-	12,0	3,97	4,4	-	15
RDMW 1604 MOT .K52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	-	16,0	4,76	5,5	-	15

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	Km	F7405 Vc (m/min)			F1020 Vc (m/min)			F1320 Vc (m/min)			T535 Vc (m/min)		
					F	R	HSC	F	R	HSC	F	R	HSC	F	R	HSC
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	1	250	200	300	280	250	320	250	180	250	250	195	250
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350	0,9	270	270	290	270	240	290	240	180	230	220	170	220
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,8	220	220	240	220	190	240	190	150	210	180	140	180
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	1	180	150	180	150	120	180	180	130	180	140	110	140
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	1	100	100										
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	1	250	200	300									
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	1,1	180	200	250									
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	1,2	220	200	250									
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130	1,3												
	RAME E SUE LEGHE - COPPER	26-28	90-110	1,2												
	NON METALLICI - PLASTICS	29-30	/	1,3												
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320	0,9	30	30	40									
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ¹⁾	0,8	30	30	40									
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ²⁾	0,8	70	70	120									

d \ ap	0,3	0,5	0,7	0,8	1	1,2	2	3	4	5	6	8
12	F	0,38	0,29	0,25	0,23	0,21	0,19					
	R				0,42	0,38	0,29	0,24	0,21	0,19	0,17	
	HSC	1,25	1,0	0,82	0,77	0,69						
16	F	0,44	0,34	0,29	0,27	0,24	0,22	0,18				
	R				0,51	0,47	0,37	0,3	0,28	0,26	0,25	0,25
	HSC											

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

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

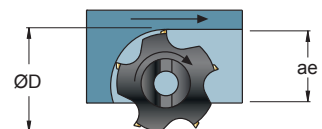
$$fn = fz \cdot z = \text{mm}$$

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

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

F = FINITURA , LAV. LEGGERA - FINISHING , LIGHT MACHINING
R = SGROSSATURA , LAV. PESANTE - ROUGHING , HEAVY MACHINING
HSC = LAVORAZIONE ALTA VELOCITÀ - HIGH SPEED CUTTING
Km = FATTORE DI AVANZAMENTO PER MATERIALE - FEED FACTOR FOR MATERIAL
Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REV.
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



■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES
●● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFÖHLENER EINSATZ - APPLICATION CONSEILLÉE

□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE
○○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

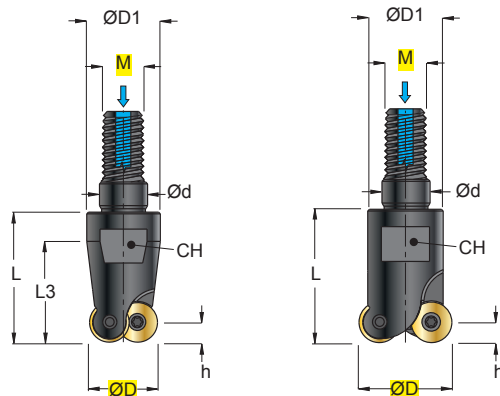
S 809W ..

