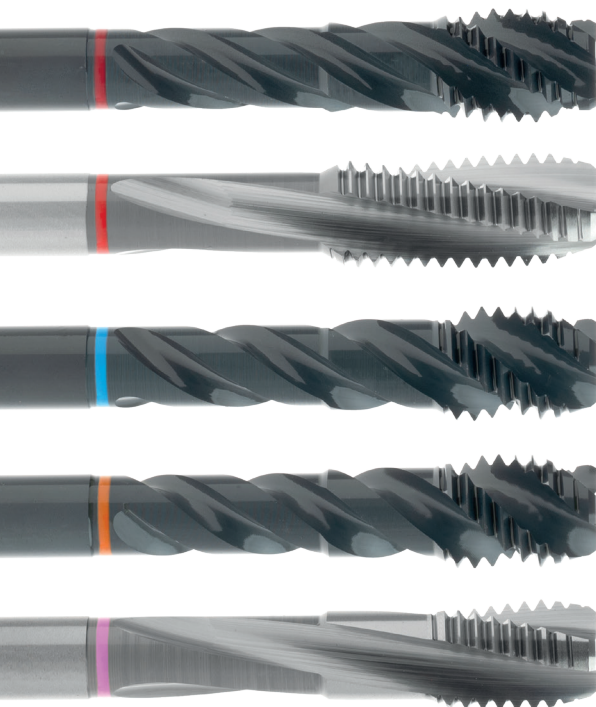


ISO P M S



MATERIAL SPECIFIC ACTION

La migliore soluzione in base al materiale lavorato.



UTENSILI

				PH-SP		PM-SP		SP-VA		ZEN-B		ZET-B	
				HSS-E	OX	HSS-P		HSS-E	OX	HSS-P	OX	HSS-P	NI
													
TCTR (tolleranza)				ISO2(6H)		ISO2X(6HX)		ISO2(6H)		ISO2X(6HX)		ISO2X(6HX)	
THCHT (imbocco)				2.5P		2.75P		2.5P		3P		3P	
Dimensioni (TD)	Passo (TP)	Punta Ø (mm)	Foro Ø (mm)	edp	€	edp	€	edp	€	edp	€	edp	€
M3	0.5	2.50	2.56	SD3.0GAEEEX	14,55	SD3.0GBDPB	15,48	SD3.0GAGEX	11,36	SD3.0GBJPX	22,34	SD3.0GBIPN	23,43
M4	0.7	3.30	3.38	SD4.0IAEEEX	14,55	SD4.0IBDPB	15,48	SD4.0IAGEX	11,36	SD4.0IBJPX	22,34	SD4.0IBIPN	22,34
M5	0.8	4.20	4.28	SD5.0KAEEEX	14,98	SD5.0KBDPB	15,73	SD5.0KAGEX	11,71	SD5.0KBJPX	23,10	SD5.0KBIPN	23,10
M6	1	5.00	5.09	SD6.0MAEEEX	14,98	SD6.0MBDPB	15,85	SD6.0MAGEX	11,82	SD6.0MBJPX	23,10	SD6.0MBIPN	23,10
M8	1.25	6.80	6.85	SD8.0NAEEEX	18,23	SD8.0NBDPB	18,87	SD8.0NAGEX	14,29	SD8.0NBJPX	28,86	SD8.0NBIPN	28,86
M10	1.5	8.50	8.60	SD10.0AEEEX	21,89	SD10.0BDPB	22,52	SD10.0AGEX	17,10	SD10.0BJPX	34,70	SD10.0BIPN	34,70
M12	1.75	10.30	10.36	SG012PAEEEX	28,51	SG012PBDPB	26,54	SG012PAGEX	22,01	SG012PBJPX	45,04	SG012PBIPN	45,04
M14	2	12	12.12	SG014QAEEEX	34,23	SG014QBDPB	31,90	SG014QAGEX	26,44	SG014QBJPX	56,87	SG014QBIPN	54,30
M16	2	14	14.12	SG016QAEEEX	43,26	SG016QBDPB	40,27	SG016QAGEX	33,42	SG016QBJPX	68,72	SG016QBIPN	68,72
M18	2.5	15.5	15.63	SG018RAEEEX	58,66	SG018RBDPB	50,42	SG018RAGEX	41,80				
M20	2.5	17.5	17.63	SG020RAEEEX	66,33	SG020RBDPB	59,43	SG020RAGEX	49,31				
M22	2.5	19.5	19.63	SG022RAEEEX	84,49	SG022RBDPB	72,29	SG022RAGEX	59,97				
M24	3	21	21.13	SG024SAEEEX	90,87	SG024SBDPB	81,90	SG024SAGEX	67,95				
				Vc (m/min)		Vc (m/min)		Vc (m/min)		Vc (m/min)		Vc (m/min)	
ISO P <900 N/mm ²								★	<10				
ISO P 900 ÷ 1150 N/mm ²				★	<8	★	<8						
ISO P 900 ÷ 1400 N/mm ²						★	<6						
ISO M 1.4301-AISI 304, 1.4305-AISI 303								★	<10	★	5 ÷ 15		
ISO M 1.4401-AISI 316, Duplex										★	5 ÷ 10		
ISO S Ni <35 HRC										★	3 ÷ 10		
ISO S Ni >35 HRC												★	3 ÷ 6
ISO S Ti												★	3 ÷ 8