FORM A

FORM B

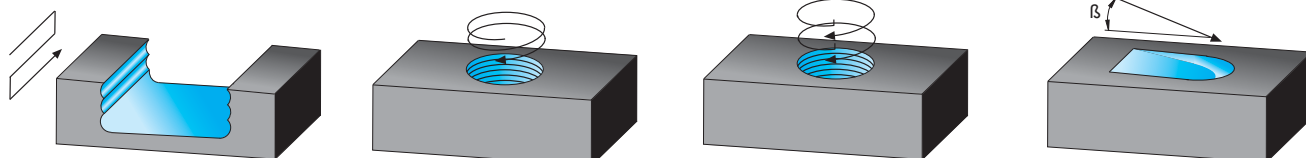
γ_p 0°
 γ_f 0°

Ø 10-42



RDHX.. .J34	
RDHX.. .J52	
RD..W.. .K52	
RDMX.. .J62	
INSERTI - INSERTS PAG. B 266	

ART.	FORM	ØD	M	Ød	ØD1	h	L	L3	β	Z	CH	kg	Nm				
S 809W 10 23 02.05	A	10	8	8,5	13	2,5	23	17	28,9°	2	10	0,019	0,4+0,5	0501	121837	-	5606
S 809W 12 23 03.05	A	12	8	8,5	13	2,5	23	17	13,8°	3	10	0,020	0,4+0,5				
S 809W 15 23 04.05	B	15	8	8,5	13	2,5	23	-	8,6°	4	10	0,023	0,4+0,5				
S 809W 16 23 04.05	B	16	8	8,5	13	2,5	23	-	7,7°	4	10	0,025	0,4+0,5				
S 809W 20 30 05.05	B	20	10	10,5	18	2,5	30	-	6,9°	5	15	0,059	0,4+0,5				
S 809W 25 35 06.05	B	25	12	12,5	21	2,5	35	-	4,0°	6	17	0,099	0,4+0,5				
S 809W 12 23 02.71	A	12	8	8,5	13	3,5	23	17	22,7°	2	10	0,019	1,0+1,2	0701	122545	-	5607
S 809W 15 23 02.72	B	15	8	8,5	13	3,5	23	-	20,0°	2	10	0,020	1,0+1,2	0702	122549	-	5607
S 809W 15 23 03.72	B	15	8	8,5	13	3,5	23	-	20,0°	3	10	0,021	1,0+1,2				
S 809W 16 23 02.72	B	16	8	8,5	13	3,5	23	-	16,8°	2	10	0,022	1,0+1,2				
S 809W 16 23 03.72	B	16	8	8,5	13	3,5	23	-	16,8°	3	10	0,022	1,0+1,2				
S 809W 20 30 04.72	B	20	10	10,5	18	3,5	30	-	11,0°	4	15	0,054	1,0+1,2				
S 809W 25 35 05.72	B	25	12	12,5	21	3,5	35	-	7,3°	5	17	0,093	1,0+1,2				
S 809W 30 43 05.72	A	30	16	17	29	3,5	43	43	5,4°	5	24	0,208	1,0+1,2				
S 809W 32 43 06.72	B	32	16	17	29	3,5	43	-	4,9°	6	24	0,219	1,0+1,2				
S 809W 35 43 06.72	B	35	16	17	29	3,5	43	-	4,3°	6	24	0,233	1,0+1,2				
S 809W 20 30 02.10	B	20	10	10,5	18	5	30	-	39,0°	2	15	0,048	3,0+3,5				
S 809W 25 35 03.10	B	25	12	12,5	21	5	35	-	14,3°	3	17	0,083	3,0+3,5				
S 809W 30 43 04.10	A	30	16	17	29	5	43	43	9,3°	4	24	0,196	3,0+3,5				
S 809W 32 43 04.10	A	32	16	17	29	5	43	43	8,6°	4	24	0,200	3,0+3,5				
S 809W 35 43 04.10	B	35	16	17	29	5	43	-	7,3°	4	24	0,215	3,0+3,5				
S 809W 35 43 05.10	B	35	16	17	29	5	43	-	7,3°	5	24	0,216	3,0+3,5				
S 809W 40 43 05.10	B	40	16	17	29	5	43	-	5,8°	5	24	0,232	3,0+3,5				
S 809W 42 43 05.10	B	42	16	17	29	5	43	-	5,4°	5	24	0,243	3,0+3,5				
S 809W 42 43 06.10	B	42	16	17	29	5	43	-	5,4°	6	24	0,245	3,0+3,5				
S 809W 25 35 02.12	B	25	12	12,5	21	6	35	-	26,0°	2	17	0,076	3,0+3,5	12T3	123509P	2435	5615
S 809W 32 43 03.12	A	32	16	17	29	6	43	43	14,3°	3	24	0,178	3,0+3,5				
S 809W 35 43 03.12	B	35	16	17	29	6	43	-	11,9°	3	24	0,194	3,0+3,5				
S 809W 40 43 04.12	B	40	16	17	29	6	43	-	9,3°	4	24	0,212	3,0+3,5				
S 809W 42 43 04.12	B	42	16	17	29	6	43	-	8,3°	4	24	0,224	3,0+3,5				
S 809W 32 43 02.16	A	32	16	17	29	8	43	43	29,6°	2	24	0,169	4,0+5,0	1604	124510	2445	5620
S 809W 40 43 02.16	B	40	16	17	29	8	43	-	15°	2	24	0,226	4,0+5,0				



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								
	F	M	HSC	F	M	HSC	F	M	HSC	F	M	HSC	F	M	HSC	F	M	HSC			F7405	F1020	T535	F1320	l	d	s	d1	r
RDHX 0501 MOS .J34	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	5,0	1,50	2,2	-	15
RDHX 0701 MOS .J34	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	1,99	2,8	-	15
RDHX 0702 MOS .J34	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	2,38	2,8	-	15
RDHX 1003 MOS .J34	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	10,0	3,18	4,4	-	15
RDHX 12T3 MOS .J34	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	12,0	3,97	4,4	-	15
RDHX 1604 MOS .J34	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	16,0	4,76	5,5	-	15
RDHX 0701 MOT .J52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	1,99	2,8	-	15
RDHX 0702 MOT .J52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	2,38	2,8	-	15
RDHX 1003 MOT .J52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	10,0	3,18	4,4	-	15
RDHX 12T3 MOT .J52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	12,0	3,97	4,4	-	15
RDHX 1604 MOT .J52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	16,0	4,76	5,5	-	15
RDHW 0501 MO .K52	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	5,0	1,50	2,2	-	15
RDHW 0701 MOT .K52	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	1,99	2,8	-	15
RDHW 0702 MOT .K52	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	7,0	2,38	2,8	-	15
RDMW 1003 MOT .K52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	10,0	3,18	4,4	-	15
RDMW 12T3 MOT .K52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	12,0	3,97	4,4	-	15
RDMW 1604 MOT .K52	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	16,0	4,76	5,5	-	15
RDMX 12T3 MOT .J62	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	12,0	3,97	4,4	-	15
RDMX 1604 MOT .J62	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	■	■	■	■	-	16,0	4,76	5,5	-	15

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	Km	F7405 Vc (m/min)			F1020 Vc (m/min)			F1320 Vc (m/min)			T535 Vc (m/min)		
					F	R	HSC	F	R	HSC	F	R	HSC	F	R	HSC
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	1	250	200	300	280	250	320	250	180	250	250	195	250
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350	0,9	270	270	290	270	240	290	240	180	230	220	170	220
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,8	220	220	240	220	190	240	190	150	210	180	140	180
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	1	180	150	180	150	120	180	180	130	180	140	110	140
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	1	100	100										
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	1	250	200	300									
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	1,1	180	200	250									
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	1,2	220	200	250									
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130	1,3												
	RAME E SUE LEGHE - COPPER	26-28	90-110	1,2												
	NON METALLICI - PLASTICS	29-30	/	1,3												
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320	0,9	30	30	40									
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ¹⁾	0,8	30	30	40									
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ²⁾	0,8	70	70	120									

d	ap	0,3	0,5	0,7	0,8	1	1,2	2	3	4	5	6	8
05	F	0,1	0,08										
	R		0,16	0,13	0,11	0,1	0,08	0,07					
	HSC	0,3											
07	F	0,17	0,13	0,11									
	R		0,22	0,21	0,19	0,17	0,13	0,11					
	HSC	0,57	0,44										
10	F	0,29	0,22	0,19	0,18	0,16							
	R				0,32	0,29	0,22	0,18	0,16	0,14			
	HSC	0,86	0,67	0,6	0,53								
12	F	0,38	0,29	0,25	0,23	0,21	0,19						
	R				0,42	0,38	0,29	0,24	0,21	0,19	0,17		
	HSC	1,25	1,0	0,82	0,77	0,69							
16	F	0,44	0,34	0,29	0,27	0,24	0,22	0,18					
	R				0,51	0,47	0,37	0,3	0,28	0,26	0,25	0,25	
	HSC												

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

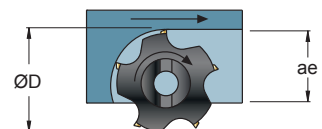
$$fz = fz0 \cdot Kae \cdot Km = \text{mm}$$