★ 1° scelta ☆ adatto

Per materiali di difficile lavorabilità quali acciai inossidabili, leghe a base di Nichel o leghe a base di Titanio, raccomandiamo di preparare il preforo al limite massimo consentito.

PM-PO	PO-VA	ZEN-P	ZET-P
HSS-P	HSS-E OX	HSS-P NX	HSS-P NI
			
ISO2X(6HX)	ISO2X(6HX)	ISO2X(6HX)	ISO2X(6HX)
5,5P	4,5P	4,5P	5P

TCTR (tolleranza)

THCHT (imbocco)

Dimensioni (TD)	Passo (TP)	Punta Ø (mm)	Foro Ø (mm)	edp	€	edp	€	edp	€	edp	€
M3	0.5	2.50	2.56	PD3.0GBDPB	13,50	PD3.0GBGEX	11,06	PD3.0GBJPW	22,46	LD3.0GBIPN	23,43
M4	0.7	3.30	3.38	PD4.0IBDPB	13,50	PD4.0IBGEX	11,06	PD4.0IBJPW	22,46	LD4.0IBIPN	23,43
M5	0.8	4.20	4.28	PD5.0KBDPB	14,05	PD5.0KBGEX	11,51	PD5.0KBJPW	23,10	LD5.0KBIPN	24,19
M6	1	5.00	5.09	PD6.0MBDPB	14,05	PD6.0MBGEX	11,62	PD6.0MBJPW	23,10	LD6.0MBIPN	23,10
M8	1.25	6.80	6.85	PD8.0NBDPB	16,62	PD8.0NBGEX	13,92	PD8.0NBJPW	28,86	LD8.0NBIPN	28,86
M10	1.5	8.50	8.60	PD10.0BDPB	22,70	PD10.0BGEX	16,66	PD10.0BJPW	34,23	LD10.0BIPN	36,42
M12	1.75	10.30	10.36	PG012PBDPB	25,92	PG012PBGEX	21,50	PG012PBJPW	45,04	LG012PBIPN	45,47
M14	2	12	12.12	PG014QBDPB	31,20	PG014QBGEX	25,88	PG014QBJPW	56,87		
M16	2	14	14.12	PG016QBDPB	39,30	PG016QBGEX	32,59	PG016QBJPW	71,96	LG016QBIPN	72,63
M18	2.5	15.5	15.63	PG018RBDPB	49,15	PG018RBGEX	40,77				
M20	2.5	17.5	17.63	PG020RBDPB	58,02	PG020RBGEX	48,15				
M22	2.5	19.5	19.63	PG022RBDPB	70,52	PG022RBGEX	58,50				
M24	3	21	21.13	PG024SBDPB	79,86	PG024SBGEX	66,28				

	Vc (m/min)		Vc (m/min)		Vc (m/min)		Vc (m/min)	
ISO P <900 N/mm ²			★	<10				
ISO P 900 ÷ 1150 N/mm ²	★	<10						
ISO P 900 ÷ 1400 N/mm ²	★	<6						
ISO M 1.4301-AISI 304, 1.4305-AISI 303			★	<10	★	5 ÷ 15		
ISO M 1.4401-AISI 316, Duplex					★	5 ÷ 10		
ISO S Ni <35 HRC					★	3 ÷ 10		
ISO S Ni >35 HRC					★	3 ÷ 6	★	3 ÷ 6
ISO S Ti							★	3 ÷ 8

★ 1° scelta ☆ adatto

Per materiali di difficile lavorabilità quali acciai inossidabili, leghe a base di Nichel o leghe a base di Titanio, raccomandiamo di preparare il preforo al limite massimo consentito.