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

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

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

- F = FINITURA, LAV. LEGGERA - FINISHING, LIGHT MACHINING
- R = SGROSSATURA, LAV. PESANTE - ROUGHING, HEAVY MACHINING
- HSC = LAVORAZIONE ALTA VELOCITÀ - HIGH SPEED CUTTING
- Km = FATTORE DI AVANZAMENTO PER MATERIALE - FEED FACTOR FOR MATERIAL
- Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
- n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REV.
- 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



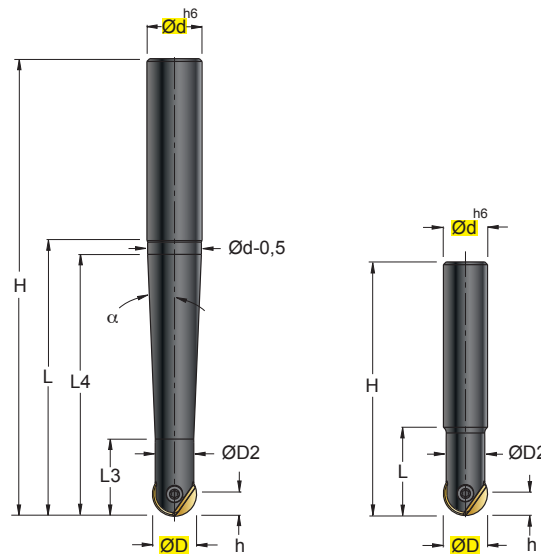
- DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES
- A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE
- APPLICAZIONE CONSIGLIATA - RECOMMENDED APPLICATION
- APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
- EMPFÖHLENER EINSATZ - APPLICATION CONSEILLÉE
- MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

S 926 ..

FORM A

FORM B

Ø 8-32



RA..
.K32



RAET..
.P42



INSERTI - INSERTS
 PAG. B 266

(mm)

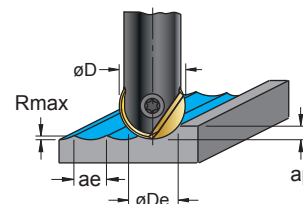
ART.	FORM	ØD	Ød	ØD2	H	h	L	L3	L4	α	N	Z	kg	Nm			
S 926 08 35 12	A	8	12	6,5	92	4	35	19	35	9,8°	1	2	0,062	0,8+1,0	08	12RA08	5407
S 926 08 53 12	A	8	12	6,5	110	4	53	19	48	5,0°	1	2	0,072	0,8+1,0			
S 926 08 75 12	A	8	12	6,5	132	4	75	19	70	2,8°	1	2	0,083	0,8+1,0			
S 926 10 35 12	A	10	12	8	92	5	35	22	35	8,9°	1	2	0,065	1,8+2,0	10	12RA10	5408
S 926 10 53 12	A	10	12	8	110	5	53	22	48	3,9°	1	2	0,076	1,8+2,0			
S 926 10 75 12	A	10	12	8	132	5	75	22	70	2,1°	1	2	0,088	1,8+2,0			
S 926 12 26 12	B	12	12	10	83	6	26	-	-	-	1	2	0,062	2,8+3,0	12	12RA12	5410
S 926 12 53 12	B	12	12	10	110	6	53	-	-	-	1	2	0,078	2,8+3,0			
S 926 12 85 16	A	12	16	10	145	6	85	22	80	2,8°	1	2	0,167	2,8+3,0			
S 926 16 32 16	B	16	16	14	92	8	32	-	-	-	1	2	0,123	4,5+5,5	16	12RA16	5415
S 926 16 63 16	B	16	16	14	123	8	63	-	-	-	1	2	0,159	4,5+5,5			
S 926 16 100 20	A	16	20	14	166	8	100	28	95	2,4°	1	2	0,312	4,5+5,5			
S 926 20 38 20	B	20	20	17	104	10	38	-	-	-	1	2	0,211	5,5+7,0	20	12RA20	5420
S 926 20 75 20	B	20	20	17	141	10	75	-	-	-	1	2	0,277	5,5+7,0			
S 926 20 115 25	A	20	25	17	191	10	115	34	110	2,8°	1	2	0,553	5,5+7,0			
S 926 25 45 25	B	25	25	21	121	12,5	45	-	-	-	1	2	0,379	10+13	25	12RA25	5430
S 926 25 90 25	B	25	25	21	166	12,5	90	-	-	-	1	2	0,501	10+13			
S 926 25 135 32	A	25	32	21	215	12,5	135	41	130	2,9°	1	2	0,962	10+13			
S 926 32 53 32	B	32	32	26	133	16	53	-	-	-	1	2	0,660	24+30	32	12RA32	5440
S 926 32 106 32	B	32	32	26	186	16	106	-	-	-	1	2	0,879	24+30			
S 926 32 160 32	A	32	32	26	240	16	160	49	155	1,5°	1	2	1,207	24+30			

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

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

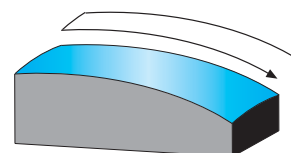
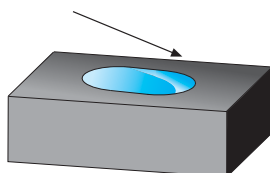
$$Vf = fz0 \cdot Km \cdot z \cdot n = \text{mm/min}$$

- F = FINITURA, LAV. LEGGERA - FINISHING, LIGHT MACHINING
- HSC = LAVORAZIONE ALTA VELOCITÀ - HIGH SPEED CUTTING
- 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
- Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
- Km = FATTORE DI AVANZAMENTO PER MATERIALE - FEED FACTOR FOR MATERIAL
- De = mm DIAMETRO EFFETTIVO - EFFECTIVE DIAMETER
- Rmax = mm RUGOSITÀ TEORICA MASSIMA - THEORETICAL MAXIMUM ROUGHNESS



$$\text{ØDe} = 2 \cdot \sqrt{D \cdot ap - ap^2} = \text{mm}$$

$$R_{\text{max}} = 0,5 \cdot (\text{ØD} - \sqrt{\text{ØD}^2 - ae^2}) = \text{mm}$$



N = NUMERO D'INSERTI / INSERT NUMBER / WENDEPLATTENANZAHL / NOMBRE DES PLAQUETTES
 Z = NUMERO TAGLIANTI / NUMBER OF CUTTING EDGES / SCHNEIDENANZAHL / NOMBRE DU COUPANTS



SCelta VELOCE - QUICK PICK

Tenacità + ↑
Toughness - ↓

Pag. B 238

COD.	P		M		K		N		S		H		HT	HW	HC			RA			RAET				
	F	HSC	F	HSC	F	HSC	F	HSC	F	HSC	F	HSC			CERMET	NON RIV. CEMENTED CARBIDE GRADES	RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS			d	s	d1	H	r	a°
																	T500								
RA 08.04 .K32	●	●	○	○	●	●					●	●							8,0	2,4	2,5	7	4	-	
RA 10.04 .K32	●	●	○	○	●	●					●	●							10,0	2,6	3,0	8,5	5	-	
RA 12.04 .K32	●	●	○	○	●	●					●	●							12,0	3,0	3,5	10	6	-	
RA 16.04 .K32	●	●	○	○	●	●					●	●							16,0	4,0	4,0	12	8	-	
RA 20.04 .K32	●	●	○	○	●	●					●	●							20,0	5,0	5,0	15	10	-	
RA 25.04 .K32	●	●	○	○	●	●					●	●							25,0	6,0	6,0	18,5	12,5	-	
RA 32.04 .K32	●	●	○	○	●	●					●	●							32,0	7,0	8,0	23,5	16	-	
RAET 100008 .P42	●	●	○	○	●	●	○	○	○	○	●	●							10,0	2,6	3,0	8,5	0,8	-	
RAET 120010 .P42	●	●	○	○	●	●	○	○	○	○	●	●							12,0	3,0	3,5	10	1,0	-	
RAET 120020 .P42	●	●	○	○	●	●	○	○	○	○	●	●							12,0	3,0	3,5	10	2,0	-	
RAET 160013 .P42	●	●	○	○	●	●	○	○	○	○	●	●							16,0	4,0	4,0	12	1,3	-	
RAET 160030 .P42	●	●	○	○	●	●	○	○	○	○	●	●							16,0	4,0	4,0	12	3,0	-	
RAET 200016 .P42	●	●	○	○	●	●	○	○	○	○	●	●							20,0	5,0	5,0	15	1,6	-	
RAET 200040 .P42	●	●	○	○	●	●	○	○	○	○	●	●							20,0	5,0	5,0	15	4,0	-	
RAET 250020 .P42	●	●	○	○	●	●	○	○	○	○	●	●							25,0	6,0	6,0	18,5	2,0	-	
RAET 250050 .P42	●	●	○	○	●	●	○	○	○	○	●	●							25,0	6,0	6,0	18,5	5,0	-	

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

TOLLERANZE TOLERANCE RANGE	D
RA..	± 0,01
RAET..	± 0,025



CON GLI INSERTI RAET.. PER OTTENERE UN BLOCCAGGIO OTTIMALE LA MARCATURA DELL' INSERTO DEVE ESSERE ORIENTATA VERSO LA TESTA DELLA VITE

FOR BEST CLAMPING WITH RAET INSERTS, DIRECT THE MARK TOWARDS THE SCREW HEAD

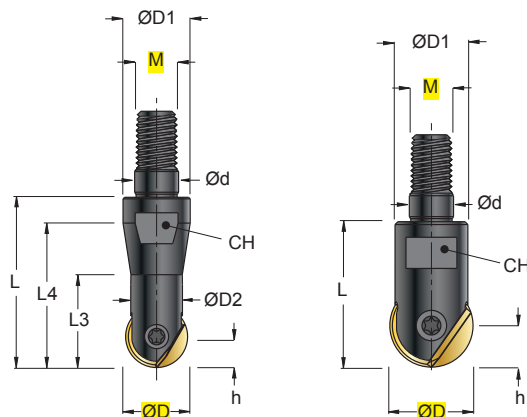
MATERIALI - MATERIALS Pag. H 73		VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	Km	ap		ae		T500 Vc (m/min)		D fz0 mm			
					F	HSC	F	HSC	F	HSC	D	F	R	HSC
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	1	D/15	0,1-0,3	D/15	D/50	300	400		8	0,15	0,2
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350	1	D/15	0,1-0,3	D/15	D/50	250	350		10	0,2	0,2
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	0,8	D/20	0,1-0,3	D/20	D/50	230	350		12	0,2	0,25
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	0,8	D/20	0,1-0,2	D/20	D/50	210	280		16	0,25	0,3
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,8	D/20	0,1-0,2	D/20	D/50	190	250		20	0,25	0,3
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	1,2	D/10	0,1-0,3	D/10	D/40	250	340		25	0,3	0,35
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	1,2	D/10	0,1-0,3	D/10	D/40	230	310		32	0,3	0,35
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	1,2	D/10	0,1-0,3	D/10	D/40	270	380				
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130	1,4	D/6	0,1-0,5	D/6	D/40	450	650				
	RAME E SUE LEGHE - COPPER	26-28	90-110	1,4	D/10	0,1-0,5	D/10	D/40	180	350				
	NON METALLICI - PLASTICS	29-30	/	1,4	D/6	0,1-0,5	D/6	D/40	400					
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320	0,8	D/30	0,1-0,2	D/30	D/50	50	90				
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ³⁾	0,8	D/20	0,1-0,2	D/20	D/50	60	100				
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ³⁾	0,8	D/30	0,1-0,2	D/30	D/50	90	150				
G	GRAFITE - GRAPHITE	45	/	1,6	D/5	0,1-0,5	D/5	D/40						
R	RESINA PER MODELLI, LEGNO - RESIN, WOOD	43	/	1,5	D/3	0,1-0,5	D/3	D/40						

S 929 ..

FORM A

FORM B

Ø 10-32



RA..
.K32



RAET..
.P42



INSERTI - INSERTS
 PAG. B 266

(mm)

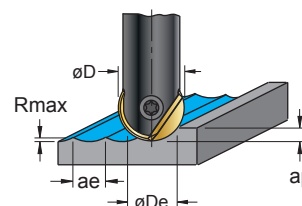
ART.	FORM	ØD	M	Ød	ØD1	ØD2	h	L	L3	L4	N	Z	CH	kg	Nm			
S 929 10 33 08	A	10	8	8,5	13	8	5	33	18	28	1	2	10	0,022	1,8÷2,0		12RA10	5408
S 929 12 33 08	A	12	8	8,5	13	10	6	33	18	28	1	2	10	0,026	2,8÷3,0		12RA12	5410
S 929 16 28 08	B	16	8	8,5	14	14	8	28	-	-	1	2	10	0,029	4,5÷5,5		12RA16	5415
S 929 20 28 10	B	20	10	10,5	17	17	10	28	-	-	1	2	15	0,042	5,5÷7,0		12RA20	5420
S 929 25 41 12	B	25	12	12,5	21	21	12,5	41	-	-	1	2	17	0,093	10÷13		12RA25	5430
S 929 32 49 16	B	32	16	17	26	26	16	49	-	-	1	2	24	0,174	24÷30		12RA32	5440

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

$$f_z = f_{z0} \cdot K_m = \text{mm}$$

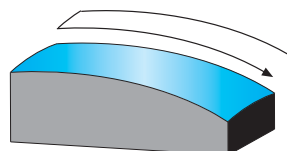
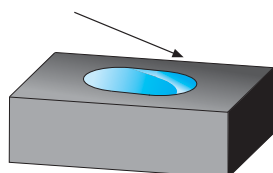
$$V_f = f_{z0} \cdot K_m \cdot z \cdot n = \text{mm/min}$$

- F = FINITURA, LAV. LEGGERA - FINISHING, LIGHT MACHINING
- HSC = LAVORAZIONE ALTA VELOCITÀ - HIGH SPEED CUTTING
- 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
- Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
- Km = FATTORE DI AVANZAMENTO PER MATERIALE - FEED FACTOR FOR MATERIAL
- De = mm DIAMETRO EFFETTIVO - EFFECTIVE DIAMETER
- Rmax = mm RUGOSITÀ TEORICA MASSIMA - THEORETICAL MAXIMUM ROUGHNESS



$$\text{ØDe} = 2 \cdot \sqrt{D \cdot ap - ap^2} = \text{mm}$$

$$R_{\text{max}} = 0,5 \cdot (\text{ØD} - \sqrt{\text{ØD}^2 - ae^2}) = \text{mm}$$



N = NUMERO D'INSERTI / INSERT NUMBER / WENDEPLATTENANZAHL / NOMBRE DES PLAQUETTES
 Z = NUMERO TAGLIENTI / NUMBER OF CUTTING EDGES / SCHNEIDENANZAHL / NOMBRE DU COUPANTS



SCelta VELOCE - QUICK PICK



COD.	P		M		K		N		S		H		HT CERNET	HW NON RIV. CEMENTED CARBIDE GRADES	HC RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS	RA			RAET				
	F	HSC	F	HSC	F	HSC	F	HSC	F	HSC	F	HSC				d	s	d1	H	r	a°		
	RA 10.04 .K32	●	●	○	○	●	●					●				●						10,0	2,6
RA 12.04 .K32	●	●	○	○	●	●					●	●						12,0	3,0	3,5	10	6	-
RA 16.04 .K32	●	●	○	○	●	●					●	●						16,0	4,0	4,0	12	8	-
RA 20.04 .K32	●	●	○	○	●	●					●	●						20,0	5,0	5,0	15	10	-
RA 25.04 .K32	●	●	○	○	●	●					●	●						25,0	6,0	6,0	18,5	12,5	-
RA 32.04 .K32	●	●	○	○	●	●					●	●						32,0	7,0	8,0	23,5	16	-
RAET 100008 .P42	●	●	○	○	●	●	○	○	○	○	●	●						10,0	2,6	3,0	8,5	0,8	-
RAET 120010 .P42	●	●	○	○	●	●	○	○	○	○	●	●						12,0	3,0	3,5	10	1,0	-
RAET 120020 .P42	●	●	○	○	●	●	○	○	○	○	●	●						12,0	3,0	3,5	10	2,0	-
RAET 160013 .P42	●	●	○	○	●	●	○	○	○	○	●	●						16,0	4,0	4,0	12	1,3	-
RAET 160030 .P42	●	●	○	○	●	●	○	○	○	○	●	●						16,0	4,0	4,0	12	3,0	-
RAET 200016 .P42	●	●	○	○	●	●	○	○	○	○	●	●						20,0	5,0	5,0	15	1,6	-
RAET 200040 .P42	●	●	○	○	●	●	○	○	○	○	●	●						20,0	5,0	5,0	15	4,0	-
RAET 250020 .P42	●	●	○	○	●	●	○	○	○	○	●	●						25,0	6,0	6,0	18,5	2,0	-
RAET 250050 .P42	●	●	○	○	●	●	○	○	○	○	●	●						25,0	6,0	6,0	18,5	5,0	-

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

TOLLERANZE TOLERANCE RANGE	D
RA..	± 0,01
RAET..	± 0,025



CON GLI INSERTI RAET.. PER OTTENERE UN BLOCCAGGIO OTTIMALE LA MARCATURA DELL' INSERTO DEVE ESSERE ORIENTATA VERSO LA TESTA DELLA VITE

FOR BEST CLAMPING WITH RAET INSERTS, DIRECT THE MARK TOWARDS THE SCREW HEAD

MATERIALI - MATERIALS Pag. H 73	VDI 3323 GR.	HB Rm ⁽¹⁾ HRC ⁽²⁾	Km	ap		ae		T500 Vc (m/min)				
				F	HSC	F	HSC	F	HSC			
P ACCIAIO NON LEGATO - NOT ALLOY STEEL ACCIAIO POCO LEGATO - LOW ALLOY STEEL ACCIAIO ALTO LEGATO - ALLOY STEEL INOX MARTENS. - STAINLESS STEEL MART	1-5	125-300	1	D/15	0,1-0,3	D/15	D/50	300	400			
	6-9	180-350	1	D/15	0,1-0,3	D/15	D/50	250	350			
	10-11	200-325	0,8	D/20	0,1-0,3	D/20	D/50	230	350			
	12-13	200-240	0,8	D/20	0,1-0,2	D/20	D/50	210	280			
M INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,8	D/20	0,1-0,2	D/20	D/50	190	250			
K GHISA GRIGIA - GREY CAST IRON GHISA SFEROIDALE - SPHEROIDAL GRAPHITE GHISA MALLEABILE - MALLEABLE CAST IRON	15-16	180-260	1,2	D/10	0,1-0,3	D/10	D/40	250	340			
	17-18	160-250	1,2	D/10	0,1-0,3	D/10	D/40	230	310			
	19-20	130-230	1,2	D/10	0,1-0,3	D/10	D/40	270	380			
N ALLUMINIO E SUE LEGHE - ALUMINIUM RAME E SUE LEGHE - COPPER NON METALLICI - PLASTICS	21-25	60-130	1,4	D/6	0,1-0,5	D/6	D/40	450	650			
	26-28	90-110	1,4	D/10	0,1-0,5	D/10	D/40	180	350			
	29-30	/	1,4	D/6	0,1-0,5	D/6	D/40	400				
S LEGHE RESIST. CALORE - HIG. TEMP. ALLOY TITANIO E SUE LEGHE - TITANIUM	31-35	200-320	0,8	D/30	0,1-0,2	D/30	D/50	50	90			
	36-37	400-1050 ⁽³⁾	0,8	D/20	0,1-0,2	D/20	D/50	60	100			
H ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ⁽³⁾	0,8	D/30	0,1-0,2	D/30	D/50	90	150			
G GRAFITE - GRAPHITE	45	/	1,6	D/5	0,1-0,5	D/5	D/40					
R RESINA PER MODELLI, LEGNO - RESIN, WOOD	43	/	1,5	D/3	0,1-0,5	D/3	D/40					

D	fz0 mm		
	F	R	HSC
8	0,15		0,2
10	0,2		0,2
12	0,2		0,25
16	0,25		0,3
20	0,25		0,3
25	0,3		0,35
32	0,3		0,35